



# **SEMI-AUTO UKM MANUAL ADDENDUM**

**IMPORTANT! THIS MANUAL DOES NOT REPLACE THE  
SEMI UK-59 MANUAL – IT IS JUST AN ADDENDUM –  
BOTH MANUALS MUST BE READ AND UNDERSTOOD! \***

## **\*\*\* IMPORTANT SAFETY NOTICE \*\*\***

**BEFORE YOU OPERATE THIS FIREARM YOU MUST READ AND UNDERSTAND THIS MANUAL INCLUDED WITH YOUR PACKAGE!** Owning a belt-fed firearm, even in semi-auto form, introduces changes to the required steps to ensure that the firearm is safe. In addition, due to its belt-fed operation, the steps to correctly and safely operate the firearm are different than a magazine fed firearm. **SO READ THE MANUAL AND FAMILIARIZE YOURSELF WITH THE FIREARM'S OPERATION BEFORE ATTEMPTING TO SHOOT IT.**

**SHOOTING IS AN INHERENTLY DANGEROUS ACTIVITY - FIREARMS CAN CAUSE SERIOUS INJURY OR DEATH. THIS IS EVEN MORE TRUE IF YOU ARE NOT KNOWLEDGEABLE ABOUT THE OPERATION AND FEATURES OF YOUR FIREARM OR IF THEY ARE HANDLED IN AN UNSAFE MANNER. BY SHOOTING THIS FIREARM THE OPERATOR ASSUMES FULL RESPONSIBILITY FOR THEIR ACTIONS, THE ACTIONS OF OTHERS ALLOWED TO USE OR HAVE ACCESS TO THE FIREARM, AND THE SAFETY OF OTHERS WHO MAY BE PARTICIPATING OR EVEN UNAWARE OF THE SHOOTING ACTIVITY. YOU ARE RESPONSIBLE FOR EVERYONE WHEN YOU OWN AND SHOOT A FIREARM.**

**PREVENT ACCESS TO THIS FIREARM BY CHILDREN AND/OR UNAUTHORIZED PARTIES! KEEP IT LOCKED AWAY AND UNLOADED WHEN NOT IN USE. SEVERE PENALTIES EXIST IF A CHILD OR ANY ONE ELSE OBTAINS AND IMPROPERLY USES A FIREARM, YOU MAY BE HELD FINANCIALLY RESPONSIBLE AND EVEN BE SENT TO PRISON.**

**WE RECOMMEND ONLY NEW, FRESH MILITARY SURPLUS STEEL CASED AMMUNITION BE USED IN THIS FIREARM. HOWEVER, SOME SURPLUS AMMUNITION MAY BE FAULTY OR EVEN DANGEROUS. WE ARE NOT RESPONSIBLE FOR DAMAGE OR INJURY AS A RESULT OF USING FAULTY, NON-STANDARD OR REMANUFACTURED AMMUNITION. COMMERCIAL AMMUNITION HAS LIGHT PRIMERS - THEREFORE DO NOT USE COMMERCIAL AMMUNITION, ONLY MILITARY SURPLUS. LIGHT PRIMERS MAY LEAD TO ACCIDENTAL DISCHARGE WHEN THE BOLT IS CLOSED. ALWAYS ENSURE THE GUN IS POINTED IN A SAFE DIRECTION BEFORE LOADING!**

**DO NOT MODIFY OR CHANGE THIS FIREARM. ITS SYSTEMS HAVE BEEN DESIGNED IN A CERTAIN WAY TO BE SAFELY USED BY THE OPERATOR. WE ARE NOT RESPONSIBLE FOR ANY DAMAGE OR INJURY DUE TO ANY MODIFICATION OR CHANGE MADE BY THE OWNER OR USER.**

**MARCOLMAR FIREARMS LLC IS NOT RESPONSIBLE FOR ACCIDENTS, INJURIES, DAMAGE OR DEATH RELATED TO UNSAFE HANDLING, IMPROPER ACTIONS, UNFAMILIAR OPERATION, IMPROPER BACKSTOP, FAULTY AMMUNITION, OR WORN COMPONENTS. DON'T TAKE RISKS - THOROUGHLY FAMILIARIZE YOURSELF WITH THE FIREARM AND FEATURES OF THE SEMI-AUTO UKM. IF YOU ARE UNSURE - STOP - MAKE THE FIREARM SAFE - AND CONSULT THE MANUAL OR CONTACT US! AND REMEMBER - DON'T RELY ON MECHANICAL SAFETIES - TREAT EVERY GUN AS IF IT IS LOADED! THOROUGHLY CLEAR / UNLOAD ANY GUN THAT IS NOT TO BE IMMEDIATELY FIRED!!**

