JP ENTERPRISES

RECOIL ELIMINATOR | BULL BARREL

- **JPRE-424B/S** (5/8-24 TPI)
- **JPRE-428B/S** (5/8-28 TPI)

CAUTION: REMOVE THE MAGAZINE AND VISUALLY CHECK THE CHAMBER TO ENSURE THAT YOUR FIREARM IS UNLOADED.

The Bull Barrel version of the Recoil Eliminator is available in 5/8-24 and 5/8-28 TPI for various applications. Make sure you know the TPI of your particular unit before threading your barrel to match.

Before beginning installation, it is important to consider the caliber of the firearm on which you intend to install the Recoil Eliminator. The exit hole for 5/8-24 models (JPRE-424B/S) is .350 and will accommodate bores up to .308. The exit hole for 5/8-28 models (JPRE-428B/S) is .281 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. The wall dividing the dual chambers of the brake is .470 and should not have to be altered unless the bore exceeds .430. The maximum caliber for any of these models should be .416.

PRE-THREADED BARRELS

1. Remove any existing muzzle treatment.
2. Degrease the threads of the barrel and of the muzzle brake's interior.
3. Install a suitable crush washer, peel washer or jam nut beneath the muzzle brake.

   JP Double Crush Washers and Jam Nuts are available to match either black or stainless brakes. Instructions for installing any of these devices are available on our website: *www.jprifles.com.*
4. Apply thread locker liberally to the barrel before final installation.
5. Install Recoil Eliminator and time accordingly before thread locker cures. Allow adequate setup time for the thread locker before live fire.

CUSTOM-THREADED BARRELS

To custom-thread for this brake, begin by removing between .600 and .700 of threads from the barrel, rebated in front of the shoulder to allow the brake to butt up with no gap.

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Best efficiency is achieved by allowing the muzzle to be recessed into the barrel nut by 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 having this barrel threaded by a gunsmith, have him fit the brake to the barrel by removing material from the back of the barrel nut or the shoulder of the brake so that it just tightens up in the level position. This eliminates the need for a jam nut or washer, resulting in the most cosmetically appealing installation.

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.

Always wear eye and ear protection when shooting or observing.

THANKS FOR YOUR BUSINESS!