ROUTINE

MWO effective date is 14 November 2008 and completion date is 14 November 2013.

MWO 9-1005-313-23-1

MODIFICATION WORK ORDER

MODIFICATION OF MACHINE GUN, 7.62MM, M240H (NSN 1005-01-518-2410)

HEADQUARTERS, DEPARTMENT OF THE ARMY, WASHINGTON, D.C.

14 November 2008

REPORTING ERRORS AND RECOMMENDING IMPROVEMENTS

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SUPERSEDURE N0TICE: This MWO supersedes MWO 9-1005-313-23-1, dated 31 July 2008

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1. **PURPOSE.** This MWO prescribes procedures to modify an M240H Machine Gun to improve both the mounting of the bipod to the weapon and functionality of the forward folding bipod.

2. **PRIORITY.** This modification is classified **ROUTINE.**

3. **END ITEM(S) OR SYSTEM(S) TO BE MODIFIED.** See Table 1.

Table 1. End Item(s) or System(s) to be Modified

Nomenclature	NSN	Part No.	CAGEC	Serial Number
M240H Machine Gun	1005-01-518-2410	13005478	19200	N/A

4. **MODULES (COMPONENTS, ASSEMBLIES, SUBASSEMBLIES, BOARDS AND CARDS) TO BE MODIFIED.** The following items, whether installed or in PLL/ASL or depot stock, shall be modified. See Table 2

Table 2. Modified Module

Nomenclature	NSN	CAGEC	Part Number	Serial Number
Bipod Assembly	1005-01-522-0759	19200	13001481	N/A

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5. **PARTS TO BE MODIFIED.** Not Applicable.

6. **APPLICATION.**

   a. Time Compliance Schedule: MWO effective date is 8 December 2008 and completion date is 8 December 2013.

   b. Lowest Level of Maintenance Authorized to Apply this MWO: Field Level.

   c. Work Force and Man-Hour Requirements for Application of the MWO is to a Single Unit, End Item, or System:

Work Skills Force	Man-Hours
MOS 45B10	0.5 hours

7. **Technical Publications Affected/Changed.** See Table 3.

Table 3. Technical Publications Affected/Changed

Publication Number	Date
TM 9-1005-313-23&P	14 December 2007
DMWR 9-1005-313	30 April 2007

8. MWO KIT(S)/PART(S) AND THEIR DISPOSITION:

a. Kit/Parts needed to apply MWO are listed in Table 4.

Table 4. MWO Kit(s)/Part(s) Needed to Apply the MWO

Nomenclature	NSN	Part No.	Qty
Modification Kit consisting of:	1005-01-563-8417	13019280	
Clamp	1005-01-563-6717	13013481	1
Shoulder Screw	5305-01-563-5472	13013482	2
Nut, Self-Locking, Hexagon	5310-00-245-8825	MS16228-4C	2
Pin, Spring-Tubular, Coiled, Heavy Duty	5315-00-690-0544	MS39086-93	2
Pin, Spring Coiled	5315-01-563-5470	ASME B1883030014HCP	1
Installation Procedure Sheets		N/A	1

b. Bulk and Expendable Material. See Table 5.

Table 5. Bulk and Expendable Material.

Nomenclature	NSN	CAGEC	Part Number
Loctite	8030-01-499-3589	05972	246

c. Parts Disposition. Dispose of excess parts in accordance with local standard operating procedures. Modification team will retain all replaced serviceable parts.

9. SPECIAL TOOLS; TOOL KITS; JIGS; TEST, MEASUREMENT AND DIAGNOSTIC EQUIPMENT (TMDE); AND FIXTURES REQUIRED. See Table 6.

Table 6. Special Tools

Nomenclature	NSN	Part Number	CAGEC
Punch, Roll Pin, 3/32” (.094”) dia.	Commercially Available	---	---
Punch, Center, 3/8” dia.	5120-01-430-8484	25647	08292
Punch, Drive Pin, 1/8” (.125”) dia.	5120-01-430-8282	25625	08292
Hammer, 8 ounce	5120-01-434-9537	69-404	98292
Wrench Set, Socket	5120-00-081-2305	B107.1	05047
Wrench, Allen, 3/16”	5120-01-335-2118	57022	08292
Wrench, Allen, 5/32”	Commercially Available	---	---
Wrench, Allen, 7/32”	Commercially Available	---	---

10. MODIFICATION PROCEDURES.

a. **Remove Barrel Assembly (Figure 1).**

WARNING
Wear eye protection to prevent injuries to personnel throughout all procedures in this MWO.

