

KAC

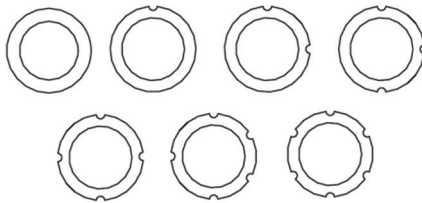
KNIGHTS ARMAMENT

ACC-IN-0001
Rev 4

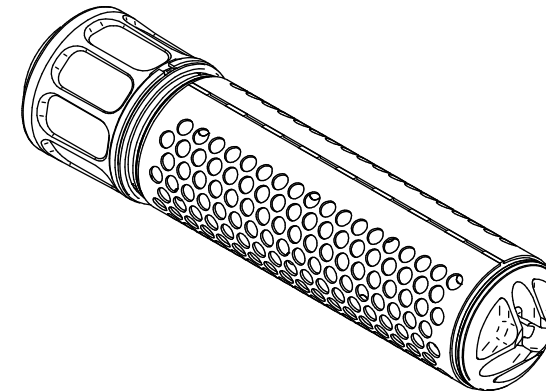
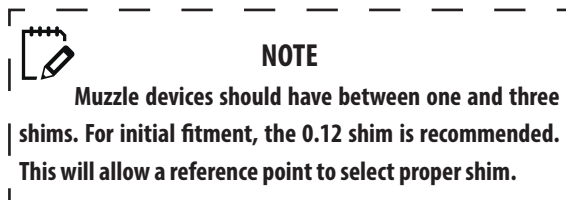
QDC & MUZZLE DEVICE INSTRUCTION



SHIMS



Shim Thickness (in)	Number of Notches
.031	no notch
.020	one notch
.015	two notches
.012	three notches
.010	four notches
.009	five notches
.008	six notches



ALIGNMENT ADJUSTMENTS

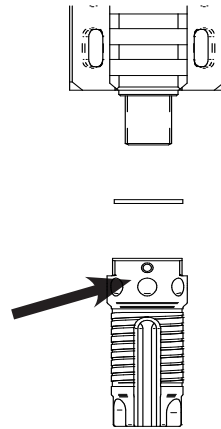
- If the suppressor index pin aligns past the 12 o'clock position by more than 1/2 turn, remove the correct shims to get the center slot close to the 12 o'clock position. Use the chart to determine the correct shim/thickness combination.
- If the suppressor index pin aligns past the 12 o'clock position by less than 1/2 turn, add shims needed for the suppressor index pin to reach the 12 o'clock position (each 1/4 turn is approximately .010" of shim thickness). Use the chart to determine the correct shim/thickness combination.
- If the suppressor index pin aligns within +/- 1/4 rotation of the muzzle device, add thickness if the slot is past 12 o'clock (top dead center); or remove thickness if it is before 12 o'clock. Use the guide for estimating shim thickness.
- Use the leading side edge of the alignment pin for a reference point. This point needs to be at 11 o'clock when hand tight so that when torqued to 15-20 ft-lbs the slot will be centered at 12 o'clock.

Large Adjustments:

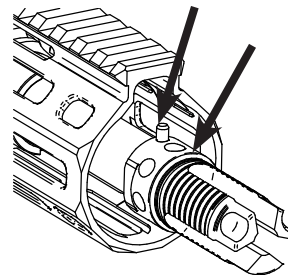
- At hand tight, to rotate the flash suppressor 180 degrees (from 6 to 12 o'clock), use .020" of shims.
- At hand tight, to rotate the flash suppressor 90 degrees (from 3 or 9 o'clock to 12 o'clock), use .010" of shims.
- Use the chart to select the shim combination of correct thickness (.056 = .010+.015+.031).
- With only this shim set installed, again install the muzzle device hand tight. Continue to adjust shim thickness + or - if needed.
- Torque the muzzle device to 15 to 20 ft-lbs so that the center slot is very close (within 1/4 slot or 5 degrees) to aligning top-dead-center (12 o'clock).
- Remove the muzzle device and thoroughly clean, degrease and dry the muzzle threads and the compensator.

1 Thread the muzzle device onto the barrel. After inserting shims, and the muzzle device is seated in the correct position, take off the muzzle device and apply Rocksett to the muzzle threads.

Allow rocksett to cure for minimum if 24 hours before use.



2 Re-attach the muzzle device and torque to 15-20 ft-lbs and ensure the alignment pin is in-line with the gas block to achieve the 12 o'clock position, +/- 3 degrees.

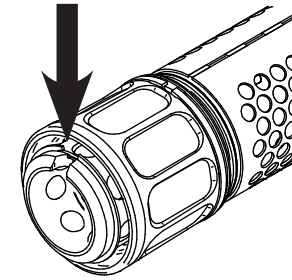


NOTE:

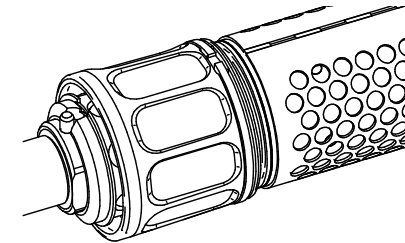


Ensure the rifle is positioned in the vertical position (muzzle up).

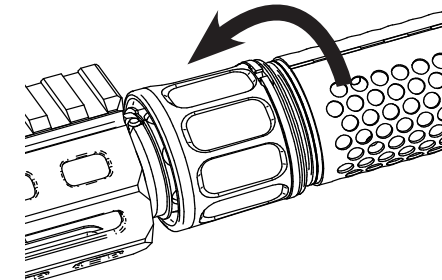
3 Unscrew the screw latch so the ball detents are free to move.



4 Pull the suppressor back onto the muzzle device so the alignment notch and the alignment pin achieve the 12 o'clock position.



5 Hand-tighten the screw latch, in line with the interior of the muzzle device.



NOTE:
For 7.62 installation, place shims inside the muzzle device with the muzzle downward. If the muzzle is upright or to the side the shims can tilt out of position and seize the threads.
For 5.56 installation, place shims over the barrel with the muzzle up.
The 5/8 x24 muzzle device indexes off the shoulder, not the face of the muzzle.



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