

TB 9-2350-264-23-1

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TECHNICAL BULLETIN

**M2 MACHINE GUN PREPARATION FOR SAFETY AND
REPLACEMENT OF HANDLE FRAMES AND GRIPS**

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HEADQUARTERS, DEPARTMENT OF THE ARMY

4 MARCH 1996

1. Scope. This Technical Bulletin (TB) provides a maintenance procedure and parts list for this procedure. The procedure will be used to modify the M2 Flexible Machine Gun for M1A2 Tank applications.

2. Procedure:

M2 MACHINE GUN PREPARATION FOR SAFETY AND REPLACEMENT OF HANDLE FRAMES AND GRIPS

TOOLS: Artillery and Turret Mechanic's Tool Kit: Ordnance (SC 5180-95-CL-A12)
 Portable Electric Drill (Item 21, Appendix E, TM 9-2350-264-20-2-4)
 Twist Drill Set (Item 22, Appendix E, TM 9-2350-264-20-2-4)

WARNING

Be sure weapon is clear before starting this task. Weapon can fire if loaded, causing serious injury or death to personnel.

NOTE

Use removal to prepare a newly received M2 machine gun for installation in commander's weapon station mount. Use installation to prepare M2 machine gun for turn-in.

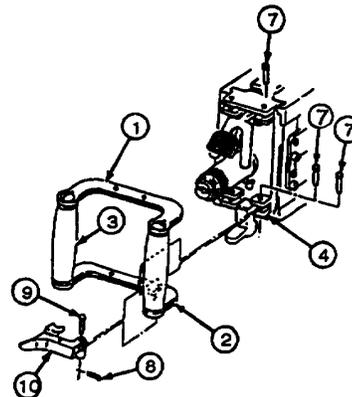
REMOVAL:

1. Remove frames (1, 2) and two grips (3) from backplate assembly (4).

NOTE

If frames (1, 2) are attached to backplate (4) with rivets (7), do step a.

a. Using drill remove four rivets (7), frames (1, 2) and grips (3) from backplate (4). Save parts for installation.

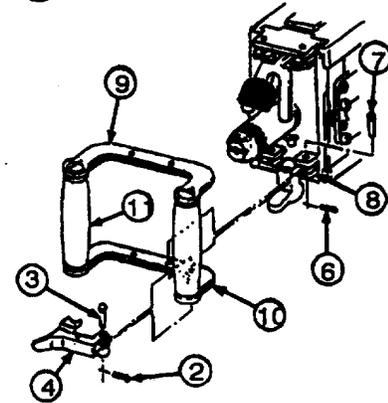
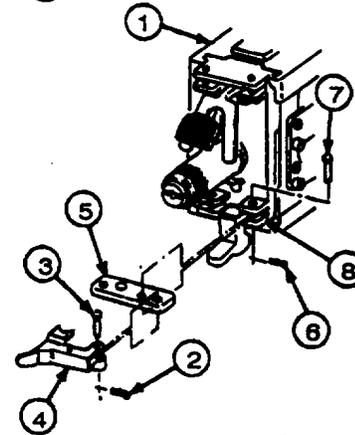
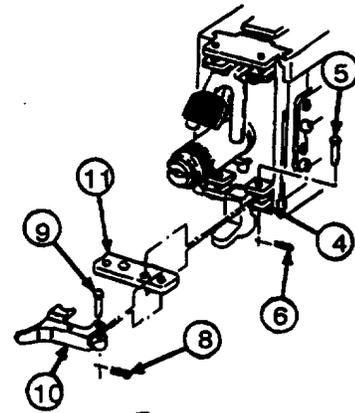


- b. Remove four lock pins (6) from pins (5). Pull out pins (5) and remove frames and grips from backplate (4). Save parts for installation. Go to step C.
 - c. Remove lock pin (8) from latch pin (9). Remove latch pin (9) and latch lock (10) from filler piece (11).
 - d. Aline filler piece (11) on lower end of backplate (4). Install two pins (5). Install two lock pins (6) on pins (5).
 - e. Aline latch lock (10) on filler piece (11). Install latch pin (9) in latch lock (10) and filler piece (11). Install lock pin (8) on latch pin (9).
2. Inspect parts for damage. Replace as required.