(1) Clear your M240H machine gun.

(2) Press barrel locking latch and hold.

(3) Turn barrel release/carrying handle to upright position and lift out the barrel assembly.

(4) Remove spade grips, drive spring and trigger group from the weapon.

(5) Manually cycle the bolt and operating rod, checking for any sign of binding in the rearmost portion of its stroke. If binding is detected, code out the weapon. Ensure gas tube and piston are free of carbon build-up. Remove the bolt and operating rod if no binding is detected.

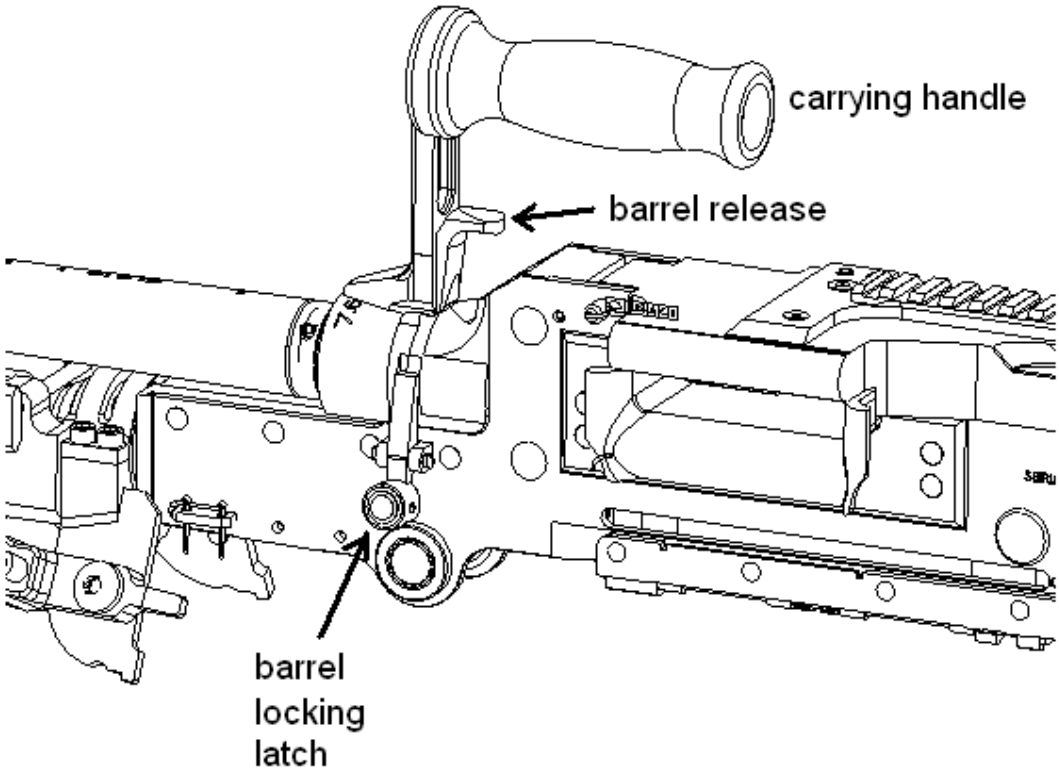


Figure 1.

b. **Remove Bipod Assembly (Figure 2)**.

(1) Remove four screws using a 5/32" Allen wrench.

(2) Identify which side of the roll pin is damaged more severely (if at all) and place the weapon so this side of the pin is facing down.

(3) Using 3/32 “(.094”) punch and 8 oz. hammer, tap out roll pin.

(4) Remove and discard old clamp.

