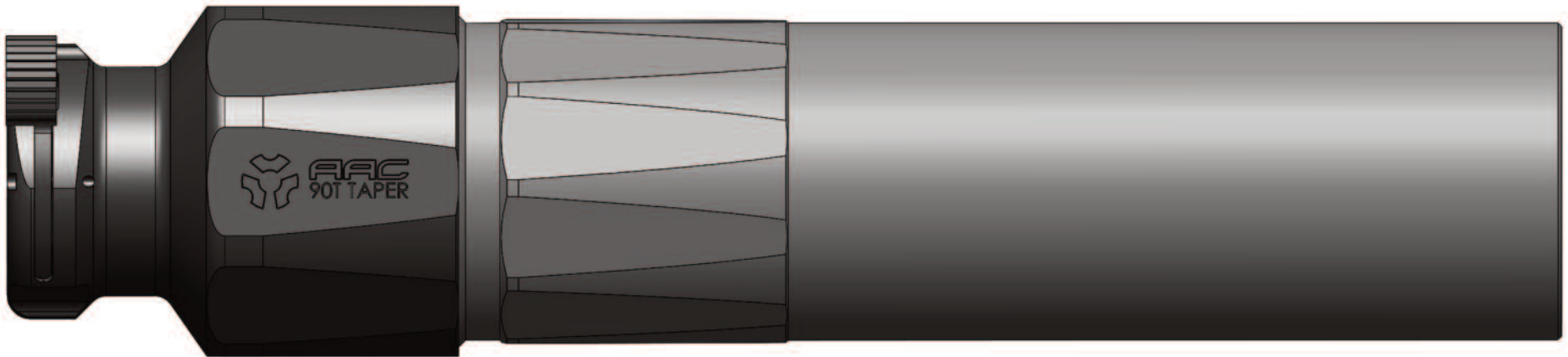


TM-Ti-RAID 30

TECHNICAL MANUAL FOR
OPERATION AND MAINTENANCE
OF SILENCER MODEL
Ti-RAID 30



AAC
ADVANCED ARMAMENT CORP.

1816 Remington Circle SW
Huntsville, AL 35824

ADVANCED ARMAMENT CORPORATION

Limited Lifetime Warranty for Silencers

ADVANCED ARMAMENT CORP. ("AAC") warrants to the original purchaser ("Purchaser") of a new Silencer from AAC that such Silencer shall be free from defects in material and workmanship for the duration of time that the Purchaser originally owns that Silencer. AAC, in its sole discretion, shall repair or replace the Silencer if the Purchaser submits a valid warranty claim in accordance with these instructions. If AAC opts to replace the Silencer, AAC will keep the Silencer that it replaces. The Purchaser's remedies under this warranty are limited to repair or replacement of the Silencer; AAC will not provide cash, credit, or refund, nor will AAC return any parts that it replaced. AAC does not warrant against any type of defect to the Silencer that AAC did not cause, including but not limited to defects or failures arising out of:

1. Failure to provide proper care and maintenance,
2. Accidents, abuse, or misuse,
3. Silencer obstruction,
4. Hand loaded, reloaded, or improper ammunition,
5. Unauthorized adjustments, repairs, or modifications, or
6. Normal wear and tear.

Additionally, AAC EXCLUDES AND WILL NOT PAY INCIDENTAL OR CONSEQUENTIAL DAMAGES UNDER THIS WARRANTY. THIS WARRANTY ALSO EXCLUDES ANY OTHER WARRANTIES, TO INCLUDE IMPLIED WARRANTIES. Furthermore, no individual or entity other than AAC possesses the authority to alter the obligations, limitations, disclaimers, or exclusions under this warranty. AAC's obligations under this warranty shall not apply to the extent that any law, regulation, or other governmental requirements prohibits the repair, replacement and, or, return of a Silencer to the person who shipped the Silencer to AAC.

The Purchaser, in order to achieve eligibility under this warranty, must be able to produce, on request, Purchaser's original sales receipt for the Silencer that clearly indicates that Purchaser is the original purchaser at retail. The Purchaser, upon discovering a defect in material or workmanship in the silencer, shall contact AAC at 770-925-9988 or techinfo@advanced-armament.com

Upon receiving the Purchaser's correspondence or phone call, AAC shall provide instructions to the Purchaser governing the manner in which to return the Silencer for repair or replacement.

Repair Policy

Should the silencer require repair or modification, the owner should contact AAC Customer Service to secure a Return Merchandise Authorization (RMA). Once the customer has the RMA, they may then ship the silencer insured to AAC for evaluation and repair, along with a photocopy of the approved form proving ownership and a brief letter detailing the customer's concerns and contact information.

Manufacturer's Disclaimer


ADVANCED ARMAMENT CORP. shall not be responsible in any manner whatsoever for physical injury or property damage stemming from criminal or negligent misuse, improper or careless handling, unauthorized modifications, defective, improper hand-loaded or reloaded ammunition, neglect, or other influences beyond our direct and immediate control. If you do not understand the instructions and recommendations in this manual, contact ADVANCED ARMAMENT CORP. at 770-925-9988 for clarification.

© 2018 Remington Arms Company, LLC.

The stylized AAC logo, BLACKOUT, Rem, and BriteBore are trademarks of RA Brands, L.L.C. All other trademarks used herein remain the exclusive property of their respective owners.

