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MADE
IN THE USA



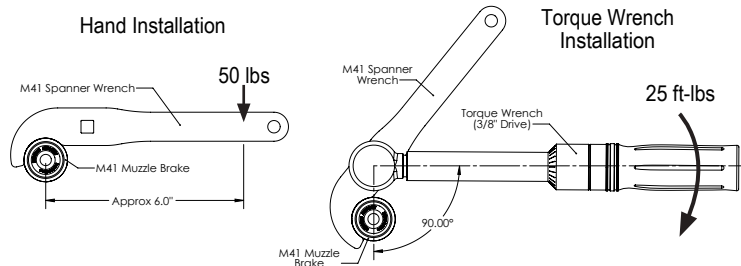
M41 Severe-Duty™ Muzzle Brake Installation Guide

IMPORTANT: READ INSTRUCTIONS COMPLETELY BEFORE INSTALLATION.

WARNING: MAKE SURE FIREARM IS UNLOADED BEFORE INSTALLATION. VISUALLY INSPECT CHAMBER, MAGAZINE, AND FIRING MECHANISM TO BE CERTAIN NO AMMUNITION IS IN THE FIREARM.

INSTALLATION: The M41 Muzzle Brake is threaded for a 5/8-24 RH thread. Be sure to properly clean threads on the barrel and on the inside of muzzle brake prior to installation. This brake has symmetrically positioned ports and therefore does not require any special timing or indexing to function correctly (no indexing washers or shims required). A small amount of high temperature thread locking compound (i.e. Loctite® 272) should be applied for final installation. The M41 Brake should be tightened on to barrel with a minimum of 25 ft-lbs of torque. This brake features five 3/16" holes, intended for tightening via M41 Spanner Wrench (A70-001) available at precisionarmament.com. This wrench is designed to work alone or with the use of a 3/8" drive torque wrench (see diagram on back). NOTE: this wrench is made from a steel that is slightly softer than the brake to avoid damage to 3/16" holes, as a result slight deformation of wrench pin may occur and is normal. Do not exceed 70 ft-lbs of torque on the M41 wrench. To avoid marring finish on brake it is recommended to fold a sheet of paper (~0.003" thick) 2-3 times and place between wrench and brake

surface when tightening or removing. Alternatively, the M41 brake can be tightened using a strap-type wrench, pipe wrench, or channel-lock pliers if a durable/soft medium (recommend using a strip of leather greater than 1/8" thick) is used between the brake and wrench jaws for protection. CAUTION: Use of a standard adjustable pin-type spanner wrench may cause deformation to 3/16" holes due to improper fit.



IMPORTANT: After installation is completed, it is imperative to check the alignment of the muzzle brake bore with the barrel bore to verify appropriate bullet clearance. This should be checked visually and with a tight fitting bore alignment rod inserted through barrel and muzzle brake to verify a bullet will not impact.

IMPORTANT: NEVER INSTALL THIS MUZZLE DEVICE ON A FIREARM THAT HAS A LARGER CALIBER DIAMETER THAN THE MUZZLE DEVICE IS DESIGNED FOR. THIS CAN ONLY BE DONE IF THE BORE IS ENLARGED TO ACCOMMODATE THE LARGER CALIBER. THIS SHOULD ONLY BE PERFORMED BY A COMPETENT GUNSMITH. RECOMMENDED MINIMUM BORE CLEARANCE IS 0.030" OVER BULLET DIAMETER.

CAUTION: This device operates by redirecting high-pressure gases at the muzzle. As a result, debris can be propelled back towards the shooter or nearby observers. ALWAYS WEAR EYE AND EAR PROTECTION WHEN SHOOTING OR OBSERVING.

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