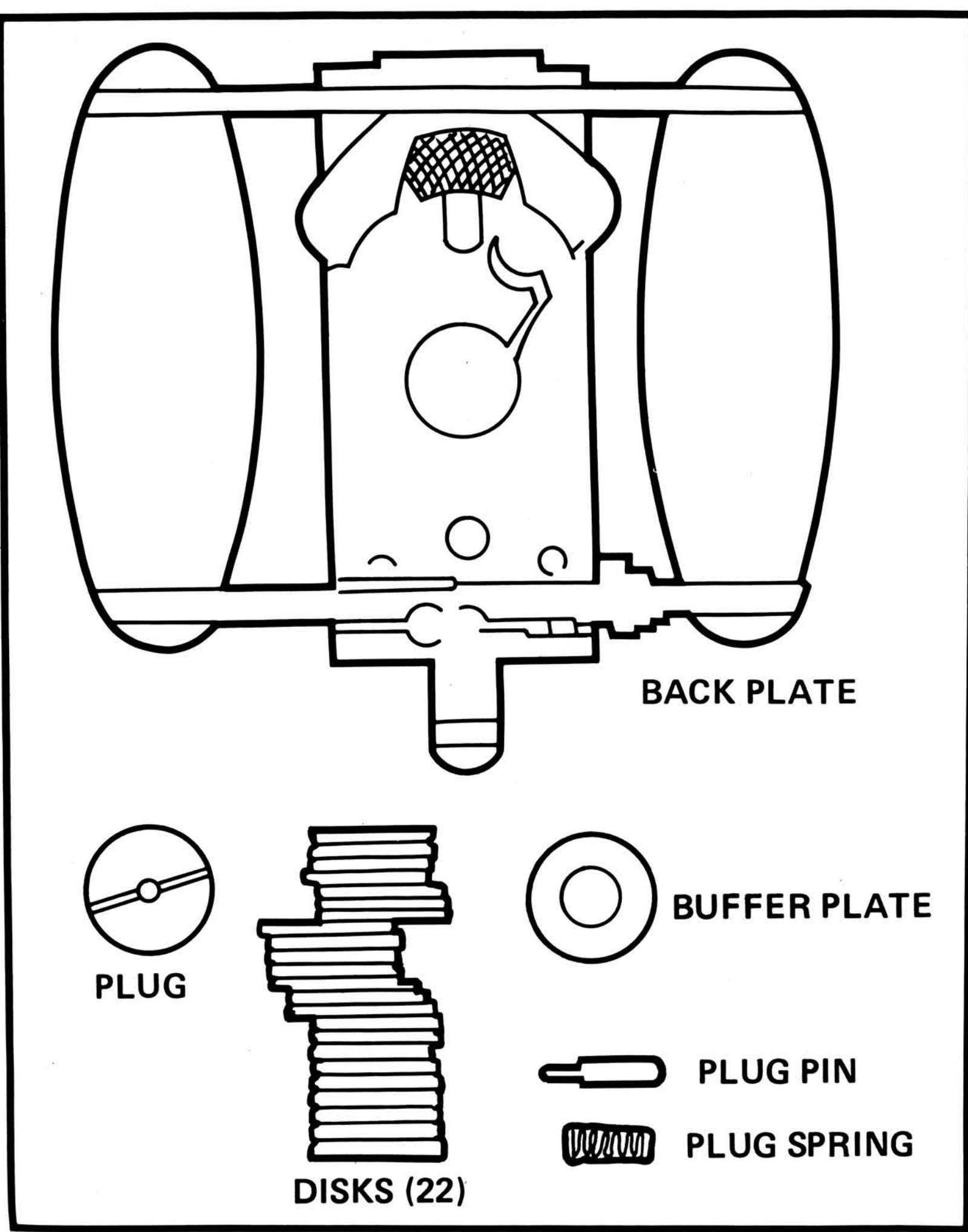
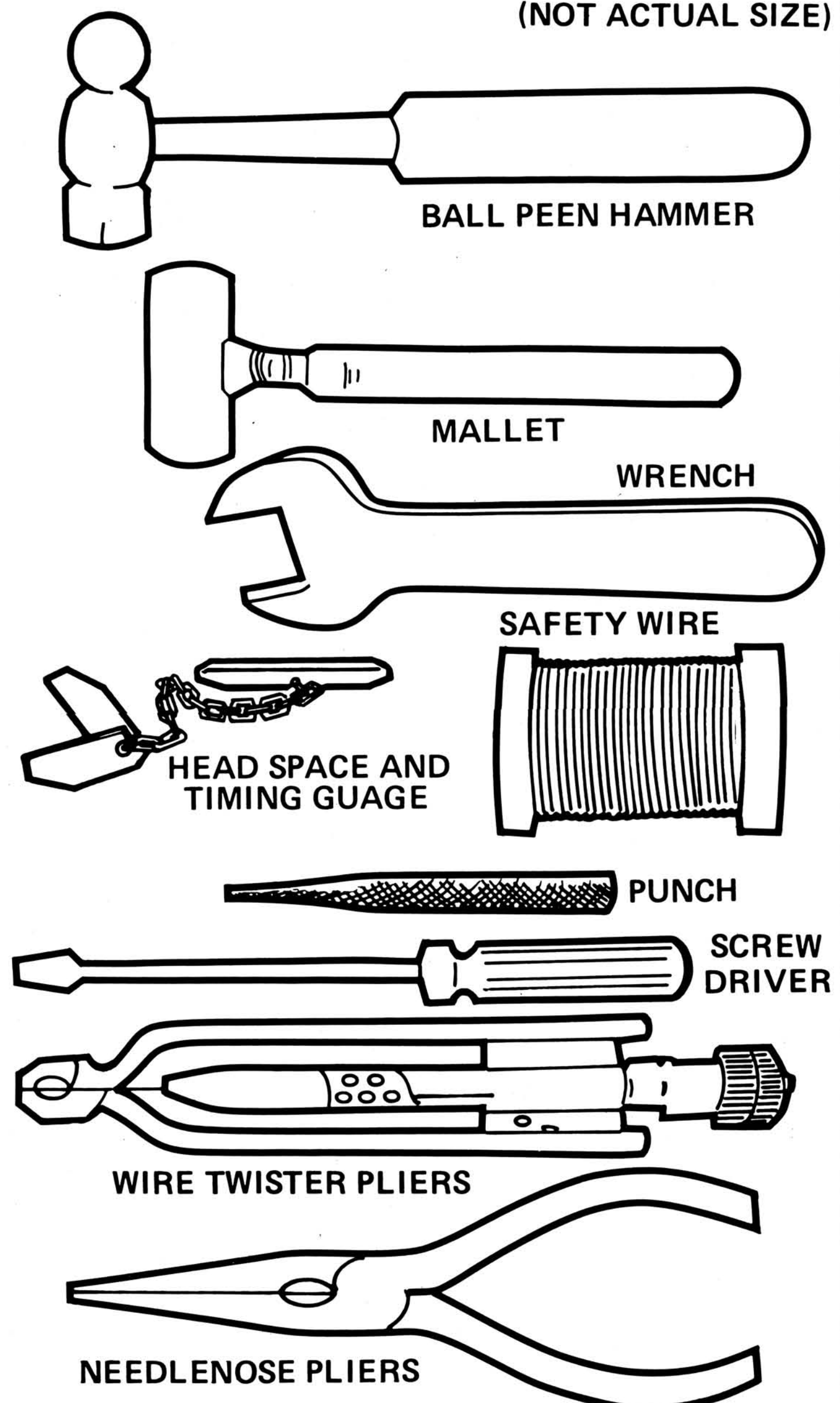


# DISASSEMBLY CHECKLIST

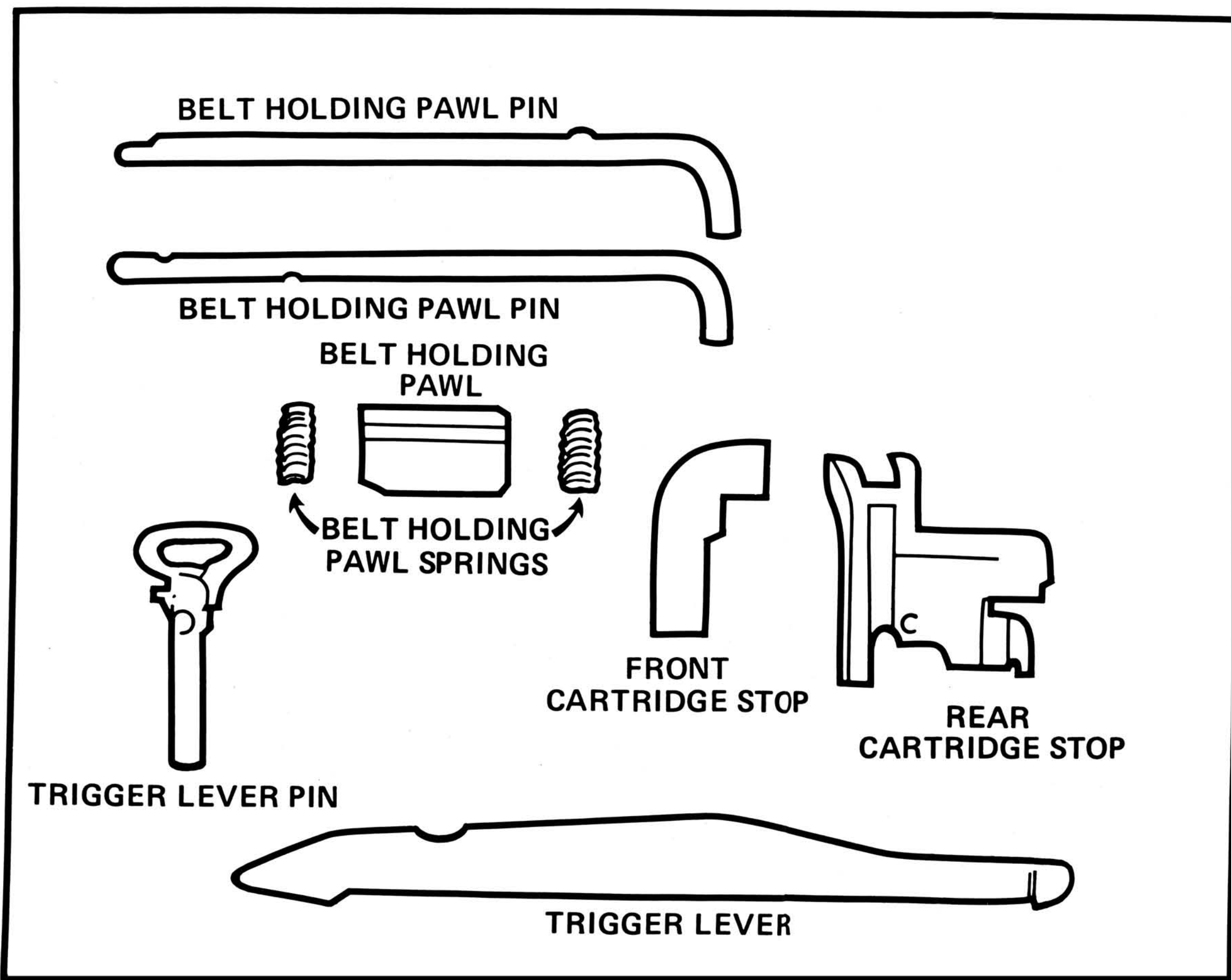
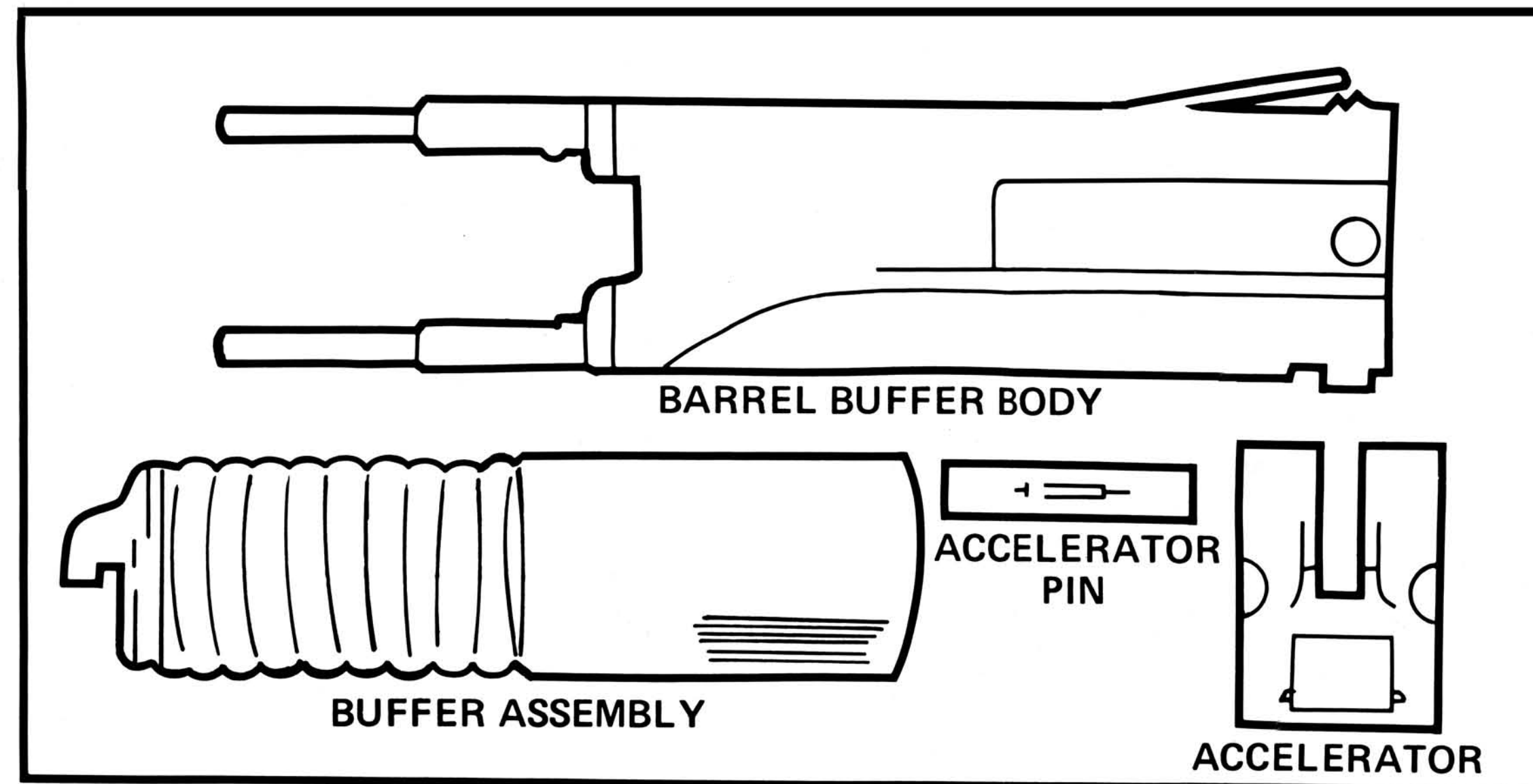
1. CLEAR THE WEAPON
2. REMOVE THE BACK PLATE ASSEMBLY
3. REMOVE DRIVE SPRING ROD ASSEMBLY
4. REMOVE BOLT STUD
5. REMOVE BOLT GROUP
6. REMOVE AND SEPARATE BARREL BUFFER GROUP AND BARREL EXTENSION GROUP
7. REMOVE COVER GROUP  
REMOVE COVER PIN  
REMOVE COTTER PIN
8. REMOVE RETRACTING SLIDE ASSEMBLY  
REMOVE SAFETY WIRES (2)  
REMOVE MACHINE SCREWS (3)  
REMOVE COTTER PINS (2)  