This manual contains operating, care, and maintenance instructions. To assure safe operation, any user of this silencer must read and understand this manual before using the silencer. Failure to follow the instructions and heed the warnings in this manual can cause property damage, personal injury, and/or death. This manual should always accompany this silencer, and be transferred with it upon change of ownership.

WARNING Keep this silencer out of the reach of children, unauthorized and/or prohibited individuals, and others unfamiliar with the safe handling of firearms and silencers.

	Alert Symbols and Definitions:
WARNING!	Indicates a hazardous situation which, if not avoided, could result in property damage, personal injury, or death.
CAUTION!	Indicates a hazardous situation which, if not avoided, could result in minor to moderate personal injury.
NOTE:	Addresses practices not relating to personal injury.

© 2018 ADVANCED ARMAMENT CORP.

OPERATIONAL MANUAL FOR SILENCER MODEL TI-RAID 30

Distributed by

ADVANCED ARMAMENT CORP.

Phone: (770) 925-9988

www.advanced-armament.com

CONTENTS:

The Ten Commandments of Firearm Safety.....	P.3
General description.....	P.3
Installing a 90T Ratchet Taper Ti-RAID 30 onto a host firearm.....	P.4
Removing a 90T Ratchet Taper Ti-RAID 30 from a host firearm....	P.6
Installing a 51T Ratchet Mount Ti-RAID 30 onto a host firearm....	P.7
Removing a 51T Ratchet Mount Ti-RAID 30 from a host firearm...	P.9
Installing a Direct-Thread Ti-RAID 30 onto a host firearm.....	P.9
Removing a Direct-Thread Ti-RAID 30 from a host firearm.....	P.11
Disassembling the Ti-RAID 30.....	P.11
Cleaning the Ti-RAID 30.....	P.13
Reassembling the Ti-RAID 30.....	P.14

THE TEN COMMANDMENTS OF FIREARM SAFETY

1. Always keep the muzzle pointed in a safe direction.
2. Firearms should be unloaded when not actually in use.
3. Do not rely on your firearm's safety.
4. Be sure of your target and what is beyond it.
5. Only use ammunition that exactly matches the markings on your firearm.
6. If your firearm fails to fire when the trigger is pulled, handle with care.
7. Always wear eye and hearing protection when shooting.
8. Be sure the barrel is clear of obstructions before shooting.
9. Do not alter or modify your firearm and have it serviced regularly.
10. Learn the mechanics and handling characteristics of your firearm.
Read your firearm's instruction manual.

WARNING! Failure to follow the instructions and recommendations set forth in this manual can create a potentially dangerous situation for the user and surrounding personnel, possibly leading to property damage, personal injury and/or death.

WARNING! DO NOT shoot through a Ti-RAID 30 silencer that is mounted on a BLACKOUT® Silencer-Mounting muzzle device that has not been installed onto the host rifle using the included Rocksett sealant and recommended torque fastening. Mounting and shooting through a Ti-RAID 30 silencer that is mounted to an unsecured BLACKOUT Silencer-Mounting muzzle device could lead to property damage, personal injury and/or death.

WARNING! DO NOT use an auxiliary thread adapter between your host weapon barrel and a BLACKOUT Silencer-Mounting muzzle device. Using an auxiliary thread adapter between your host weapon barrel and a BLACKOUT Silencer-Mounting muzzle device could lead to misalignment between the host weapon bore and the Ti-RAID 30 silencer, which could lead to property damage, personal injury and/or death.

WARNING! We recommend having your BLACKOUT Silencer-Mounting muzzle device installed by a competent gunsmith or armorer. Neither Advanced Armament Corp. nor its affiliates are liable for damage(s) to the host weapon, silencer, and user attributed to improper installation. An improperly installed or misaligned BLACKOUT

Silencer-Mounting muzzle device can create a potentially dangerous situation for the user and surrounding personnel, and may lead to property damage, personal injury and/or death.

WARNING! Always wear protective gear, such as eye protection and solvent-resistant gloves when working with any solvent. Only use solvents in a well-ventilated area away from open flames. Unsafe use of solvents may lead to property damage, personal injury and/or death.

WARNING! DO NOT use a crush washer or compression washer when installing a BLACKOUT Silencer-Mounting muzzle device. Installing a BLACKOUT Silencer-Mounting muzzle device with a crush washer or compression washer can lead to misalignment of a BLACKOUT Silencer-Mounting muzzle device and the host weapon bore. Misalignment of a BLACKOUT Silencer-Mounting muzzle device and the host weapon bore can create a dangerous situation that may lead to property damage, personal injury and/or death.

WARNING! Never install or remove a silencer on or from a host firearm that you have not verified to be completely empty and rendered safe. Installing or removing a silencer on or from a loaded firearm may lead to property damage, personal injury and/or death.

WARNING! The Ti-RAID 30 is designed for use on modern rifles and carbines in serviceable condition. It is the user's responsibility to ensure the intended host firearm is in serviceable condition. Using a Ti-RAID 30 on firearms that are not in serviceable condition can lead to property damage, personal injury and/or death.

WARNING! The barrel threads must be properly machined to allow proper attachment of a BLACKOUT Silencer-Mounting muzzle device. The use of an improperly threaded barrel with a BLACKOUT Silencer-Mounting muzzle device may lead to property damage, personal injury and/or death. For further clarification on muzzle threads, contact ADVANCED ARMAMENT CORP. at 770-925-9988.

