

JP Small-Frame Compensator Installation **JPTRE-324 / 324S (5/8" - 24 TPI)**

Parts Included:

- JP compensator
- Crush washer (JPTRE-324 and JPTRE-324S only)

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

On 5/8"-24 Pre-threaded Barrels (such as AR-10, BAR-10, LR300, SR25), this brake can be installed by simply removing the existing flash suppressor and installing the supplied crush washer (if included) and muzzle brake. Degrease the threads on the barrel and on the inside of the brake prior to installation. Apply Loctite 242 to the threads for the final installation.

Custom Threaded Barrels: Cut 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" which directs the expanding gas forward into the baffles. If you are installing the brake on a gun which 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 barrel so the brake just tightens up in the level position, thereby eliminating the need for a jam nut or crush washer, resulting in the most cosmetically appealing installation.

After installation, it is imperative that alignment of 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.

Important: The exit hole on this brake may be either .281 or .350. Our standard .281 final exit hole will accommodate bore diameters up to .243 (6mm). If your rifle is of a larger caliber, the exit hole must be enlarged to accommodate it. The final exit hole must be .040 minimum over bore diameter. For example, if you are installing this brake on a 7.62/.308 rifle, you should bore the final exit hole to .350 minimum. It is essential to measure the exit hole and verify that it will

accommodate the bore diameter of your rifle. Failure to do so will cause damage to the brake and possible secondary projectile material directed off to the sides of the muzzle. Check your exit hole!

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. ***Always wear eye protection and ear protection when shooting or observing.***

This device is considered a “compensator” by BATF, not a “flash suppressor” and is not designed or intended to be a flash suppressor.

THANKS FOR YOUR BUSINESS!