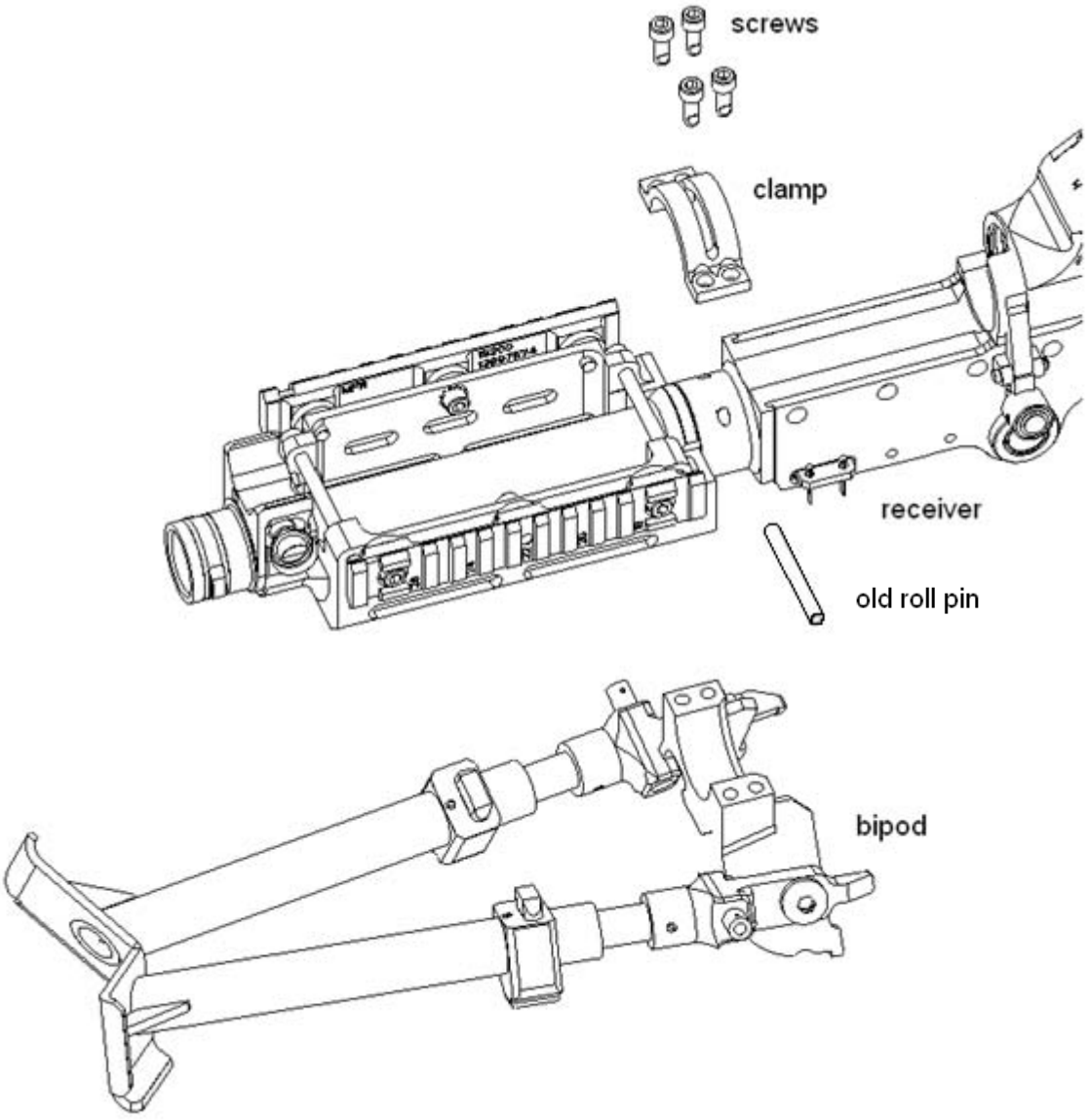


Figure 2.

c. Replace Roll Pin in Gas Cylinder (Figure 3).