WARNING! The bore through your Ti-RAID 30 must align concentrically with the bore of the barrel to which it is mounted. A misalignment of the silencer and barrel bore may lead to property damage, personal injury and/or death.

WARNING! Discharging silenced firearms can make airborne and/or

deposit lead and other substances around, on and in the silencer. Using, handling and/or cleaning a silencer may result in exposure to lead and other substances known to cause birth defects, reproductive harm, cancer and other serious physical injury. Have adequate ventilation at all times and wash hands thoroughly after exposure.

CAUTION! Silencers can become extremely hot while the host firearm is being discharged. After shooting, allow the silencer to reach ambient temperature before attempting to remove the silencer from the firearm. If removal is necessary prior to the silencer cooling to ambient and/or the tightness of the silencer on the host firearm barrel must be verified, the use of heat-resistant gloves is mandatory. Handling a hot silencer without heat resistant gloves may lead to skin burns and/or personal injury.

CAUTION! Always wear eye and hearing protection when discharging a firearm. Discharging a firearm without wearing eye and hearing protection may lead to personal injury.

GENERAL DESCRIPTION

Congratulations! You are now the proud owner of the best high-performance, user-serviceable, user-configurable sound and flash suppressor for .30 caliber rifles and carbines available in today's marketplace. The Ti-RAID 30 can, in seconds and without tools, be configured as either a direct-thread or fast-attach suppressor. In addition to the ease of configuring the mounting apparatus, the Ti-RAID 30 can be fully disassembled by the user with no special tools required. The ability to fully disassemble the Ti-RAID 30 means users will be able to remove copper and carbon deposits that are impossible to remove from a fully-welded, sealed suppressor. The revolutionary design of the Ti-RAID 30 baffle core significantly reduces felt recoil, environmental disturbance, and aids in the preservation of the hearing of shooters and observers. In numerous circumstances, the Ti-RAID 30 may deliver an overall sound signature below the pain threshold and risk limit for hearing loss*. The Ti-RAID 30 is constructed entirely of lightweight, high-strength, corrosion resistant Titanium alloy and features a PVD finish.

* The cumulative effects of sound on hearing are influenced by multiple factors, including but not limited to the sound level, the total amount of time (or number of times) one is exposed, barrel length, type of firearm operating system, ammunition selection, and the surrounding environment. Also,

unforeseen events, such as case ruptures, can expose the user and bystanders to sound levels well beyond the level of suppressed fire. For these reasons, AAC recommends the use of hearing protection, even when shooting with a suppressor.

INSTALLING A Ti-RAID 30 SILENCER ONTO A HOST FIREARM -90 TOOTH RATCHET TAPER FAST-ATTACH CONFIGURATION-

WARNING! Never attempt to attach a Ti-RAID 30 to a BLACKOUT Silencer-Mounting muzzle device with threads that are dirty or damaged, as this may lead to property damage, personal injury and/or death.

WARNING! Never attempt to attach a Ti-RAID 30 with dirty or damaged threads to a BLACKOUT Silencer-Mounting muzzle device, as this may lead to property damage, personal injury and/or death.

WARNING! Never use a silencer with an obstructed bore, as this may lead to property damage, personal injury and/or death.

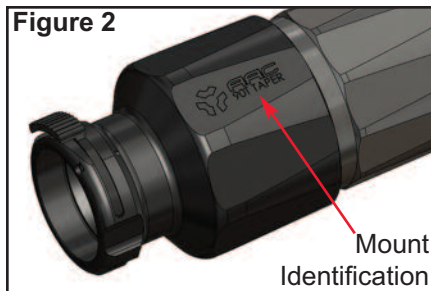
1. Always keep the firearm pointed in a safe direction.
2. Render the firearm safe by removing the magazine, completely unloading the firearm and engaging the safety mechanism to the "SAFE" position. See the firearm's owner's manual for detailed instructions.

3. Inspect the ACME thread on the exterior of the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device, the toothed gear behind the threads, and the silencer alignment surfaces to verify they are clean and undamaged. See Figure 1.

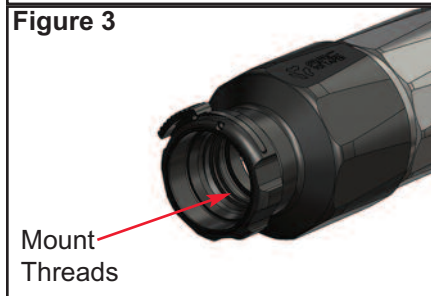


4. Verify the fast-attach mount is compatible with the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device mounted to the host firearm. The fast-attach mount designation is marked on the mount. See Figure 2.