## **SAFETY:**

Safety is **EVERYONE'S** concern. We want to ensure that you, your Semi-Auto UKM, and anyone who may be close while firing, or around the gun while stored, is always safe. **DON'T GIVE THE ANTI-GUNNERS ANYTHING TO TALK ABOUT!** Ensure the firearm is always secured and follow the NRA's Rules of Safety:

1. **TREAT EVERY FIREARM AS IF IT WERE LOADED AT ALL TIMES.**
2. **ALWAYS KEEP THE GUN POINTED IN A SAFE DIRECTION.**
3. **KEEP YOUR FINGER OFF THE TRIGGER UNTIL READY TO SHOOT.**
4. **ALWAYS CARRY YOUR FIREARM IN A MANNER SO NO ONE WOULD BE HURT IF YOU STUMBLED OR FELL.**
5. **BEFORE YOU SHOOT CHECK THE BARREL FOR OBSTRUCTIONS AND THE ACTION FOR PROPER FUNCTIONING.**
6. **ALWAYS KEEP THE GUN UNLOADED AND SECURED WHEN NOT IN USE.**
7. **KNOW YOUR TARGET! DO NOT SHOOT AT UNSAFE TARGETS OR THOSE THAT COULD POSE A RICHOCHET THREAT.**
8. **KNOW YOUR BACKSTOP! MAKE SURE IT IS CLEAR AND SAFE AND THERE ARE NOT PEOPLE OR PROPERTY BEYOND AT RISK.**
9. **ALWAYS USE HEARING AND EYE PROTECTION AT ALL TIMES.**
10. **KNOW HOW TO USE THE FIREARM AND MAINTAIN IT. NEVER ALLOW THOSE UNFAMILIAR WITH ITS OPERATION TO USE IT.**
11. **USE THE CORRECT AMMUNITION FOR YOUR GUN. USE CLEAN AND FRESH STEEL CASED MILITARY SURPLUS / FACTORY LOADED AMMUNITION OF THE CORRECT CALIBER.**
12. **NEVER PASS A LOADED FIREARM TO ANOTHER PERSON. ENSURE THE FIREARM IS UNLOADED AND THE ACTION IS OPEN AND SAFE.**
13. **NEVER USE ALCOHOL, ILLEGAL DRUGS, OR OVER-THE-COUNTER DRUGS BEFORE OR WHILE SHOOTING!**
14. **STORE THE FIREARM SECURELY SO THAT IT IS NOT AVAILABLE TO UNAUTHORIZED PERSONS – ESPECIALLY CHILDREN! NEVER STORE THE AMMUNITION WITH THE GUN – PLACE AMMUNITION IN SECURE STORAGE AS WELL.**
15. **NEVER STORE THE FIREARM LOADED! WHEN SHOOTING IS COMPLETE UNLOAD THE FIREARM BEFORE TRANSPORT AND STORAGE.**
16. **DON'T RELY ON YOUR FIREARMS SAFETY MECHANISM. HANDLE EVERY FIREARM AS IF IT WILL GO OFF AT ANY TIME – EVEN WITHOUT THE TRIGGER BEING PULLED.**
17. **DO NOT ALTER OR MODIFY THIS GUN IN ANY WAY. IF YOU ARE HAVING PROBLEMS CONTACT THE MANUFACTURER DIRECTLY. ALTERING OR MODIFYING THIS FIREARM VOIDS THE WARRANTY AND MAY CAUSE UNSAFE CONDITIONS OR EVEN DEATH.**
18. **HAVE YOUR FIREARM OCCASIONALLY INSPECTED BY A COMPETENT GUNSMITH TO ENSURE IT IS STILL IN GOOD RUNNING CONDITION.**
19. **IF THE FIREARM FAILS TO FIRE WHEN THE TRIGGER IS PULLED – BE EXTREMELY CAUTIOUS! KEEP THE MUZZLE POINTED IN A SAFE DIRECTION IN CASE THE FIREARM DOES DISCHARGE. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AND WAIT AT LEAST 30 SECONDS TO ENSURE THAT IT IS NOT A DELAYED IGNITION OR FIRING**

CARTRIDGE. AFTER 30 SECONDS CAREFULLY OPEN THE ACTION, UNLOAD THE FIREARM, AND SAFELY DISPOSE OF THE ROUND.