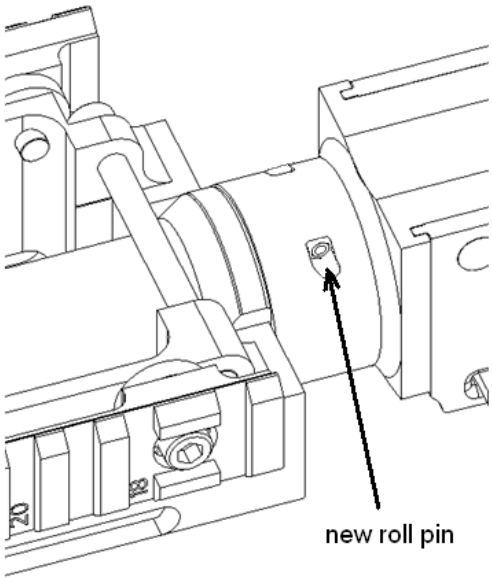
(1) Ensure there are no foreign objects inside of through hole.

(2) Visually examine the hole and the gas cylinder for any signs of gas cylinder misalignment evidenced by visible constriction in the hole. Do not install a new pin if misalignment is evident. If the gas cylinder is misaligned, code out the weapon.

(3) Using 8oz hammer and 1/8” (.125”) roll pin punch, tap in new M3x14 roll pin (shortest pin included in MWO kit). Using 8oz hammer and 3/32" punch, center and tap in pin (be sure that neither end of the pin protrudes out of the receiver).

Note

1/8" punch is too large to fit inside the hole.



New Short Roll Pin Installation

Figure 3.

d. **Remove Shoulder Screws**. Using 7/32" Allen wrench, remove and discard two shoulder screws from bipod legs.