5. Inspect the threads in the rear of the 90T Ratchet Taper Mount to verify they are clean and undamaged. See Figure 3.

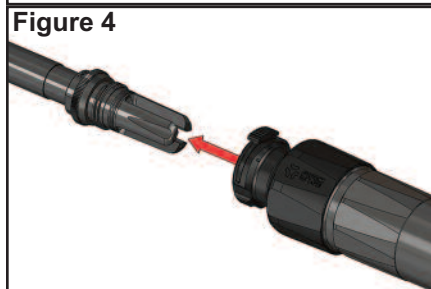


6. Look through the silencer from the rear to ensure the bullet path through the silencer is unobstructed.

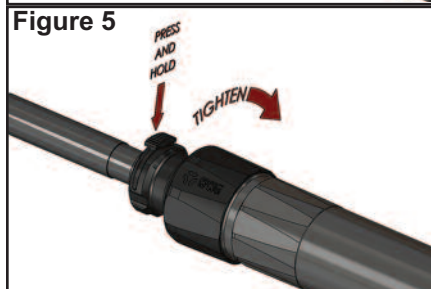


7. Examine the silencer for any signs of damage.

8. Grasp the silencer by the installed mount and slide the Ti-RAID 30 over the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device. See Figure 4.

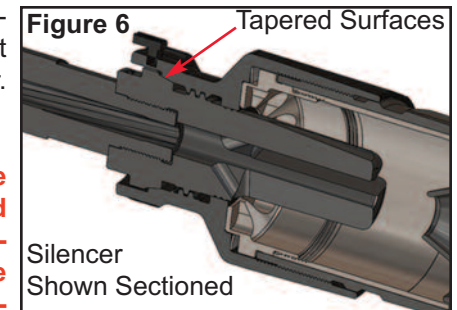


9. Hold the Ti-RAID 30 by the mount and while keeping the textured thumb pad of the latch depressed, carefully screw the silencer onto the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device threads in the direction indicated in Figure 5.



10. Tighten the silencer fully onto the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device *hand-tight* just until the tapered alignment surface adjacent to the toothed gear on the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device engages the mating tapered alignment surface in the rear of the Ti-RAID 30 silencer. When the silencer is fully engaged with the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device, release tension on the textured thumb pad. There should be no perceptible movement between the 90T Ratchet

Taper BLACKOUT Silencer-Mounting muzzle device/host rifle and the Ti-RAID 30 silencer. See Figure 6.



WARNING! User must ensure the silencer stays securely threaded to the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device during use. Failure to ensure the silencer stays securely threaded to the BLACKOUT Silencer-Mounting muzzle device may lead to property damage, personal injury and/or death.

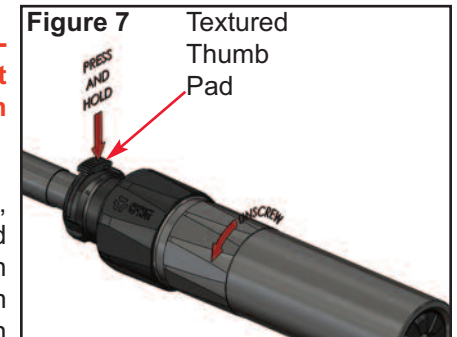
NOTE. Do not over-tighten the silencer onto the 90T Ratchet Taper BLACKOUT Silencer-Mounting muzzle device/host firearm, as it may be difficult to remove.

REMOVING A Ti-RAID 30 FROM A HOST FIREARM -90 TOOTH RATCHET TAPER FAST-ATTACH CONFIGURATION-

1. Keep the host firearm pointed in a safe direction.
2. Render the firearm safe by removing the magazine, completely unloading the firearm and engaging the safety mechanism to the "SAFE" position. See the firearm's owner's manual for detailed instructions.
3. Verify the silencer is at ambient temperature. If the silencer is hot, allow it to cool.

CAUTION! Never handle a hot silencer without heat-resistant gloves, as this may lead to skin burns and/or personal injury.

4. While firmly grasping the mount, depress and hold the textured thumb-pad on the ratchet latch and unscrew the silencer from the muzzle brake in the direction indicated in Figure 7.



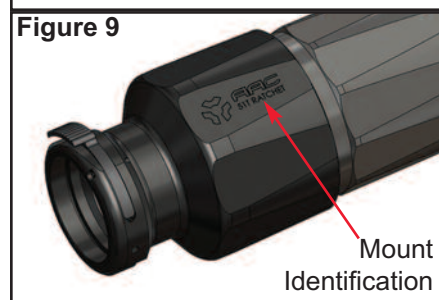
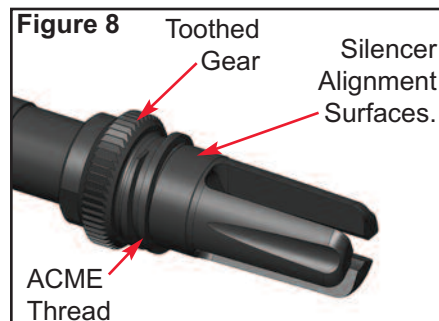
INSTALLING A Ti-RAID 30 SILENCER ONTO A HOST FIREARM -51T TOOTH RATCHET MOUNT FAST-ATTACH CONFIGURATION-

WARNING! Never attempt to attach a Ti-RAID 30 to a BLACKOUT Silencer-Mounting muzzle device with threads that are dirty or damaged, as this may lead to property damage, personal injury and/or death.

WARNING! Never attempt to attach a Ti-RAID 30 with dirty or damaged threads to a BLACKOUT Silencer-Mounting muzzle device, as this may lead to property damage, personal injury and/or death.