20. DO NOT ALLOW THE FIREARM TO BUILD UP EXCESSIVE HEAT BY RAPID AND CONTINUOUS SHOOTING. DOING SO MAY ALLOW THE FIREARM TO HEAT TO THE POINT THAT ROUNDS BEGIN TO "COOK OFF" IN THE ACTION. THIS CONDITION WILL ALLOW THE ROUND TO FIRE WITHOUT THE OPERATOR PRESSING THE TRIGGER. BETWEEN BELTS OR AFTER LONG FIRING SESSIONS, PERIODICALLY ALLOW THE FIREARM TO TOTALLY COOL BEFORE SHOOTING.

**WARNING:** SHOOTING FIREARMS IN POORLY VENTILATED AREAS, CLEANING THEM, AND HANDLING AMMUNITION, MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM, AND OTHER SERIOUS INJURIES. ALWAYS ENSURE YOU HAVE ADEQUATE VENTILATION WHEN SHOOTING AND CLEANING YOUR FIREARM. ALWAYS WASH YOUR HANDS WHEN YOU ARE THROUGH SHOOTING AND CLEANING YOU FIREARM, OR AFTER HANDLING AMMUNITION.

AND FINALLY:

**YOUR PURCHASE AND SUBSEQUENT USE OF THIS FIREARM DEMONSTRATES YOUR UNDERSTANDING AND AGREEMENT WITH THE PRECEDING STATEMENTS, AND YOUR PERSONAL ACCEPTANCE OF ALL RESPONSIBILITY FOR THIS FIREARM AND ITS USE.**

**IMPORTANT SAFEGUARDS ON THIS GUN!**

\*\*\* SINCE THIS GUN USES THE TOPCOVER AS THE BARREL LATCH, **NEVER EVER** FIRE THE SEMI-AUTO UKM WITH THE TOPCOVER UP OR UNLATCHED!!! DOING SO MAY RESULT IN HEADSPACE ISSUES AND RESULT IN A DANGEROUS PRESSURE CONDITION! \*\*\*

\*\*\* IF YOU CHARGE THE GUN WITH THE SAFETY ON, DAMAGE TO THE GUN MAY RESULT. THE GUN SHOULD **NEVER** BE COCKED, OR THE PISTOL GRIP UNLOCKED AND FULLY MOVED TO THE REAR ALLOWING THE BOLT PIN TO ENGAGE THE BOLT PIN RAMP, WITH THE SAFETY ON! \*\*\*

\*\*\* **NEVER EVER** ALLOW THE BOLT CARRIER AND BOLT TO FLY FORWARD UNDER SPRING PRESSURE WITHOUT THE BARREL IN THE RECEIVER, AND LOCKED IN PLACE. DOING SO WILL DAMAGE THE GUN! \*\*\*

\*\*\* SINCE THIS GUN HAS A REMOVABLE BARREL, ALWAYS ENSURE THAT THE BARREL IS **FULLY SEATED** AND PUSHED ALL THE WAY INTO THE RECEIVER BEFORE FIRING OR CYCLING THE ACTION! \*\*\*

\*\*\* NOTE: NEVER EVER USE A DIFFERENT TOPCOVER WITH YOUR GUN. THIS IS AN INTEGRAL PART, AND WORKS IN CONCERT WITH THE BARREL AND BOLT LOCK TO SET HEADSPACE! REPLACEMENT COULD LEAD TO A DANGEROUS CONDITION WITHOUT CHECKING HEADSPACE! \*\*\*

## **CONGRATULATIONS ON YOUR PURCHASE OF THE SEMI-AUTO UKM!**

We are confident that this limited run of UKMs will be the highlight of your military firearm collection. MarColMar Firearms LLC has taken great care in the design, construction and quality of production with this firearm.

**THIS MANUAL DOES NOT REPLACE THE SEMI-AUTO UK-59 MANUAL YOU ALSO RECEIVED WITH YOUR UKM... IT IS AN ADDENDUM, AND IS DESIGNED TO ONLY OUTLINE THE ENHANCEMENTS MADE TO THE UK-59 TO MAKE IT THE UPDATED UKM. YOU MUST ALSO READ AND UNDERSTAND THE UK-59 MANUAL TO SAFELY AND COMPETENTLY OPERATE YOUR UKM! IF YOU LATER SELL THIS FIREARM, BOTH MANUALS MUST ACCOMPANY IT!**

MarColMar's development of the UKM was born out of our past experience with the semi-auto PKM and UK-59. These classic firearms each have their own unique advantages and disadvantages, and we wanted to design a new, modern firearm, that would not only incorporate the advantages of each design, but also bring to the table some features that neither can easily offer. The UKM was born out of that effort.

