TRENTECH

VIPER

Muzzle brake Fitting Instructions

1: Remove magazine and clear the firearm of any live ammunition. Ensure bolt/slide is open or removed and the chamber is clear. Making the firearm safe should always be the first step.

2: Loosen and remove the existing thread protector cap or previous muzzle brake/flash hider (if there is one) from the barrels muzzle. Then using solvent or alcohol and a bristle brush, clean the threads on the muzzle thoroughly, removing all traces of dirt, carbon and grease.

3: Apply a fresh smear of grease (any quality firearm grease will do) to the muzzle threads. **NOTE! Do not skip this step!** Grease lubrication MUST be used on all threads on a Trentech Viper brake. Failure to use grease can result in galled and damaged threads.

4: Ensure the muzzle brake lock nut is screwed all the way onto the brake body by turning the nut clockwise until it stops. This should only be finger tight at this stage. Screw muzzle brake (with locknut) onto the barrel until it contacts the shoulder on the barrel.

5: Then unscrew the brake the required amount to get the main ports at the 9 O-clock and 3 o-clock position, with the smaller blast ports at the top (12 o-clock) position. Proper alignment will occur within one revolution. Once the brake body is aligned, unscrew the locknut from the brake body and wind it back towards the barrel shoulder until it contacts the shoulder.

6: Using a 7/8” spanner on the body to maintain alignment, and a 1” Spanner on the nut, tighten the nut against the barrel shoulder while maintaining body alignment. (Using a piece of paper or thin card between the spanner and the brake will prevent marring of the finish.) Adjustable spanners can be substituted with care if correct spanners are not available. Once the nut is tight, double check the alignment with the barrel and repeat step 5 if necessary to achieve correct alignment. (3/4” & 7/8” spanners for the 1/2x28 thread models.

TIPS:

Always ensure adequate grease lubrication on all muzzle brake threads. Failure to use grease can result in Galling and damage of the threads on both the brake and the rifle. I recommend a product called Nulon L90 Anitseize, but any quality industrial grease will work. Keep the muzzle brake clean and free from carbon fouling build up. Regular bore solvent and a small brush works well. Alternatively the brake can be removed and cleaned in an ultrasonic cleaner, however remember to re-grease all the threads on the bake and lock nut. DO NOT use a vibratory style tumbler, or stainless steel pin tumbler to clean or polish the brake as it will damage the threads.

STEP 4

STEP 5

STEP 6

STEP 6