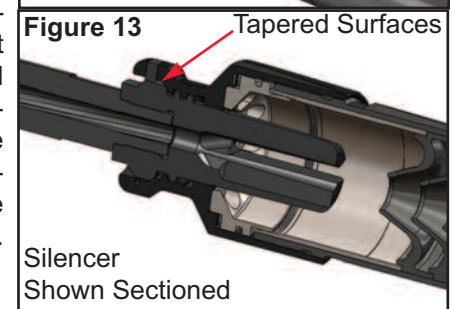
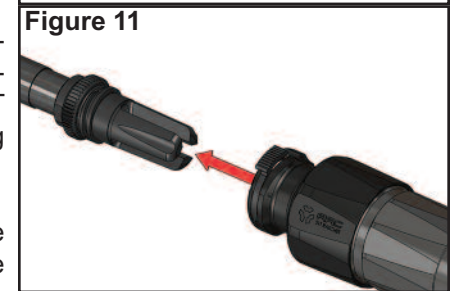
WARNING! Never use a silencer with an obstructed bore, as this may lead to property damage, personal injury and/or death.

1. Always keep the firearm pointed in a safe direction.
2. Render the firearm safe by removing the magazine, completely unloading the firearm and engaging the safety mechanism to the "SAFE" position. See the firearm's owner's manual for detailed instructions.
3. Inspect the ACME thread on the exterior of the 51T BLACKOUT Silencer-Mounting muzzle device, the toothed gear behind the threads, and the silencer alignment surfaces to verify they are clean and undamaged. See Figure 8.
4. Verify the fast-attach mount is compatible with the 51T BLACKOUT Silencer-Mounting muzzle device mounted to the host firearm. The fast-attach mount designation is marked on the mount. See Figure 9.
4. Inspect the threads in the rear of the 51T Ratchet Mount to verify they are clean and undamaged.



See Figure 10.

5. Look through the silencer from the rear to ensure the bullet path through the silencer is unobstructed.
6. Examine the silencer for any signs of damage.
7. Grasp the silencer by the installed mount and slide the Ti-RAID 30 over the 51T BLACKOUT Silencer-Mounting muzzle device. See Figure 11.
8. Hold the Ti-RAID 30 by the mount and while keeping the textured thumb pad of the latch depressed, carefully screw the silencer onto the 51T BLACKOUT Silencer-Mounting muzzle device threads in the direction indicated in Figure 12.
9. Tighten the silencer fully onto the 51T BLACKOUT Silencer-Mounting muzzle device *hand-tight* until the tapered alignment surface adjacent to the toothed gear on the BLACKOUT Silencer-Mounting muzzle device fully engages the mating tapered alignment surface in the rear of the Ti-RAID 30 silencer. See Figure 13.



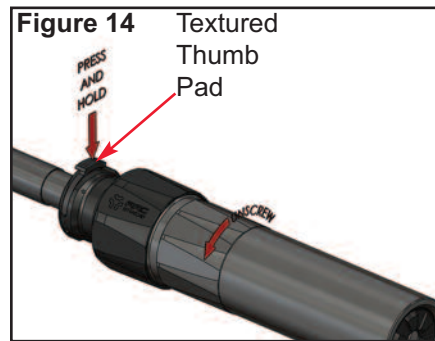
WARNING! User must ensure the silencer stays securely threaded to the BLACKOUT Silencer-Mounting muzzle device during use. Failure to ensure the silencer stays securely threaded to the BLACKOUT Silencer-Mounting muzzle device may lead to property damage, personal injury and/or death.

REMOVING A Ti-RAID 30 FROM A HOST FIREARM -51 TOOTH RATCHET MOUNT FAST-ATTACH CONFIGURATION-

1. Keep the host firearm pointed in a safe direction.
2. Render the firearm safe by removing the magazine, completely unloading the firearm and engaging the safety mechanism to the "SAFE" position. See the firearm's owner's manual for detailed instructions.
3. Verify the silencer is at ambient temperature. If the silencer is hot, allow it to cool.

CAUTION! Never handle a hot silencer without heat-resistant gloves, as this may lead to skin burns and/or personal injury.

4. While firmly grasping the mount, depress and hold the textured thumb-pad on the ratchet latch and unscrew the silencer from the muzzle brake in the direction indicated in Figure 14.



INSTALLING A Ti-RAID 30 SILENCER ONTO A HOST FIREARM -DIRECT-THREAD CONFIGURATION-

WARNING! Never attempt to attach a Ti-RAID 30 to muzzle threads that are dirty or damaged, as this may lead to property damage, personal injury and/or death.

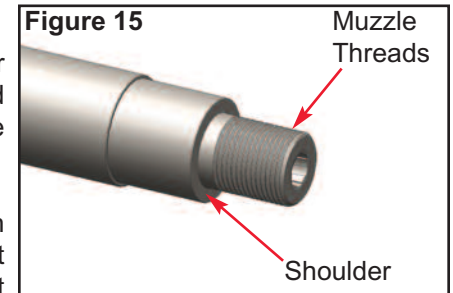
WARNING! Never attempt to attach a Ti-RAID 30 with dirty or damaged threads to a threaded muzzle, as this may lead to property damage, personal injury and/or death.

WARNING! Never use a silencer with an obstructed bore, as this may lead to property damage, personal injury and/or death.