REMOVE HEX NUTS (2)  
REMOVE SHOULDER BOLTS (2)
9. DISASSEMBLE RECEIVER GROUP  
REMOVE BELT HOLDING PAWL PIN  
REMOVE BELT HOLDING PAWL  
REMOVE BELT HOLDING PAWL SPRINGS (2)  
REMOVE BELT HOLDING PAWL PIN  
REMOVE FRONT CARTRIDGE STOP  
REMOVE REAR CARTRIDGE STOP  
REMOVE TRIGGER LEVER PIN  
REMOVE TRIGGER LEVER
10. DISASSEMBLE RETRACTING SLIDE ASSEMBLY  
REMOVE COTTER PIN  
REMOVE HEX NUT  
REMOVE THRUST WASHER  
REMOVE RETRACTING SLIDE LEVER AND HANDLE  
REMOVE TORSION SPRING  
REMOVE RETRACTING SLIDE STUD  
REMOVE RETRACTING SLIDE
11. DISASSEMBLE COVER ASSEMBLY  
REMOVE BELT FEED LEVER PIN  
REMOVE BELT FEED LEVER  
REMOVE AND SEPARATE BELT FEED LEVER PLUNGER AND SPRING  
REMOVE COVER LATCH SPRING  
REMOVE COVER EXTRACTOR SPRING
12. REMOVE BELT FEED SLIDE ASSEMBLY
13. DISASSEMBLE BELT FEED SLIDE ASSEMBLY  
REMOVE BELT FEED PAWL PIN  
REMOVE BELT FEED PAWL  
REMOVE BELT FEED PAWL ARM  
REMOVE BELT FEED PAWL SPRING
14. DISASSEMBLE COVER LATCH ASSEMBLY  
REMOVE COTTER PIN  
REMOVE COVER LATCH SHAFT  
REMOVE THRUST WASHER  
REMOVE COVER LATCH
15. DISASSEMBLE BARREL EXTENSION  
REMOVE BREECH LOCK PIN  
REMOVE BREECH LOCK
