

### JP TACTICAL COMPENSATOR INSTALLATION

PATENTED

**JPTRE-2 / 2S** (1/2 x 28 pre-ban), **JPTRE-3 / 3S** (9/16 x 28 post-ban),  
**JPTRE-5.12B / 5.12S** (1/2 x 28 .925 OD at threaded end)

#### Parts Included:

- Tactical compensator
- Crush washer (TRE-2 only)
- Peel washer (TRE-2S only)

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

**ON 1/2 x 28 PRE-THREADED BARRELS** (such as AR-15), this brake can be installed by simply removing the existing flash suppressor and installing the supplied peel washer and muzzle brake. It may be necessary to heat the flash suppressor to remove if it doesn't easily come off. Degrease the threads on the barrel and on the inside of the brake prior to installation. The matte 1/2x28 TPI recoil eliminators come packaged with a crush washer made of soft aluminum that will compress sufficiently when tightened to allow for proper timing of the muzzle break. Install the crush washer so that the small protruded portion of the washer is contacting the flange surface of the barrel. Now, tighten the break against the crush washer at least half a turn until the break is properly aligned on the barrel. Included with the stainless 1/2x28 TPI recoil eliminators is a peel washer that consists of many thin layers (.002 thick) laminated together. The peel washer allows you to achieve a thickness that will enable you to time the brake up level to the rifle. It just takes a little bit of trial and error to get the right thickness on the washer. Make sure to apply a liberal amount of Loctite 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 so the brake just tightens up in the level position, thereby eliminating the need for a jam nut or peel washer, resulting in the most cosmetically appealing installation. If your barrel is significantly smaller than .750 OD, we have available a "tapered" nut version which will provide a better cosmetic transition from the barrel to the brake. If you have the "tapered" version, shorten the tapered portion of the nut until it matches the barrel diameter, then go a little further if necessary to level the brake. If you have the straight nut version, you may contour the nut into your barrel at the time of installation for the best appearance.

NOTE: The JPTRE-3 is threaded 9/16x28 and can be used for a post ban legal installation on a semi auto rifle.

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. However, exit hole on this brake is sufficiently oversized to accommodate most tolerance stack ups within reason without sacrificing any performance.



**RIGHT OR LEFT HAND BIASING:** The Tactical comps are shipped in the "neutral" configuration. However, by drilling a port on the right or left hand side of the flat area just ahead of the muzzle, the comp can be given a thrust bias into the support hand which makes the overall impulse of the rifle more linear for off hand, kneeling or any position shooting other than prone off bi-pod. For example, if you are right handed, drill a 3/16" hole on the right side in the flat area just ahead of the muzzle, behind the first expansion chamber.

**IMPORTANT:** THE EXIT HOLE ON THIS BRAKE IS .280 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 .040 MINIMUM OVER BORE DIAMETER. IF YOU HAVE ORDERED THE DUAL CHAMBER VERSION, THE INTERMEDIATE EXIT HOLE IS .470 AND SHOULD NOT HAVE TO BE ALTERED. THE MAX CALIBER THAT THE 1/2 X 28 VERSION SHOULD BE USED FOR IS .358.

**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.**

**NOTE:** This device is considered a "compensator" by BATF, not a "flash suppressor" and is not designed or intended to be a "flash suppressor."

Visit us at [www.jp Rifles.com](http://www.jp Rifles.com)

Rev. 07.08

P.O. Box 378, Hugo, MN 55038 • VOICE: 651-426-9196 • FAX: 651-426-2472