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Suggested Lubrication Practices

for applying TW25B to the

M-134 Minigun

I. PREPARATION OF THE SURFACE

Follow the "Preparation of Surface" steps on the TW-25B Application Instruction Sheet.

II. APPLICATION

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

Each M-134 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

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

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 to all parts of Bolt Assembly.

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

Ensure a light coating of TW-25B is in place on the bolt face and extractor groove surfaces. 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 Ball Bearings

Apply a heavy coating of TW-25B to all internal surfaces. Wipe off excess lubricant after seals have been assembled.

For the convenience of application, use the 0.5 wt. oz. syringe (NSN: 9150-01-448-2266) or the 1.5 wt. oz. tube (NSN: 9150-01-439-0859).

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 internal cam path.

8. Gun Drive Assembly

a. Gears

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

9. Gun Barrel

WARNING

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

a. Chamber and Bore

No TW-25B lubricant required.

b. Barrel, Exterior Surfaces Only

Apply a light coating of TW-25B lubricant.

10. Clutch Assembly

a. Chamber

Apply a very light coating of TW-25B lubricant to all parts, except for the solenoid assembly (which includes the plunger and spring).

III. Referenced TW-25B Packages

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

	Mil-Comm Part Number	National Stock Number (NSN)
1.5 wt. oz. tube	TW25B-1SP11	9150-01-439-0859
4.0 wt. oz. tube	TW25B-4SP14	9150-01-439-1873
8 wt. oz. can	TW25B-1JSL16	9150-01-439-0858
16.9 fl. oz. (500 ml) EP spray	TW25B-CA16EP	9150-01-448-2298
0.5 wt. 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.