

## INSTRUCTIONS

This is a Beretta 391 factory gas system.



Just follow these steps and you will be fine.

Step #1 – Using a small pipe wrench or Vise Grip style pliers, loosen the spring retainer.



Step #2 – The retainer has a lot of threads. You will be able to unscrew it by hand until it comes off. The spring will have no tension when the retainer free. The center piece will slide out of the gas cup from the open side. Note the position of the deflector section. The solid area faces the barrel gas ports.



This is what it will look like fully disassembled



Step #3 – Clean all carbon buildup inside the gas cup and its outer seal surfaces. Clean the base of the seal plate too. The seal plate has a flat side (base which fits against the gas cup when installed) and a cupped side (the top side when installed)

Gas cup seal surface cleaned



Outer surfaces of gas cup cleaned



Step #4 – Slide cleaned gas cup seal onto shaft – flat surface down.



Step #5 – Slide SRM bushing over the shaft, so it seats against the cupped side of the seal and screw the retainer onto the shaft.



Hand tighten the retainer against the bushing. Try to keep the bushing centered in the seal plate as best as possible. It is not critical but looks nicer when you keep it centered.



Step #6 – Tighten retainer with whatever tool you used to loosen it and repeat for the lock ring



The sealing job is now complete.