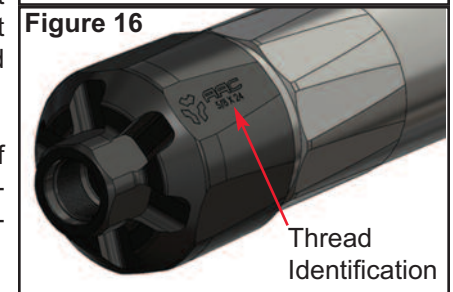
1. Always keep the firearm pointed in a safe direction.

2. Render the firearm safe by removing the magazine, completely unloading the firearm and engaging the safety mechanism to the "SAFE" position. See the firearm's owner's manual for detailed instructions.
3. Remove the existing flash hider and any washers or shims from the host firearm muzzle.

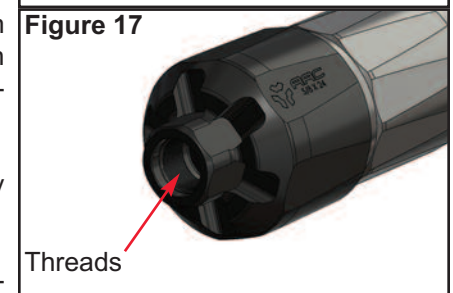
4. Clean the threads and shoulder on the host-firearm muzzle and verify they are undamaged. See Figure 15.



5. Verify the thread specification on the Direct-Thread mount matches the threads on the host firearm muzzle. The mount thread specification is marked on the mount. See Figure 16.



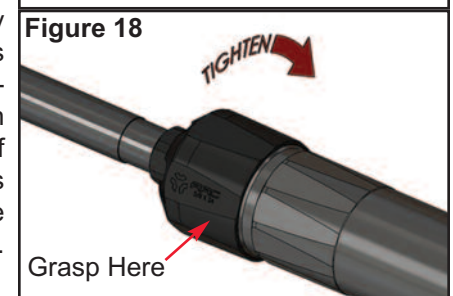
6. Inspect the threads in the rear of the Direct-Thread Mount to verify they are clean and undamaged. See Figure 17.



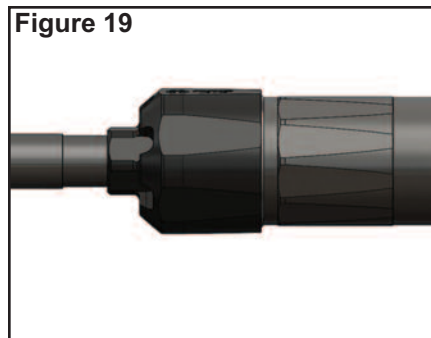
7. Look through the silencer from the rear to ensure the bullet path through the silencer is unobstructed.

8. Examine the silencer for any signs of damage.

9. Hold the silencer by the direct-thread mount and carefully screw it onto the muzzle threads in the direction indicated in Figure 18. Thread the silencer on completely so that the rear of the direct-thread mount sits flush and square against the shoulder behind the threads. See Figure 19.



WARNING! User must ensure the silencer stays securely threaded to the host-firearm muzzle threads during use. Failure to ensure the silencer stays securely threaded to the host-firearm muzzled threads may lead to property damage, personal injury and/or death.

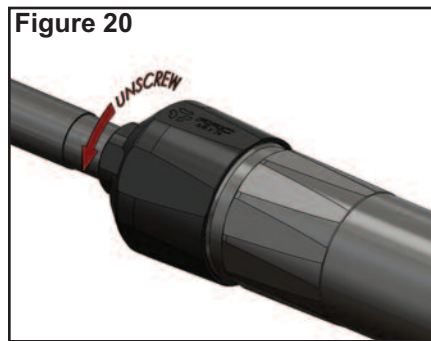


REMOVING A Ti-RAID 30 FROM A HOST FIREARM -DIRECT-THREAD CONFIGURATION-

1. Always keep the host firearm pointed in a safe direction.
2. Render the firearm safe by removing the magazine, completely unloading the firearm and engaging the safety mechanism to the "SAFE" position. See the firearm's owner's manual for detailed instructions.
3. Verify the silencer is at ambient temperature. If the silencer is hot, allow it to cool.

CAUTION! Never handle a hot silencer without heat-resistant gloves, as this may lead to skin burns and/or personal injury.

4. While firmly grasping the direct-thread mount, unscrew the silencer from the muzzle threads in the direction indicated in Figure 20.



DISASSEMBLING THE Ti-RAID 30

WARNING! Only perform disassembly procedures on silencers that are not mounted to a firearm. Attempting disassembly on a mounted silencer could lead to property damage, personal injury and/or death.

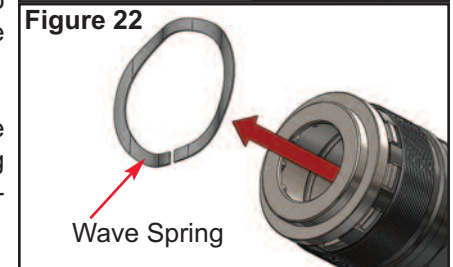
1. If the Ti-RAID 30 is mounted to a host firearm, dismount it following the procedure outlined in "Removing the Ti-RAID 30 from a host firearm" in

this manual.

