

BLACKOUT™ MUZZLE BRAKE INSTALLATION INSTRUCTIONS

The AAC sound and flash suppressors can couple to this proprietary muzzle brake that attaches to the threads on the muzzle of the host rifle. The following are instructions for the installation of the BLACKOUT™ muzzle brake.

1. The AAC muzzle brake attaches to the existing threads of the host firearm. To maximize recoil reduction and minimize the disturbance of sand, dirt, and vegetation when firing prone without the suppressor installed, the ports of the muzzle brake must be oriented at 9 and 3 o'clock. The ideal method of achieving this orientation is to have a depot level armorer machine a stainless steel washer of the proper thickness that allows the muzzle brake to thread on so that the ports align at 9 and 3 o'clock. The following instructions will allow armorer's in the field to achieve this orientation using the provided shim set.
2. Parts Required:
 - (1) Muzzle Brake (AAC Supplied)
 - (1) Appropriately-Sized Open End Wrench
 - (1) Wrench, Torque
 - (1) Appropriately-Sized Adaptor for Torque Wrench
 - (1) Protective Vice Jaws
 - (1) Solvent
 - (1) Rocksett™ Sealant (AAC Supplied)
 - (1) Six Piece Shim Kit (AAC Supplied)
3. Remove the factory muzzle brake, flash hider, or thread protector from the host rifle following the procedure set forth in the host rifle operator manual.
4. Clean the barrel shoulder and exposed barrel threads thoroughly with solvent. Rust, grease, oil, and other contaminants **MUST** be removed.

5. Using solvent, de-grease and dry the threads on the inside of the AAC muzzle brake.
6. Thread the AAC muzzle brake onto the barrel threads of the rifle with 20 to 30 ft.-lbs of torque. If the muzzle brake is not aligned so that the wrench flats are at 12 and 6 o'clock, measure the amount of rotation required to achieve alignment. Install a shim or combination of shims that will allow the muzzle brake to thread onto the barrel in this orientation at the specified torque.
7. When the optimum combination of shims has been installed on the barrel of the host rifle and the muzzle brake has been test fit to the threads, remove the muzzle brake and once again de-grease the threads on the barrel and the mating threads on the muzzle brake.
8. Install the shim or shims with the thinnest shim placed on the barrel first.
9. Apply and distribute one or two drops of ROCKSETT™ to the muzzle threads of the weapon and the threads inside the muzzle brake.
10. Quickly screw the AAC muzzle brake onto the muzzle threads and up against the washer or shim stack.
11. Set the torque wrench for a value between 20 and 30 ft.-lbs. Position the torque wrench and appropriately-sized adaptor as far to the rear of the wrench flats as possible and torque the AAC muzzle brake onto the host weapon's barrel.
12. Wipe off any excess ROCKSETT™ sealant. Allow sealant to cure for 24 hours for best results.
13. Enjoy!