INSTALLATION:

Prepare machine gun (1) for storage.

- a. Remove lock pin (2) from latch pin (3). Remove latch pin (3) and latch lock (4) from filler piece (5).
- b. Remove two lock pins (6) from pins (7). Remove pins (7) and filler piece (5) from backplate (8). Save filler piece (5) for storage with machine gun (1).
- c. Aline frames (9, 10) and two grips (11) on backplate (8). Install four pins (7) in frames (9, 10) and backplate (8). Install four lock pins (6) on pins (7).
- d. Aline latch lock (4) on lower frame (10). Install latch pin (3) in latch lock (4). Install lock pin (2) on latch pin (3).

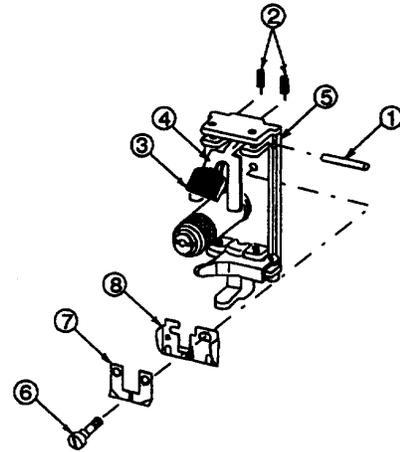


3. M2 Machine Gun Safety

REMOVAL:

Remove backplate assembly from Machine Gun and disengage bolt latch lock on back plate.

- Remove pin (1) and two springs (2) from trigger (3) and bolt latch release (4). Do not remove trigger (3) and bolt latch release (4) from backplate (5).
- Cut safety wire from two screws (6) and safety spring (8). Remove two screws (6) from safety (7) and safety spring (8).
- Inspect parts for damage. Replace damaged or worn parts.



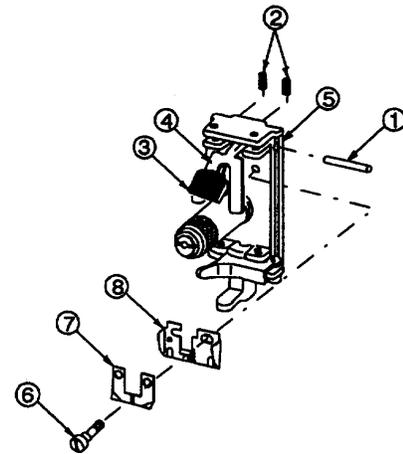
INSTALLATION:

Apply light coat of lube on all safety components.

- Align safety spring (8) and safety (7) on backplate (5). Install safety spring (8) and safety (7). Thread two screws (6) by hand into threaded holes in backplate (5). **DO NOT TIGHTEN SCREWS.**
- Using screwdriver, snug screws (6) against safety (8) and spring (7). Attempt to operate the safety by sliding it from side to side. If safety slides freely continue to step c.

If safety does not operate freely, back off tension on screws as necessary to just allow safety to function freely.

- Install lockwire through holes in each screw (6) and through respective hole in bottom corner of spring (7). Twist lockwire to secure.



Attempt to operate safety again. Check to ensure that safety clicks into each position "S" and "F". Verify that when the "S" is visible, the trigger is locked. Verify that when "F" is visible, the trigger may be depressed.

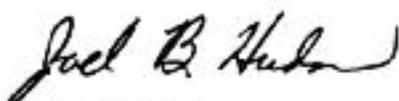
d. Reinstall the backplate with safety onto the weapon.

3. **BACKPLATE KIT COMPONENTS.** The following items are for the M2 Machine Gun Back Plate Kit for M2 Machine Guns that are mounted on M1A2 Tanks:

QUANTITY	NAME OF ITEM	DWG NO	PART NO	STOCK NO
2	Pin, Lock	7312517	7312517	5315-00-731-2517
2	Pin, Straight, Headed	5152854	5152854	5315-00-515-2854
1	Piece, Filler	5152750	5152750	1005-00-51 5-2750
2	Screw	MB3955	MB3955	5305-0141 5-3269
1	Spring	1969	1969	5360-01-415-3267
1	Safety	1968	1968	1010-01-414-9706

By Order of the Secretary of the Army:

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