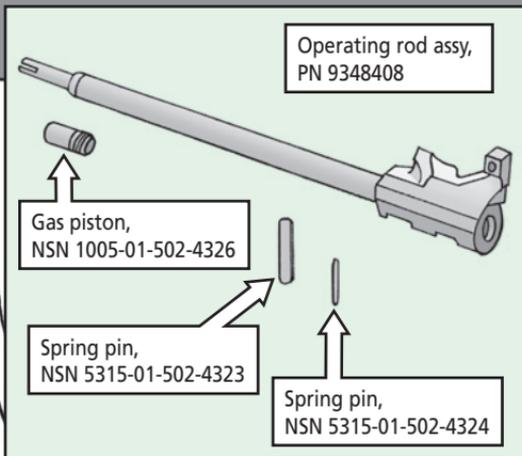
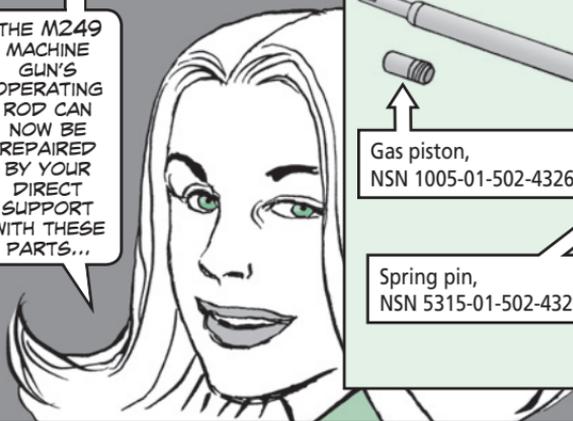


# Repairing Op Rod

**GOOD NEWS,  
ARMORERS.**

THE M249  
MACHINE  
GUN'S  
OPERATING  
ROD CAN  
NOW BE  
REPAIRED  
BY YOUR  
DIRECT  
SUPPORT  
WITH THESE  
PARTS...



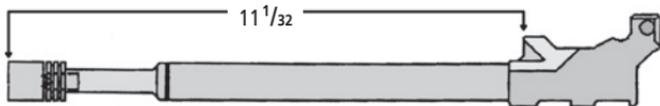
Here are the instructions for installing the op rod parts:

Using a pin punch, drive the inside spring pin out of the operating rod. Do the same with the larger spring pin. Unscrew the piston from the operating rod.

The pins should never be removed unless they're damaged. Once removed, they cannot be reused!

Screw the new piston onto the operating rod. The face of the piston should be  $11\frac{1}{32}$  inch  $\pm$   $\frac{1}{16}$  inch from the front of the operating rod crown point. Align the spring pin holes in the operating rod with the pin holes in the piston.

$11\frac{1}{32}$  inches  
 $\pm$   
 $\frac{1}{16}$  inch



From the recess side of the piston hole, use a pin punch to drive the larger spring pin into the hole. Then again from the recess side drive the smaller spring pin into the center of the first spring pin.

Make sure the spring pin slots are located 180 degrees apart from each other.

This procedure will be added to TM 9-1005-201-23&P.