The UKM has the following advantages over the PKM and Uk-59:

### **Better than PKM:**

**Receiver:** The UKM retains the UK-59 milled receiver, which the original factory rated to 5 million rounds. Firearms aficionados understand that the milled receiver is much more durable than those that are stamped from sheet metal. Receiver twisting, stretching, and rivet stress is no longer a concern. The disposable sheet metal receiver of the PKM, M60, and MG42 type weapons must be monitored and maintained to a much greater degree than a milled receiver counterpart.

**Barrel Change:** The PKM requires the shooter to open not only the topcover, but also the feed tray to change the barrel. Once both are lifted, it also requires the manipulation of a small barrel "gate" to release the current barrel. The reverse is required to put the firearm back in service. The UKM utilizes the same system as the Uk-59, which simply requires only the topcover to be opened and rotated right to release the barrel, and the reverse to lock the new barrel in. The result is a much faster barrel change.

**Push Through Belt/Overall Length:** The PKM utilizes the older Maxim belt that requires the round be removed to the rear. This greatly increases the overall length of the receiver, and thus the entire firearm. The UKM utilizes the push through belt of the Uk-59, which is robust and easy to load. The result is a much shorter and easier to maneuver firearm.

**In Field Repair:** The PKMs sheet metal construction requires rivets to be used to affix many of the operational components to the receiver, such as the feed pawl and ejector. Due to the milled receiver, the UKM and Uk-59 allows much easier maintenance and field replacement of critical components. The ejector, feed pawl, and belt retainers are all user replaceable in the field. In addition, unlike many of the PKMs critical parts that are sheet metal stamped, the Uk and UKM are machined for longer wear and greater strength.

**Parts Cost/Availability:** PKM parts have gotten prohibitively expensive. Uk-59 parts sets are still readily available and inexpensive in comparison. The owner can build a good set of maintenance parts at much cheaper prices, to keep the gun running for a lifetime.

**Bolt Handle:** The weak point of the PKM is the bolt handle. It invariably is bent or broken when trying to remove stuck steel cartridges due to its linkage, or worse yet, the receiver channel can be damaged as well. The Uk and UKM utilizes the pistol grip itself, for greater leverage and the ability to maintain the firing hand on the controls.

### **Better than UK-59:**

**Buttstock:** Like the PKM, the buttstock of the UKM provides the shooter a handhold for the offhand, which is the preferred way to shoot and manipulate light machine gun types of firearms. This feature was not found on the UK-59 but has been added to the UKM.

**Bipod:** Like the M-60, the UK-59 requires the user to move the bipod to the spare barrel when switching barrels, or have another bipod on the spare barrel itself. On the UKM MarColMar moved the bipod to the receiver, just like the PKM. This allows the gun to remain in place while a spare barrel is put into the receiver, increasing replacement speed, and increasing convenience while the gun is being cleaned or worked on.

**Flash Hider:** The original UK-59 utilizes a cone shaped flash hider, which actually masks the effects of muzzle flash from the shooter, not necessarily from the “enemy.” The UKM utilizes the late model Uk-59 flash hider, very reminiscent of the early PK or M-60 flash hider, which due to its design, is much more effective at reducing flash both for the shooter and “enemy.”

### **Better than Both:**

**Furniture:** Both the original PKM and the Uk-59 utilized wood furniture, in either standard, or laminated form. Wood is subject to damage from abrasion, water intrusion, and heat. Due to this, the UKM was developed with completely synthetic furniture that is far more resistant to these potential sources of damage.

**Rail Flexibility:** Neither the original PKM or Uk-59 have the ability to easily mount rail systems like more modern firearms. This leaves both firearms unable to utilize many of the modern sights, tactical handles, and illuminators, as well as many other shooting aids developed for the picatinny rail system. From the beginning, MarColMar wanted to rectify this issue, so the UKM was developed with a picatinny rail handguard, as well as a picatinny rail for optical and iron sights.

**Sight Height:** The UKM utilizes the standard AR-15 sight height to allow access to all kinds of rear sights, optics, and provide co-witnessing of sights, if so desired.