16. DISASSEMBLE BOLT  
REMOVE EXTRACTOR ASSEMBLY  
REMOVE BOLT SWITCH  
REMOVE COCKING LEVER PIN  
REMOVE COCKING LEVER  
REMOVE ACCELERATOR STOP LOCK  
REMOVE ACCELERATOR STOP  
REMOVE SEAR SLIDE  
REMOVE SEAR  
REMOVE SEAR SPRING  
REMOVE FIRING PIN EXTENSION  
REMOVE FIRING PIN
17. DISASSEMBLE THE BACK PLATE ASSEMBLY  
REMOVE PLUG  
REMOVE HEADLESS SHOULDER PIN  
REMOVE HELICAL SPRING  
REMOVE DISKS (22)  
REMOVE BUFFER PLATE

## TOOLS

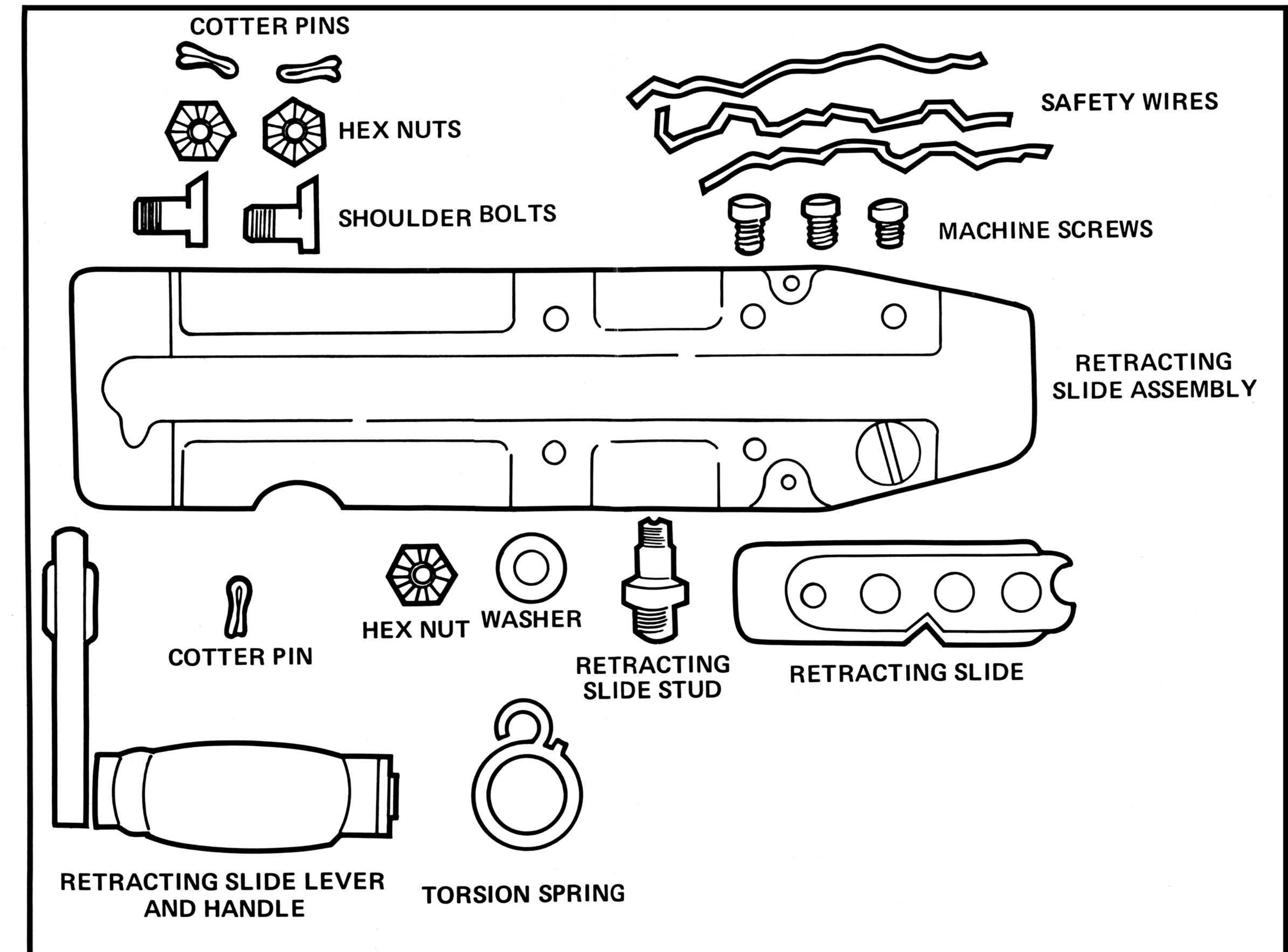
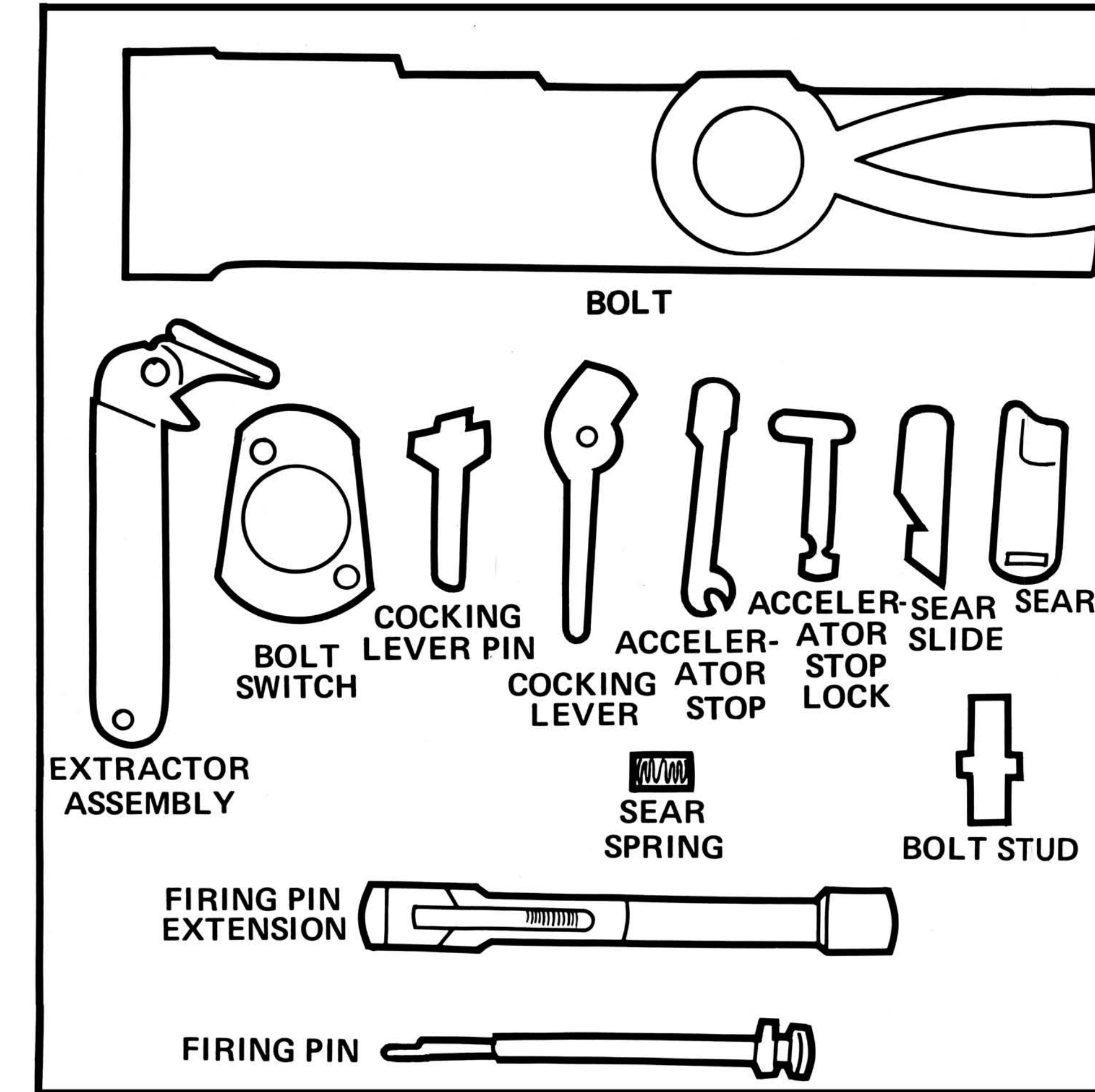
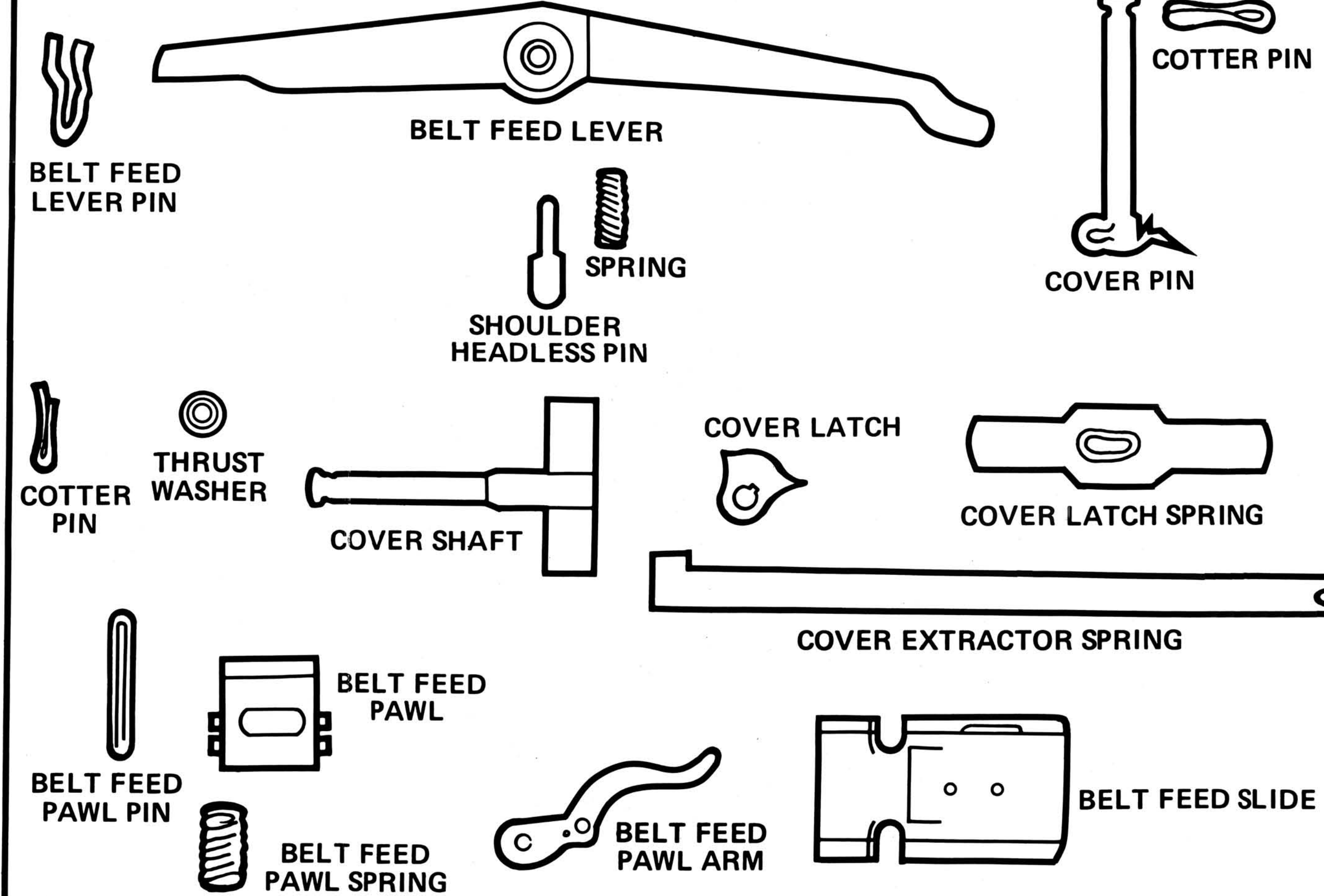