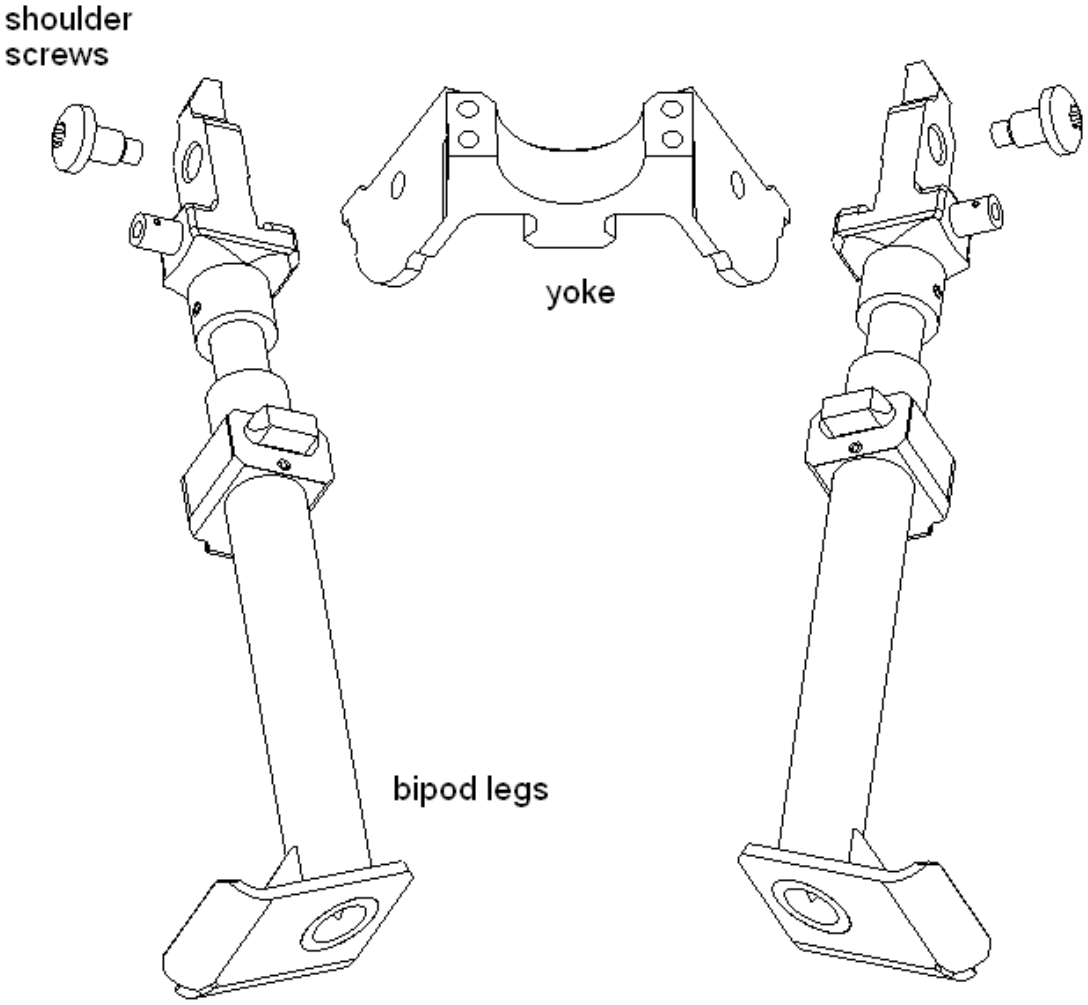


Figure 4.

e. Replace Roll Pins (Figure 5).

(1) Using 1/8” (.125”) punch and 8 oz. hammer, tap out roll pins from bipod legs. Discard roll pins.

NOTE

Ensure the holes are not misaligned. If misaligned, use 1/8” punch to realign holes.

(2) Using 8 oz. hammer, install two new roll pins (MS39086-93, part of the MWO kit), one in each bipod leg.

(3) Using 3/8” diameter center punch, stake both sides of the bipod legs to the roll pin to help prevent the pin from vibrating loose.

