

# Suggested Lubrication Practices

for TW-25B Lubricant/Protectant on the

## **GAU-2B/A Minigun**

(7.62mm, six-barrel)

### **I. PREPARATION OF THE SURFACE**

Follow the TW-25B Application Instructions.

### **II. APPLICATION**

Refer to the Thickness chart in the TW-25B Application Instructions.

Each GAU-2B/A can be lubricated according to these instructions with approximately 2 oz. of TW-25B, which can be applied easily from tube or can. Refer to chart in Section III.

#### **1. Gun Housing**

##### a. Exterior Surfaces

No TW-25B lubricant required.

##### b. Internal Surfaces

Apply a moderate coating of TW-25B to both sides of the bolt roller cam path.

#### **2. Gun Rotor Assembly**

##### a. Rotor

Apply a very light coating of TW-25B to all surfaces. Add a moderate coating of TW-25B to the trackway surfaces that guide the bolt body, to the bolt head lock support, to the firing pin cocking surface, and to the assembled tracks.

The most efficient applicator for achieving the very light coating on the complex rotor is the EP spray container. (NSN: 9150-01-448-2298)

#### **3. Bolt Assembly**

##### a. All parts

Apply a very light coating of TW-25B.

##### b. Bolt Body Assembly

Add a moderate coating of TW-25B to the trackway surfaces, to both sides of the helical cam, to the firing pin hole, and to the top and bottom surfaces of the assembled roller. Work in the TW-25B between the body stud and the assembled roller.

##### c. Bolt Head Assembly

Add a moderate coating of TW-25B to the bolt head firing pin hole, to the assembled wear pins, and to both sides of the helical tang.

##### d. Firing Pin

No additional TW-25B lubricant required.

##### e. Firing Pin Spring

Add a moderate coating of TW-25B. Do not wipe off any excess lubricant from between the spring coils.

#### **4. Housing Cover and Safety Sector**

##### a. Bolt Roller Cam Path

Apply a moderate coating of TW-25B to the sides of the bolt roller cam path.

#### **5. Gun Rotor Gears**

##### a. Gear Surfaces

Apply a very light coating to all surfaces of the gears.

#### **6. Bearings**

##### a. Forward Bearings

Re-pack bearings with TW-25B using approximately 1/8 to 1/4 ounce.

For the convenience of an approximate measure as well as for directional delivery, use the 0.5 oz. syringe. (NSN: 9150-01-448-2266)

##### b. Rear Bearings

Re-pack bearings with TW-25B.

#### **7. Delinking Feeder Assembly**

##### a. Gear Teeth

Apply a very light coating of TW-25B to gear teeth. Remove excess lubricant from sides of gears.

##### b. Push Rods and Rollers

Apply a moderate coating of TW-25B to all surfaces.

##### c. Rear Housing

Apply a moderate coating of TW-25B to the sides of the cam path.

#### **8. Gun Drive Assembly**

##### a. Gears

Apply a moderate coating of TW-25B to all surfaces.

#### **9. Gun Barrel**

##### a. Barrel

No TW-25B lubricant required.

##### b. Chamber

No TW-25B lubricant required. (Recommended that chamber be left dry.)

#### **WARNING**

Lubrication in gun barrel chamber could cause damage to gun components.

### **III. Referenced TW-25B Packages**

The above instructions make reference to the following TW-25B packages:

	<b>Mil-Comm Part Number</b>	<b>National Stock Number (NSN)</b>
1.5 oz. tube	TW25B-1SP11	9150-01-439-0859
4.0 oz. tube	TW25B-4SP14	9150-01-439-1873
8 oz. can	TW25B-1JSL16	9150-01-439-0858
16.9 fl. oz. (500 ml) EP Spray	TW25B-CA16EP	9150-01-448-2298
0.5 oz. Syringe	TW25B-1SY12	9150-01-448-2266

Mil-Comm offers other packaging of TW-25B. Contact your local Representative or the Defense Logistics Agency.