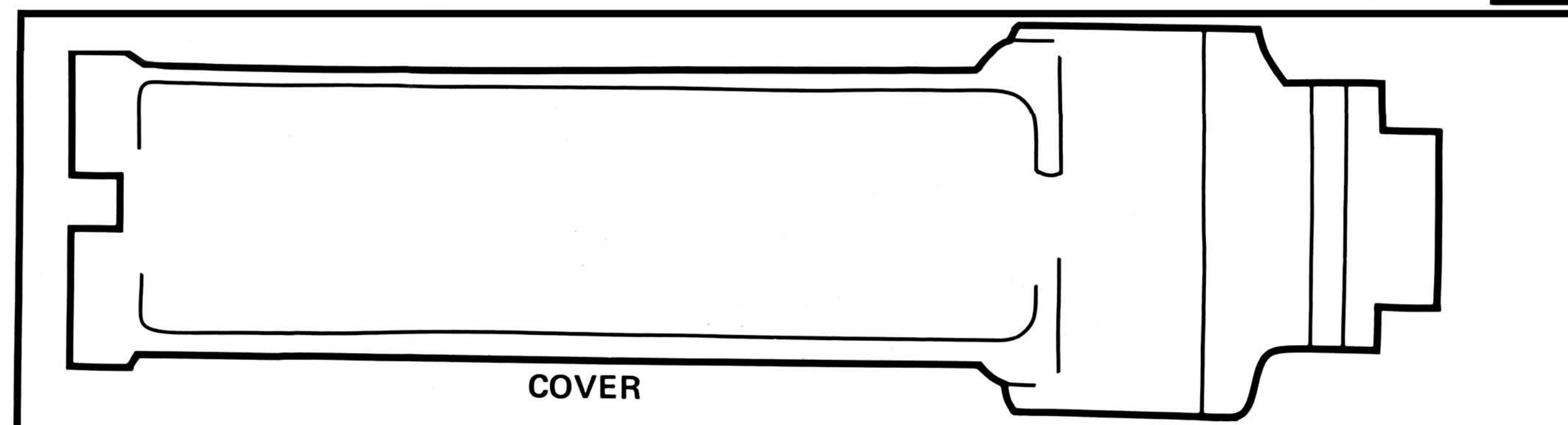
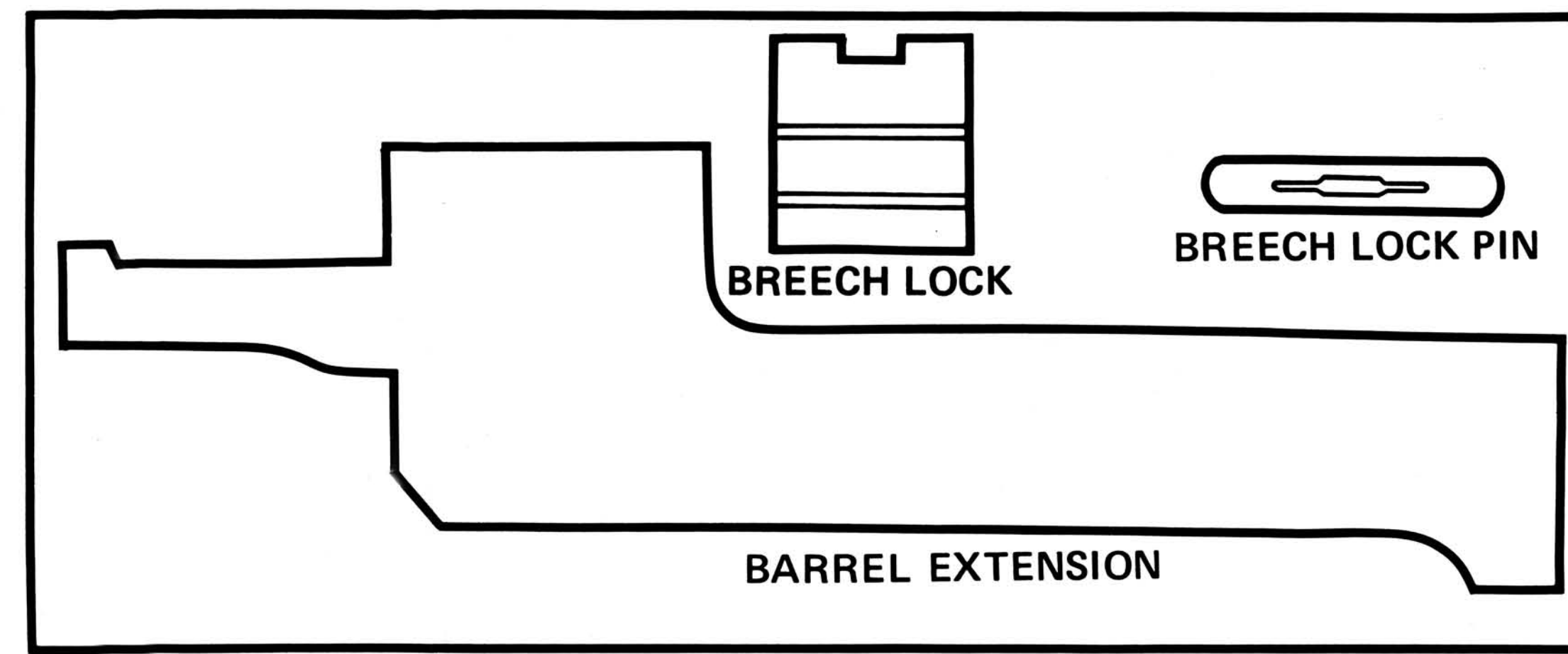
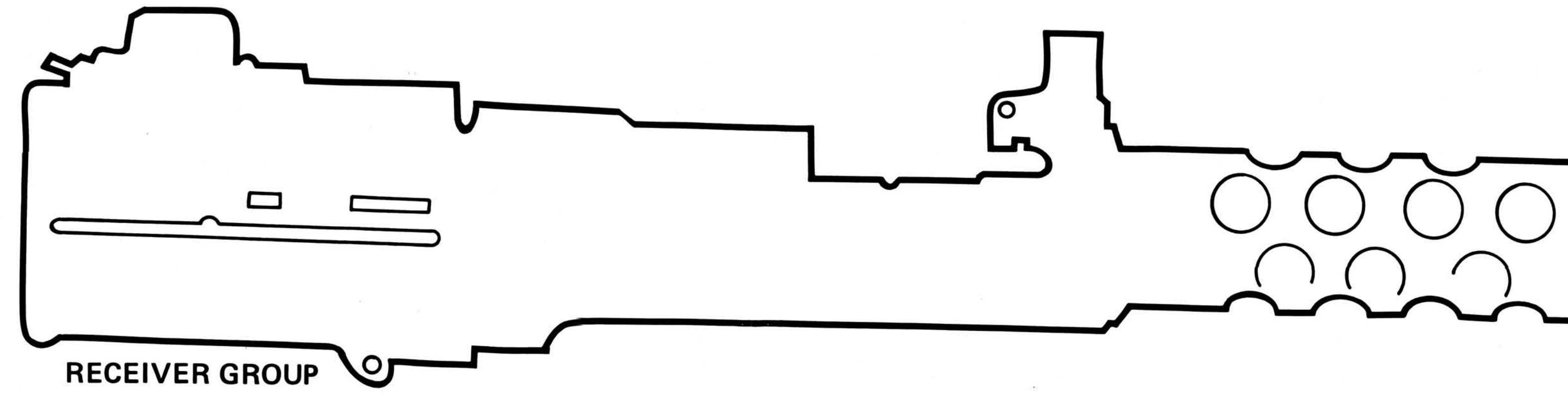
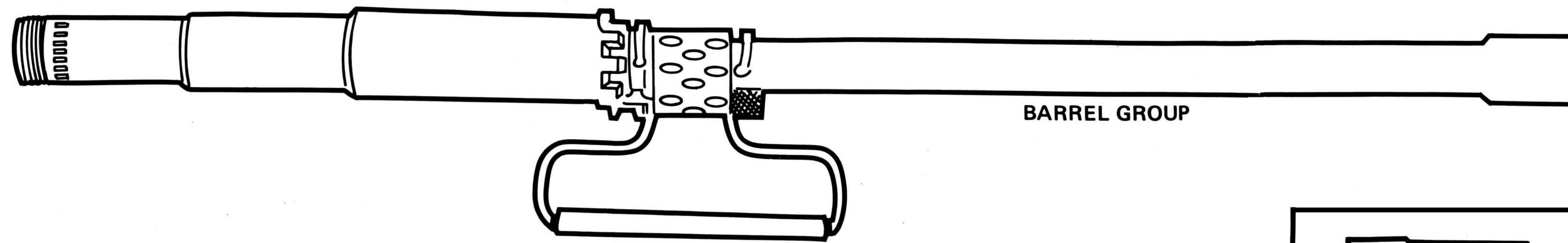
(NOT ACTUAL SIZE)



## DRIVE SPRING ROD ASSEMBLY



# .50 CALIBER MG LAYOUT CHART



# ASSEMBLY CHECKLIST

1. ASSEMBLE RECEIVER GROUP  
INSTALL TRIGGER LEVER  
INSTALL TRIGGER LEVER PIN  
INSTALL REAR CARTRIDGE STOP  
INSTALL FRONT CARTRIDGE STOP  
INSTALL BELT HOLDING PAWL SPRINGS  
INSTALL BELT HOLDING PAWL  
INSTALL BELT HOLDING PAWL PIN
2. ASSEMBLE RETRACTING SLIDE ASSEMBLY  
INSTALL RETRACTING SLIDE  