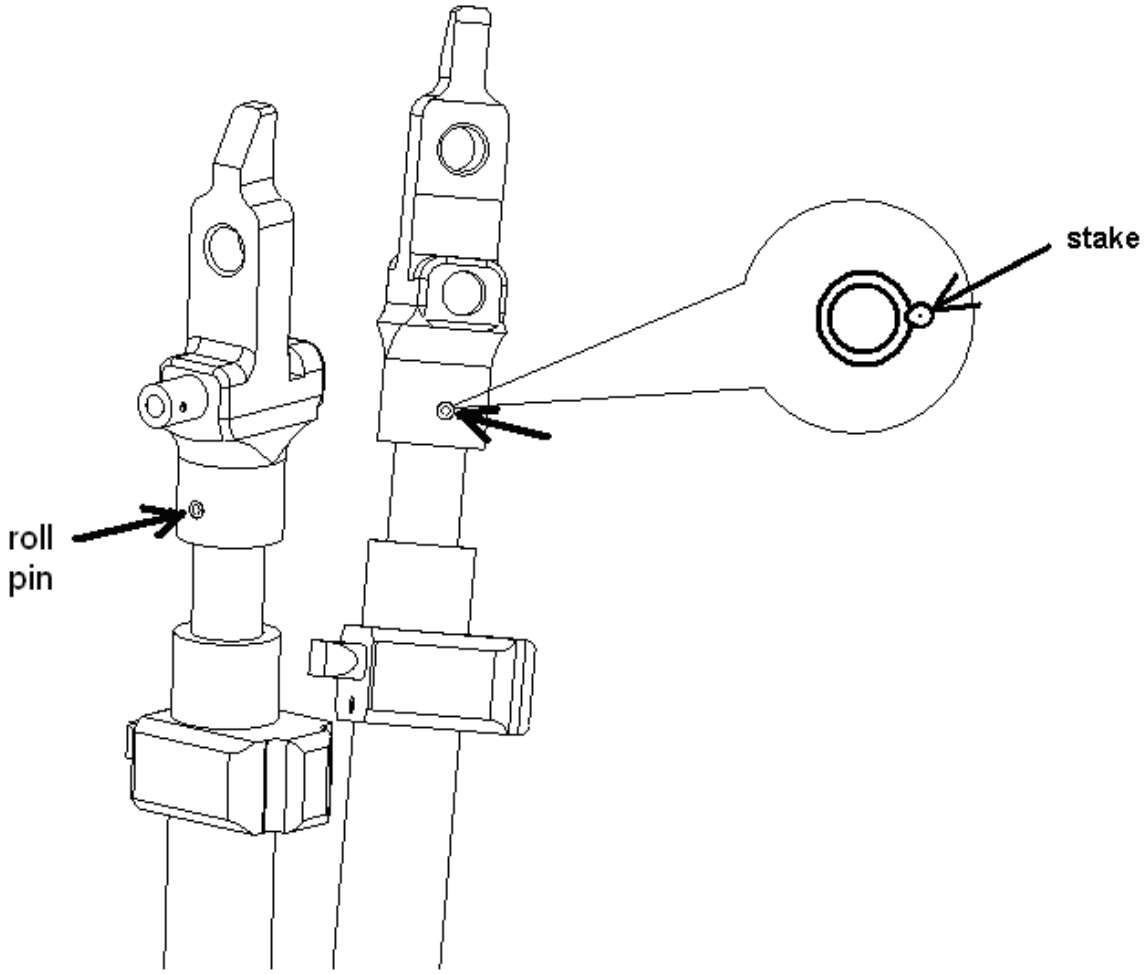


Figure 5.

f. Assemble Bipod (Figure 6).

NOTE
Ensure threads of shoulder screws are free of oil.

(1) Apply one drop of Loctite 246 on threads of new shoulder screws and nylock nuts (shoulder screws and nylock nuts supplied in MWO kit).

(2) As pictured below, align one bipod leg with yoke. Using 3/16" Allen wrench, securely install new shoulder screw and securely fasten with nylock nut using a 1/2" socket wrench. Ensure that the left and right legs are correctly aligned with the yoke and are not reversed.

NOTE
Ensure the shoulder screw does not backup when tightening nylock nut.

(3) Repeat previous step for the remaining bipod leg.

(4) After installation, each bipod leg shall be able to extend, retract, and lock into both positions located on the yoke.

(5) Ensure setscrews in lower bipod legs are flush with surface. If not, requisition new setscrew(s), NSN 5305-01-524-2975.

