

# Checking Headspace on an MG34 Barrel

Since the receiver and barrel jacket control the orientation of the rotational alignment between the bolt and barrel assemblies, headspace must be checked within assembled guns.

## On the MG34:

- Remove the extractor from the bolt.
- Remove the top cover, feed tray, and mainspring.
- Insert the barrel into the jacket making sure that it reciprocates freely prior to closing with the receiver to simulate its short recoil movement. If the barrel is sticking or dragging, the jacket is likely bent and the system will not function.

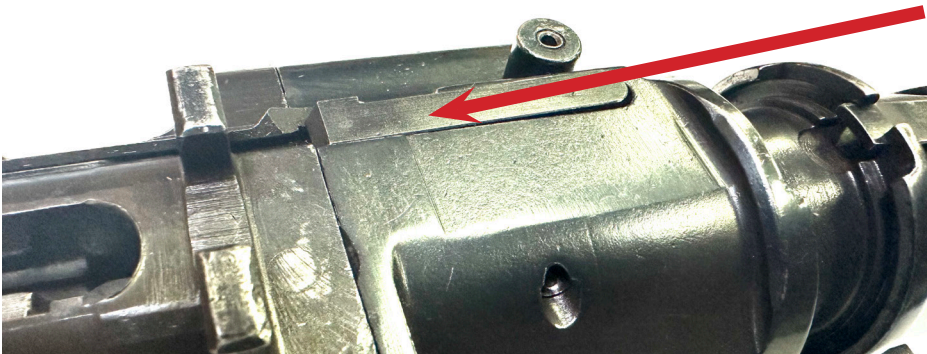
## Method 1:

Insert a gauge close to the minimum acceptable headspace (1.6355" for NATO and 1.63" for .308 Win.), close with receiver, and push the bolt forward. The bolt head and carrier should twist into each other far enough to:

- A) Trip the firing lever
- B) Lock on the barrel jacket bolt catch lever. (*Figure 1*)

Lastly, insert the Max/Field gauge and repeat making sure that the barrel jacket bolt catch lever does NOT lock on the bolt head. (*Figure 2*)

## Barrel Jacket Bolt Catch Lever Shown LOCKED on the Right Side Bolt Roller



\* The bolt rotated in the system to properly lock on the barrel jacket bolt catch lever.

## Barrel Jacket Bolt Catch Lever Shown UNLOCKED

\*\* The bolt cannot rotate in the system far enough to properly lock on the barrel jacket bolt catch lever.

