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MADE IN THE USA

Hypertap® Gunsmith Model - Supplemental Instructions

IMPORTANT: This manual contains specific instructions for the Gunsmith Models of the Hypertap® Muzzle Brake product line. These instructions are only intended to supplement the Hypertap Muzzle Brake Instruction Manual (DOC-A013). Be sure to follow all instructions and warnings provided in manual DOC-A013 prior to installation.

MACHINING GUIDELINES: The Hypertap® Gunsmith Model Muzzle Brake is intended to be finish threaded and through-bored to suit for custom installation. **THIS MUST ONLY BE PERFORMED BY A QUALIFIED GUNSMITH.** Chart 1 outlines factory dimensions and the allowable range of thread and through-bore sizes that each Hypertap® body size can accommodate. Do not exceed these dimensions.

Chart 1: Factory Dimensions & Allowable Machining Range

Hypertap Size	Factory Thread Bore	Factory Through-Bore	Allowable Thread Range	Maximum Through-Bore	Maximum Caliber
Slim Body	.375”	.282”	1/2”-5/8” (12.7-16mm)	.418”	.358/9mm
Standard Body	.468”	.282”	(1/2”-3/4”) (12.7-19mm)	.560”	.500/12.7mm

Figure 2 illustrates the required geometric tolerance for concentricity between the threads and the through-bore. This tolerance is easily achieved by cutting the threads and through-bore in a single fixture step with single point tools. Do not install brake on a firearm unless it satisfies the tolerance in Figure 2.

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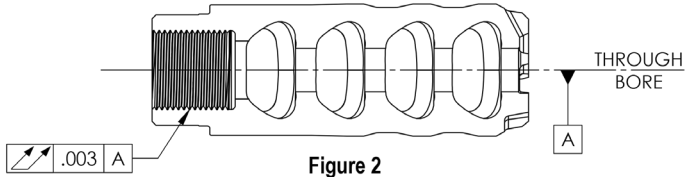

Figure 2

THREADS: A Class-2B or Class-3B thread is required for installation. The threads can be cut to a blind depth to suit the length of thread on barrel (as shown in Figure 2), or they can be cut through to the first blast chamber. Both configurations are acceptable. The length of thread engagement between the barrel and brake body should be at least 60% of thread diameter. For example, on the 5/8-24 thread there should be a minimum of 0.375” of thread engagement.

THROUGH-BORE: It is recommended to cut the through-bore 0.060” larger in diameter than bullet diameter. For example, if machining the brake for use with .308” diameter bullets, it is recommended to cut the through-bore to a diameter of 0.368”.

TIMING NUT: Machine the clearance hole in the timing nut to 0.005” larger in diameter than the barrel thread diameter. A small internal chamfer can be added to account for a radius at the barrel shoulder interface. It is required that the barrel shoulder be a minimum of .05” larger in diameter than the barrel thread. This is to ensure adequate contact surface to tighten the nut against during installation. For example, on a 5/8-24 threaded barrel, the barrel shoulder needs to be a minimum of .675” in diameter for safe installation.

For more information on barrel thread specifications please visit:
https://precisionarmament.com/manuals

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