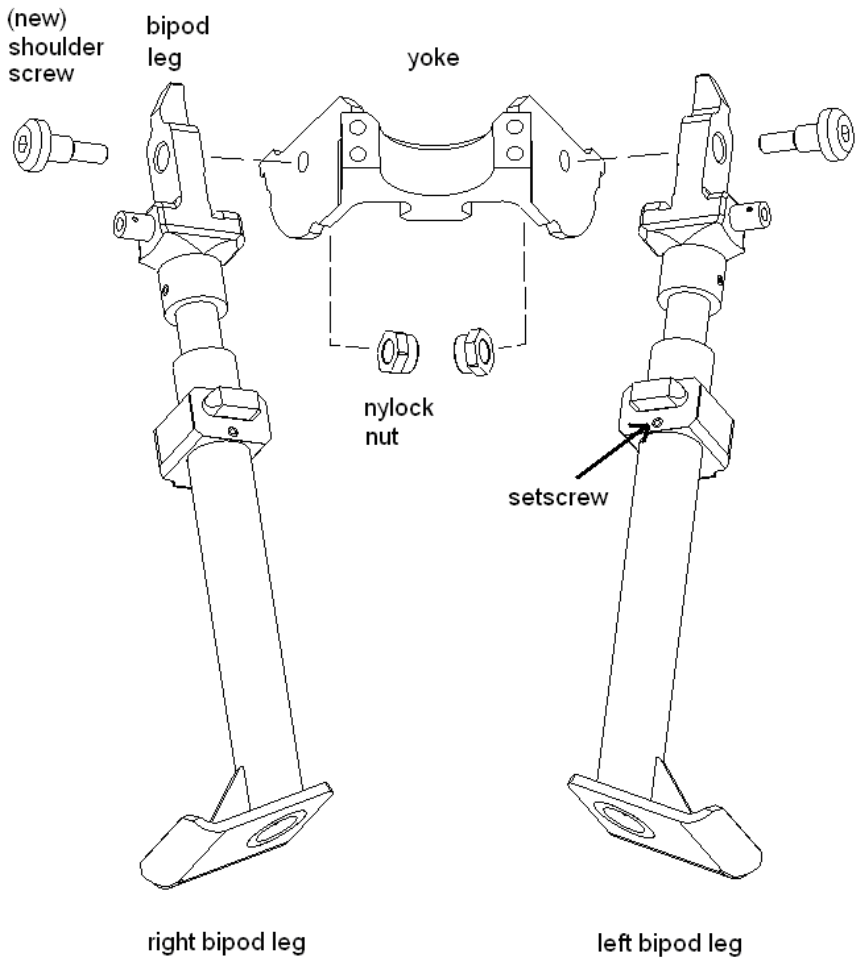


Figure 6.

g. Install Bipod Assembly to Receiver (Figure 7).

(1) Position bipod yoke appropriately under gas cylinder making sure the bipod legs are in the forward folding position.

(2) Align new clamp with holes in yoke. Ensure clamp lugs point toward receiver as shown below.

(3) Apply one drop of Loctite 246 on threads of screws. Using a 5/32" Allen wrench, install four screws into new clamp, securing it to the yoke.

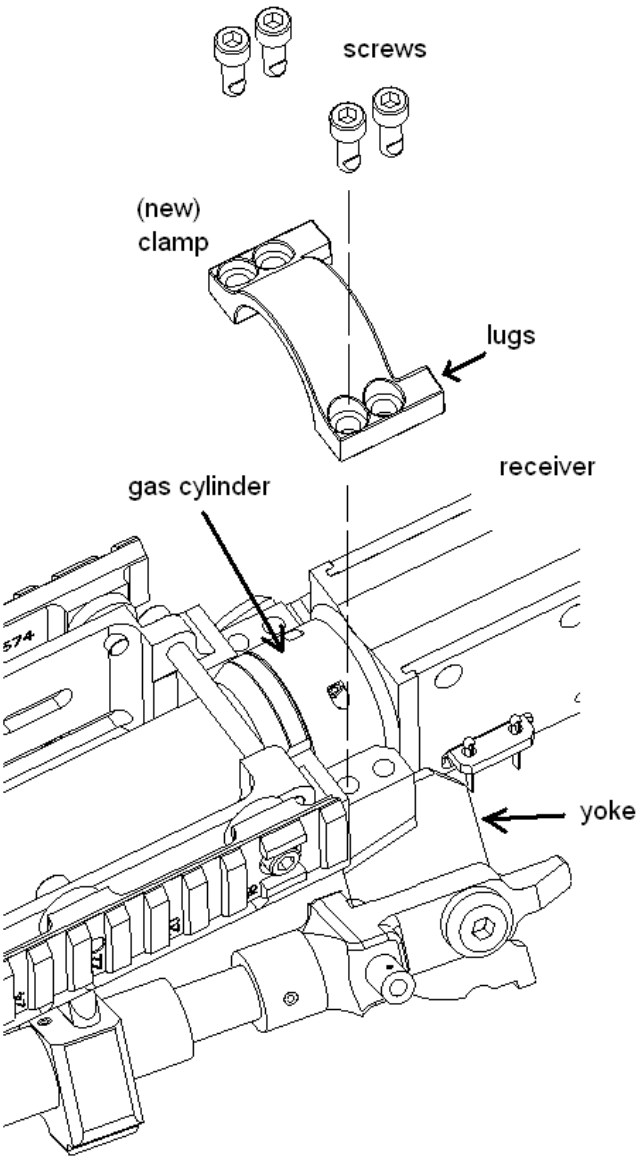


Figure 7.

h. Reassembly (Figure 8).

(1) Insert bolt and operating rod.

(2) Manually cycle bolt and operating rod, checking for any sign of binding in the rearmost portion of its stroke. If binding is detected, code out the weapon.

(3) Install trigger group, drive spring, and spade grips.

(4) Insert barrel assembly fully into socket and push barrel release/carrying handle clockwise as far as it will go.

(5) Push barrel release and rotate carrying handle and return to upright position.

(6) Push carrying handle clockwise while counting the clicks. (Fewer than 2 clicks and more than 7 clicks indicate defective parts.)