## **Important Features of the UKM:**

As we have said, the UKM functions exactly like the Uk-59 Semi, which is covered extensively in the included manual. Please thoroughly read and understand that manual for operating details.

This Addendum will provide details of the changes and guidance for the owner about those changes and their use:

### **Bipod:**

The UKM has moved the bipod from the front of the Uk-59 barrel, to the receiver mounted rail system. This bipod is an original Uk-59 bipod, chosen for its strength and capability. The bipod adaptor is designed to accept the bipod just like the original Uk-59 front sight, but with picatinny rail capability. The bipod has been cut to size and welded as well, and allows the shooter to pitch the bipod forward and back, and has a degree of side-to-side cant, and even traverse.

Should you decide to replace the bipod of this firearm please note... **THIS IS A HEAVY GUN AND AR-15 TYPE BIPOD SYSTEMS ARE INADEQUATE TO TAKE THE WEIGHT AND STRESS OVER TIME.** Using these bipods could lead to their failure and in some situations, an unsafe condition. If you decide to replace the bipod, only use those that are designed for the weight of the gun, and the power of its cartridge.

### **Forward Rails:**

The receiver mounted rail system is made of aluminum and has been anodized black. The rail system features rails on the left, right, and bottom of the receiver. This is to allow the use of many grips, illuminators, and other tactical accessories that many shooters desire.

The rail system is attached to the receiver by the rearmost three bolts (toward the shooter) on each side. The bolts are allen keyed 5/32", and the two rearmost bolts on each side are 1/2" while the third bolt is 5/8". **WE DO NOT RECOMMEND THAT YOU REMOVE THE RAIL SYSTEM FROM THE UKM RECEIVER. HOWEVER IT IS RECOMMENDED THAT YOU CHECK THE THREE REARMOST BOLTS ON EACH SIDE FROM TIME-TO-TIME, TO ENSURE THEY ARE SNUG AND NOT WORKING LOOSE.** If for some reason you do remove the rail system, the bolts MUST be put back in the correct order, or damage to the receiver may result!!

**NEVER OVER-TIGHTEN THESE BOLTS. JUST ENSURE THEY ARE HAND TIGHT AND SNUG FOR SHOOTING!**

On the bottom of the rail you will see two vents or outlets; when you clean your UKM make sure to pay special attention to this area, and remove all carbon and other deposits from firing, and oil this area. In addition, pay special attention to the gas piston area, and the area just beyond it inside the rail system, to ensure it remains clean and free of rust and deposits.

Finally, while the rail system has been tested for its bipod, **WE DO NOT RECOMMEND THAT YOU UTILIZE THESE RAILS TO SUPPORT THE FULL WIGHT OF THE GUN ON A STAND UP MOUNT OR SIMILAR DEVICE.** Doing so could damage the rails, or even the threading of the rail system to the receiver.

### **Rear Sight Picatinny:**

The rear sight is now on a picatinny rail. The gun also comes with a quick flip backup sight. Any standard AR-15 rear sight can be used in this application as the UKM features a standard AR-15 sight height.

The rear sight picatinny can accommodate many lightweight rear sights and optics. However we do not recommend that large and heavy night vision or similar infa-red system utilize this rail. Anything that is heavy could cause stress or damage to the rail and/or receiver.

### **Stocks / Furniture:**

The UKM features injection-molded stocks that are impervious to moisture. No special care is required. Simply oil the stocks from time-to-time to keep them looking dark. Avoid having them come in contact with any abrasives as well to keep them looking nice. On the back of the buttstock you will find a Magpul AR-15 recoil pad. If for some reason the length of the stock is too much, the user may replace this pad with a thinner Magpul AR-15 recoil pad of the same type.

### **Tripod:**

Due to the use of tripods being a rare and unusual occurrence for any firearm other than a heavy machinegun in the modern militaries of the world, we elected to remove the tripod interfaces on the UKM's receiver. This allowed the use of picatinny rail rear sights, as well as the picatinny rail system mounted on the receiver. We believe that trade was a good one, and one the vast majority of users will never miss.

**This completes the specific UKM instructions on the different features of the UKM vs. the Uk-59.**

**We hope you enjoy the UKM and spread the word about the unique advantages of its design. Most importantly, HAVE FUN AND BE SAFE!**

**And remember to support our Troops, and candidates that support our 2<sup>nd</sup> Amendment!**