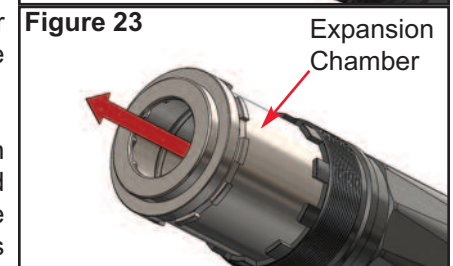
2. Begin disassembly by unscrewing the mount from the tube body. See Figure 21. NOTE: It may be necessary to secure either the 90T Ratchet Taper Mount or the tube body using a vice or other work holding device in order to unscrew the tube body and the mount.



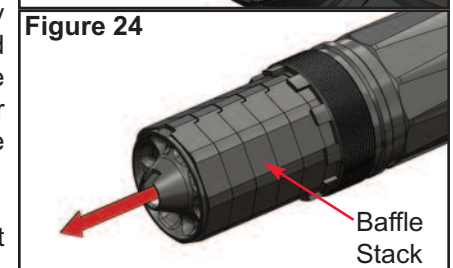
3. Remove and set aside the mount-tensioning wave spring from rear of the expansion chamber. See Figure 22.



4. Extract the expansion chamber from the tube body. See Figure 23.



5. Tilt the tube body as shown in Figure 24. The seven baffles and front chamber should fall free from the tube body. If the baffles and front chamber will not easily fall free, push on the exposed face of the front chamber to free the baffles and front chamber from the tube body. See Figure 25.



6. Separate the baffles and front chamber. See Figure 26. Disassembly is complete.



CLEANING THE Ti-RAID 30

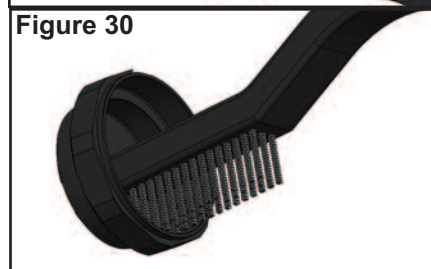
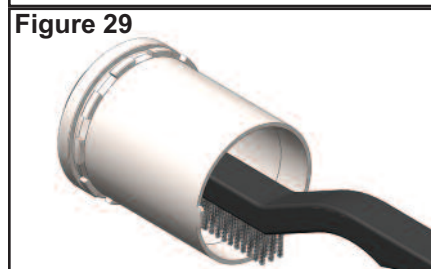
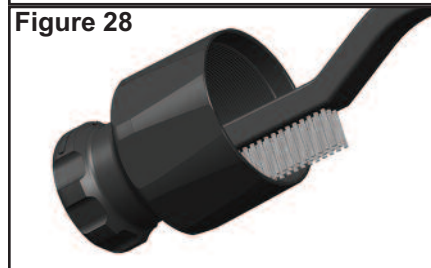
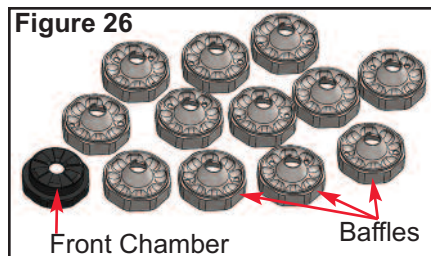
WARNING! Only perform cleaning and maintenance procedures on silencers that are not mounted to a firearm. Attempting to clean or perform maintenance on a mounted silencer could lead to property damage, personal injury and/or death.

WARNING! Always wear protective gear, such as eye protection and solvent-resistant gloves when working with any solvent. Only use solvents in a well-ventilated area away from open flames. Unsafe use of solvents may lead to property damage, personal injury and/or death.

1. Use a brush and BriteBore® to clean the flash hider receptacle in the rear of the mount and the threaded socket in the front of the mount. Stubborn carbon and copper deposits can be removed using copper solvent and a Scotch-Brite pad. See Figures 27 and 28.

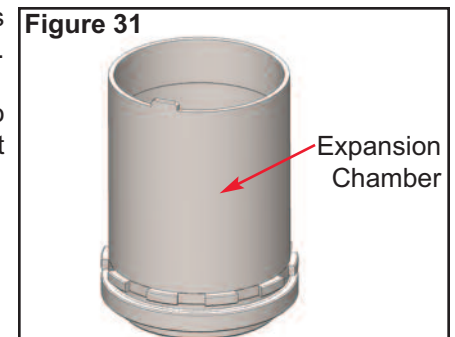
2. Use a brush and BriteBore® to clean the inside of the expansion chamber. Wipe any carbon from the outside with a cloth moistened with copper remover. See Figures 29 and 30.

3. The Titanium baffles of the Ti-RAID 30 can be cleaned with a brass brush and BriteBore®, ultrasonic cleaning, or light abra-



sive blasting. Copper deposits and carbon should be removed.

