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**MADE USA**  
IN THE



## M11 & M11-SPR 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.

Model	Barrel Thread	Accu-Washer System
M11-SPR	1/2-28 TPI	AWS-500 (1/2-28)
M11	5/8-24 TPI	AWS-625 (5/8-24)

**INSTALLATION:** Be sure to properly clean threads on barrel and on the inside of muzzle brake prior to installation. It is recommended to apply a high temperature thread locking compound (i.e. Loctite® 272 or Flexbar® Rocksett) for final installation. This is not required but will provide maximum thread holding strength. The M11 muzzle brake should be tightened on to the barrel with a minimum of 20 ft-lbs of torque. Tighten via wrench flats on top and bottom of muzzle brake. To avoid marring finish it is recommended to fold a sheet of paper (~0.003" thick) 2-3 times and place between wrench and flats on brake when tightening or removing.

**TIMING:** The M11 Severe-Duty™ Muzzle Brake has a side venting baffle design and requires proper 'timing' or 'indexing' on the barrel to function correctly. When properly installed the three large side venting chambers should be at the 3 & 9 o'clock position, and the two top vents (aid in muzzle climb reduction) should be at the 12 o'clock position. Several suitable options are available for properly timing the M11 muzzle brake. We highly recommend using the Precision Armament Accu-Washer™ Muzzle Device Alignment System; this method guarantees the most accurate alignment with the bore providing the highest level of safety and performance. Please refer to chart on front to select the correct size Accu-Washer™ for your muzzle brake. Alternatively, a peel washer or other multi-shim alignment system can be used and will provide suitable bullet clearance. It is not recommended to use a crush washer for alignment as this can result in an unacceptable level of misalignment. If custom threading the barrel for installation, the position of the thread shoulder can be adjusted so the brake torques to the proper position.

**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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