INSTALL RETRACTING SLIDE STUD  
INSTALL TORSION SPRING  
INSTALL LEVER GROUP HANDLE  
INSTALL THRUST WASHER  
INSTALL HEX NUT  
INSTALL COTTER PIN
3. ASSEMBLE COVER LATCH ASSEMBLY  
INSTALL COVER LATCH  
INSTALL COVER LATCH SHAFT WASHER  
INSTALL COVER PIN
4. ASSEMBLE COVER  
INSTALL COVER EXTRACTOR SPRING  
INSTALL COVER LATCH SPRING  
JOIN AND INSTALL BELT FEED LEVER PLUNGER  
INSTALL BELT FEED LEVER  
INSTALL BELT FEED LEVER PIN
5. ASSEMBLE BELT FEED SLIDE  
INSTALL BELT FEED PAWL ARM  
INSTALL BELT FEED PAWL SPRING  
INSTALL BELT FEED PAWL  
INSTALL BELT FEED PAWL PIN
6. INSTALL BELT FEED SLIDE ASSEMBLY
7. ASSEMBLE BARREL BUFFER GROUP  
INSTALL ACCELERATOR PIN  
INSTALL BARREL BUFFER
8. ASSEMBLE BARREL EXTENSION GROUP  
INSTALL BREECH LOCK  
INSTALL BREECH LOCK PIN
9. ASSEMBLE BOLT GROUP  
INSTALL FIRING PIN  
INSTALL FIRING PIN EXTENSION  
INSTALL SEAR SPRING  
INSTALL SEAR  
INSTALL SEAR SLIDE  
INSTALL ACCELERATOR STOP  
INSTALL ACCELERATOR STOP LOCK  
INSTALL COCKING LEVER  
INSTALL COCKING LEVER PIN  
INSTALL BOLT SWITCH  
INSTALL EXTRACTOR ASSEMBLY
10. ASSEMBLE BACK PLATE  
INSTALL BUFFER PLATE  
INSTALL DISKS (22)  
INSTALL PLUG SPRING  
INSTALL PLUG PIN  
INSTALL PLUG
11. INSTALL RETRACTING SLIDE ASSEMBLY  
INSTALL SHOULDER BOLTS (2)  
INSTALL HEX NUTS (2)  
INSTALL COTTER PINS (2)  
INSTALL MACHINE SCREWS (3)  
INSTALL SAFETY WIRES (2)
12. INSTALL COVER GROUP  
INSTALL COVER PIN  
INSTALL COTTER PIN
13. JOIN AND INSTALL BARREL BUFFER GROUP AND BARREL EXTENSION GROUP
14. INSTALL BOLT
15. INSTALL BOLT STUD
16. INSTALL DRIVE SPRING ROD ASSEMBLY
17. INSTALL BACK PLATE ASSEMBLY
18. PERFORM FUNCTION CHECK

Wipe with a clean, dry cloth or tissue to remove oil or grease. Do not use cleaning solvents.