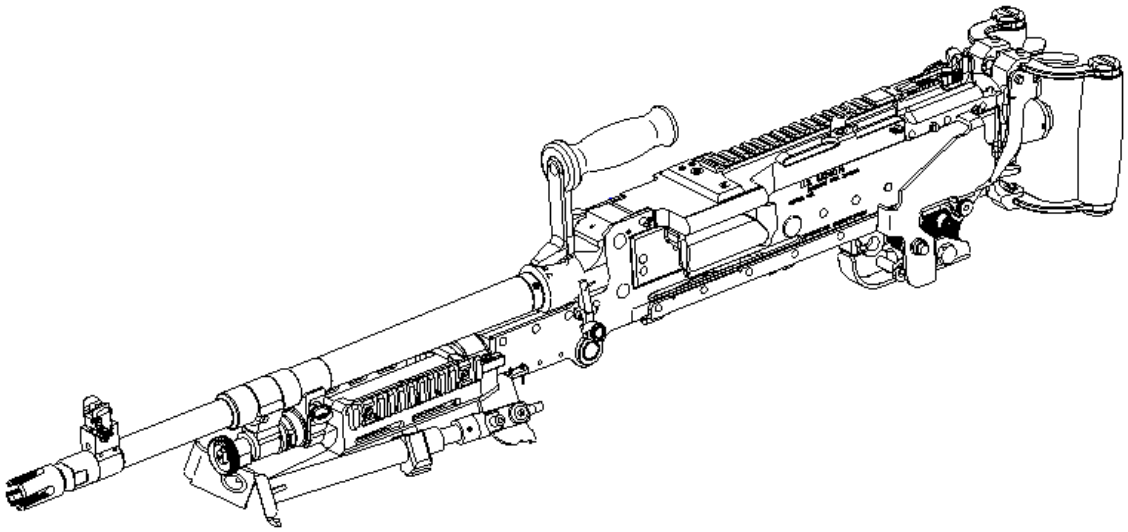


Figure 8

11. **CALIBRATION REQUIREMENTS**. Not applicable.

12. **WEIGHT AND BALANCE DATA.** Weight and balance are not significantly affected.

13. **QUALITY ASSURANCE REQUIREMENTS.**

    a. General quality assurance inspection criteria shall be in accordance with TM 750-245-4.

    b. Have modification installation inspected by technical inspector

    c. Verify that modification is properly recorded (refer to Para 14).

14. **RECORDING AND REPORTING OF THE MODIFICATION**.

    a. Records and Reports. Reporting will be accomplished by electronic means. MWO application information may be input directly into the Modification Management Information system (MMIS) over the internet. Entry into the MMIS system is password protected. New users may register online at https://www.mmis.army.mil. Passwords are normally approved and issued within 48 hours.

       (1) Submission will be comprised of the nine data elements listed in Table 7. Elements 1, 2 and 6 are given for this MWO.

       (2) The person reporting the MWO data will acquire the remaining elements (3, 4, 5, 7, 8 and 9) and input all nine elements into the MMIS.

Table 7. Data Elements.

Data Element	Input Data
1. Materiel Change Number (MCN)	1-08-05-0002
2. MWO Number	MWO 9-1005-313-23-1
3. Unit Identification Code (UIC)	
4. Unit Name	
5. Unit Location	
6. NSN of End Item	1005-01-518-2410
7. Date of Application	
8. Man-Hours Required for Application	
9. Serial Numbers	

    b. Marking Equipment. Not applicable.

    c. Identification Data. Not applicable.

15. **MATERIEL CHANGE NUMBER (MCN).** This MWO is authorized by Materiel Change Number 1-08-05-0002.

16. **MODIFICATION IDENTIFICATION.** Visual verification of application can be made as shown in illustrations.

By Order of the Secretary of the Army:

GEORGE W. CASEY, JR.
General, United States Army
Chief of Staff

Official:

JOYCE E. MORROW
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Secretary of the Army
0831106

Distribution:

To be distributed in accordance with the initial distribution number (IDN) 990003, requirements for MWO 9-1005-313-23-1.

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