

UKM ADJUSTABLE GAS BLOCK MANUAL ADDENDUM:

- PLEASE ENSURE THAT THIS MANUAL ADDENDUM STAYS WITH THE UKM MANUAL & SEMI UK-59 MANUAL THAT YOU RECEIVED WITH YOUR GUN!
- IF YOU SELL OR TRADE THE GUN, PLEASE ENSURE THAT THIS ADDENDUM, AS WELL AS THE ORIGINAL MANUALS GO WITH THE UKM!



As of October 3, 2018, MarColMar Firearms LLC began incorporating an adjustable gas block into its semi-auto UKM design. This change was due to the large variation our customers had experienced in surplus 7.62x54r ammunition, and most notably with commercial grade ammunition. While very few issues had occurred with our users, we wanted to ensure that the UKM is able to function with the widest range of quality ammunition. **WE CONTINUE TO RECOMMEND THAT YOU ONLY USE COMMERCIAL GRADE, SAAMI SPEC AMMUNITION IN THE UKM.**

Some users found that our universal gas block was not allowing enough gas to reliably function the UKM with some types of weaker ammo. Due to this, we redesigned the entire gas block system and incorporated a gas regulator, with three positions or gas settings.

Position 1: This position is marked with the number “1”. It is the smallest gas port opening and will allow the least amount of gas into the operating system.

Position 2: This position is marked with the number “2”. It is the intermediate gas port opening, and will allow a moderate amount of gas into the operating system.

Position 3: This position is marked with the number “3”. It is the largest gas port opening, and will allow the largest amount of gas into the operating system.

Changing the gas setting: On the regulator, you will note a small round circle. The user simply moves this circle in line with the desired setting in order to select that port. We recommend that you use the tool contained in your gunner’s pouch to move the regulator between settings **AS THE BARREL AND GAS BLOCK MAY BE HOT IF YOU HAVE ALREADY BEEN SHOOTING!**



PLEASE NOTE: The regulator (shown in this document in the white for picture clarity), **SHOULD ONLY be rotated with the barrel out of the firearm.** This is to ensure the safety of the user, and also so the regulator cannot be lost. Pictured to the left the barrel has been released and pushed forward so the regulator is accessible.

Follow your UKM / Semi Uk-59 manual’s instructions for removing and replacing the barrel, to allow you to move the gas regulator to your preferred setting.

UNDER NO CIRCUMSTANCES SHOULD YOU EVER CHANGE THE GAS REGULATOR SETTING WHILE STANDING IN FRONT OF THE BARREL, OR WITH A ROUND OF AMMUNITION IN THE BARREL, OR WHILE THE BARREL IS LOCKED INTO THE UKM!!! BEFORE YOU ATTEMPT TO CHANGE THE GAS REGULATOR SETTING, REMOVE THE BELT FROM THE GUN, CHECK THE ACTION FOR ROUNDS, VERIFY THE UKM IS UNLOADED, AND THEN LIFT AND ROTATE THE TOPCOVER TO UNLOCK THE BARREL. MOVE THE BARREL FORWARD WITH THE CARRY HANDLE, UNTIL THE GAS REGULATOR CAN BE ROTATED.

When finished, simply put the barrel back into the UKM (according to your manual's instructions), once in, the gas regulator can no longer be removed from the barrel, rotated, or lost.

Selecting the Proper Gas Setting: During the initial break-in period of your UKM, we recommend that you use gas position '3'. After a few hundred rounds, or whenever you have new ammunition to shoot in your UKM, we suggest you put the UKM on setting '1' and attempt to fire. If the gun operates properly, continue to use setting '1'. However, if the gun does not fully cycle, ejecting the spent cartridge, and loading the next cartridge with the hammer in the firing position locked by the sear - you should unload and clear the UKM, verify no round is in the barrel, and change the gas regulator setting to '2' (according to the instructions outlined above).

Once reloaded, and using the '2' setting, fire to see if the gun fully cycles, ejects the spent cartridge, and fully loads the next round, with the hammer in the firing position locked by the sear. If it does not, you should unload and clear the UKM, verify no round is in the barrel, and change the gas regulator setting to '3' (according to the instructions outlined above). However, it does operate properly, use position '2'.

From our testing, the gas regulator position '3' should operate the UKM with even the weakest 7.62x54r ammunition. Eventually your gun will also break in and may be able to use a lower gas setting. **MAKE SURE THAT FROM TIME-TO-TIME THAT YOU ARE TESTING THE UKM TO ENSURE YOU ARE USING THE LOWEST GAS SETTING THAT RELIABLY OPERATES THE FIREARM. THIS WILL REDUCE THE AMOUNT OF STRESS ON THE FIRING COMPONENTS LIKE THE MAINSPRING, HAMMER, AND SEAR AND WILL GREATLY REDUCE FELT RECOIL FOR YOU THE SHOOTER.**

Removal / Cleaning: Another added benefit of the change is the ease of cleaning. To remove the gas regulator, with the barrel **TOTALLY REMOVED FROM THE GUN**, simply take your tool and rotate the regulator so the indicating mark is pointed down, and pull the regulator forward out of the gas block.

Occasionally you may find that carbon may make it hard to remove the regulator if you have had an extended firing session, or failed to clean the regulator / gas system from the last firing session. In this instance simply rotate the regulator to release, and use a rod from the piston opening to gently push the regulator out.

WE RECOMMEND THAT YOU ALWAYS REMOVE THE REGULATOR AND CLEAN IT AND THE GAS SYSTEM THOROUGHLY EVERY TIME YOU SHOOT – THIS IS IMPERATIVE IF USING CORROSIVE AMMUNITION.

Finally if you are reading this and you own a MarColMar UKM that does not have the adjustable gas block system, MarColMar is providing this upgrade **FREE OF CHARGE** to all owners, simply cover the cost of shipping your UKM to MarColMar Firearms and back. **WE THANK YOU ALL FOR YOUR BUSINESS!**