4. Use a brush and solvent to clean the inside of the front chamber. See Figure 30.



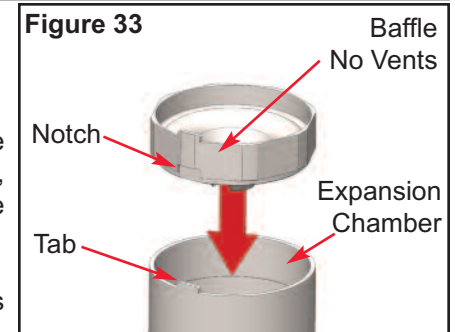
REASSEMBLING THE Ti-RAID 30

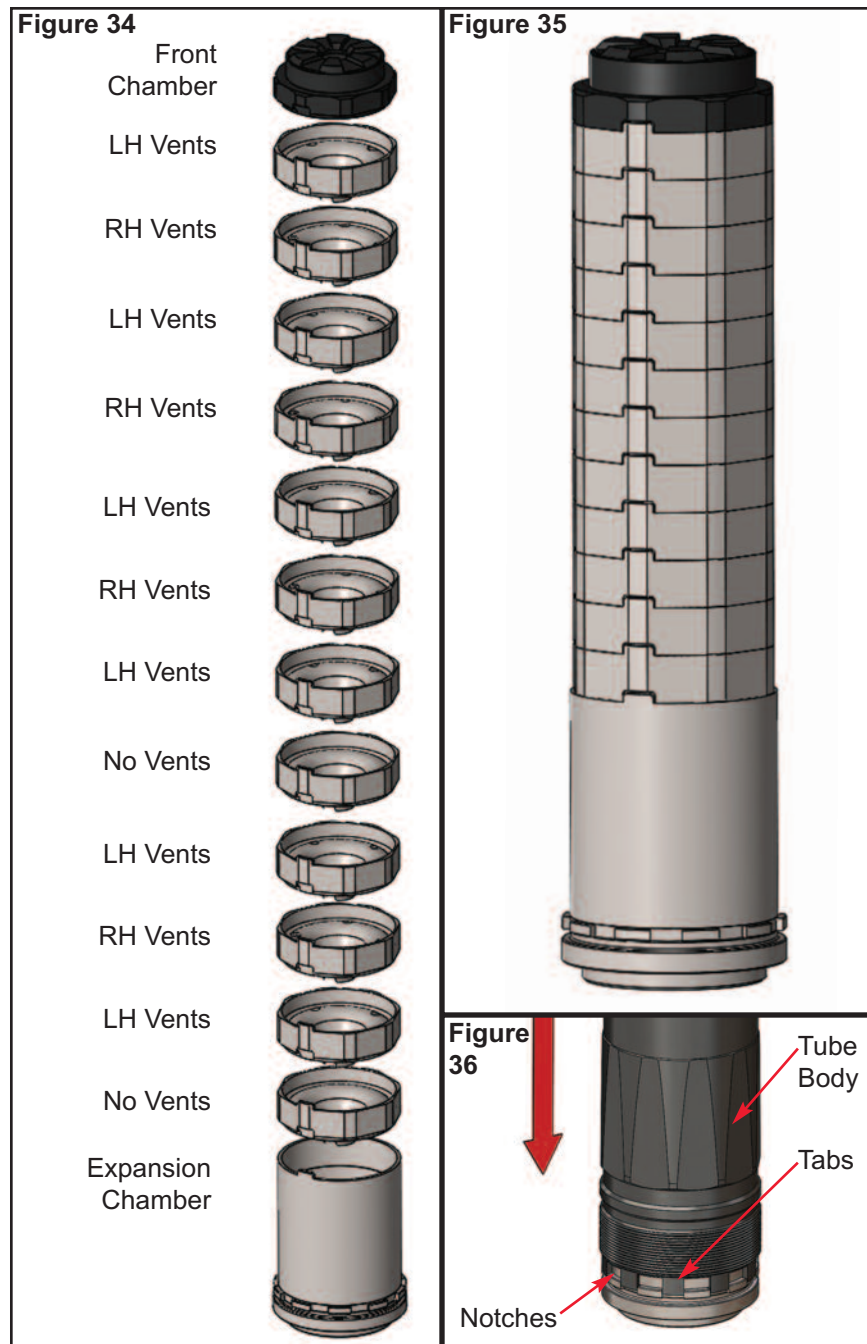
1. Begin reassembly by placing the expansion chamber on a flat, level surface as shown in Figure 31.

2. The Ti-RAID 30 baffle stack is made up of twelve Titanium baffles. The baffles all feature a gas-diverting shear cut, but they differ in that some have an offset cluster of four gas diversion vents. Figure 32 illustrates the different baffle designs.

3. Begin rebuilding the baffle stack by placing a shear cut baffle with no vents on top of the expansion chamber so that the tab on the expansion chamber engages the notch on the baffle as seen in Figure 33.

4. Continue building the baffle stack following the illustration in Figure 34. The Front Chamber sits atop the baffle stack and is tabbed to the last





baffle. The completed internal component stack is shown in Figure 35.

- Slide the tube body over the assembled baffle stack so that the tabs on the rear of the tube body engage the notches on the rear of the expansion chamber. See Figure 36.

NOTE: The tab and notch relationship of the tube body and expansion chamber enables users to rotationally adjust the baffle stack in 36 degree increments to minimize point of impact shift. The optimum baffle alignment is one that orients the shear cuts of the baffles as close to vertical, either up or down, when mounted to the host firearm. See Figures 37 and 38.

- Turn the assembled tube body upright and place the wave spring on the circular boss on the rear of the expansion chamber. See Figure 39.
- Hold the reassembled tube body upright and thread the mount onto the tube. Resistance will be felt as the wave spring is compressed between the mount and the expansion chamber. Thread the mount to the tube, by hand, until the mount will tighten no further. See Figure 40.

