

JP Recoil Eliminator Installation Instructions: 1/2 x 28 TPI and 9/16 x 28 TPI models

Parts Included:

- Recoil eliminator
- Crush washer (JPRE-2 only)
- Peel washer (JPRE-2S only)

CAUTION: REMOVE MAGAZINE AND VISUALLY CHECK CHAMBER TO MAKE SURE THAT FIREARM IS UNLOADED.

Before beginning installation, it is important to consider the caliber of the firearm on which you intend to install this product. The exit hole on this brake is .280 and will accommodate bores up to .244 (6mm). If your rifle is of a larger caliber, the exit hole must be enlarged to accommodate it. The final exit hole must be a minimum of .040 over the bore diameter. Also, the wall dividing the dual chambers of the brake is .470 and should not have to be altered. The maximum caliber that the 1/2 x 28 TPI version should be used for is .358.

1/2 x 28 TPI Pre-Threaded Barrels: For rifles such as AR-15s, this brake can be installed by simply removing the existing flash suppressor and installing the supplied crush washer or peel washer and the muzzle brake. It may be necessary to heat the flash suppressor to remove it if it doesn't come off easily. Prior to installation, degrease the threads on the barrel and on the inside of the brake. Included with the black 1/2 x 28 TPI recoil eliminators is a crush washer made of soft aluminum that will compress sufficiently when tightened to allow for proper timing of the muzzle break. Included with the stainless 1/2x28 TPI recoil eliminators is a peel washer that consists of many thin layers (.002 thick) laminated together. The peel washer allows you to achieve a thickness that will enable you to time the brake up level to the rifle. It just takes a little bit of trial and error to get the right thickness on the washer. Make sure to apply a liberal amount of Loctite to the threads for the final installation.

Custom Threaded Barrels (1/2 x 28 TPI or 9/16 x 28 TPI): Begin by cutting off about .625 of threads. Best efficiency is achieved by allowing the muzzle to be recessed in the barrel nut about a quarter of an inch. This has the effect of forming a cup that directs the expanding gas forward into the baffles. If you are installing the brake on a gun that you are having threaded, have the gunsmith fit the brake to the barrel by removing material from the back of the barrel nut on the brake or the shoulder of the brake so that it just tightens up in the level position, thereby eliminating the need for a jam nut or peel washer and resulting in the most cosmetically appealing installation. If your barrel is significantly smaller than .750 OD, we have available a tapered nut version that will provide a better cosmetic transition from the barrel to the brake. If you need to make an exchange for the tapered nut version, please call us. For the straight nut version, you may contour the nut into your barrel at the time of installation for the best appearance.

After installation, it is imperative that alignment of the exit hole and bore be checked visually and with a cleaning rod inserted through brake and barrel to confirm that bullets will not impact the brake. Not all bores are centered in the barrel, and not all threaded ends are concentric with the bore. However, the exit hole on this brake is sufficiently oversized to accommodate most tolerance stack-ups without sacrificing any performance.

This device is considered a "compensator" by BATF. It is not a "flash suppressor" and is not designed or intended to be so.

Caution!

Muzzle brakes by their very nature redirect high-pressure gasses and can blow dirt or other materials present in the shooting area back towards the shooters or bystanders, especially at indoor ranges with enclosed shooting booths.