

INSTALLATION OF BI-LOCK MOUNT

This suppressor is attached to the rifle with ease on a standard sized, proprietary Bi-Lock mount. Proper alignment and mounting of the suppressor is dependent on the care and precision used during installation of the Bi-Lock mount.

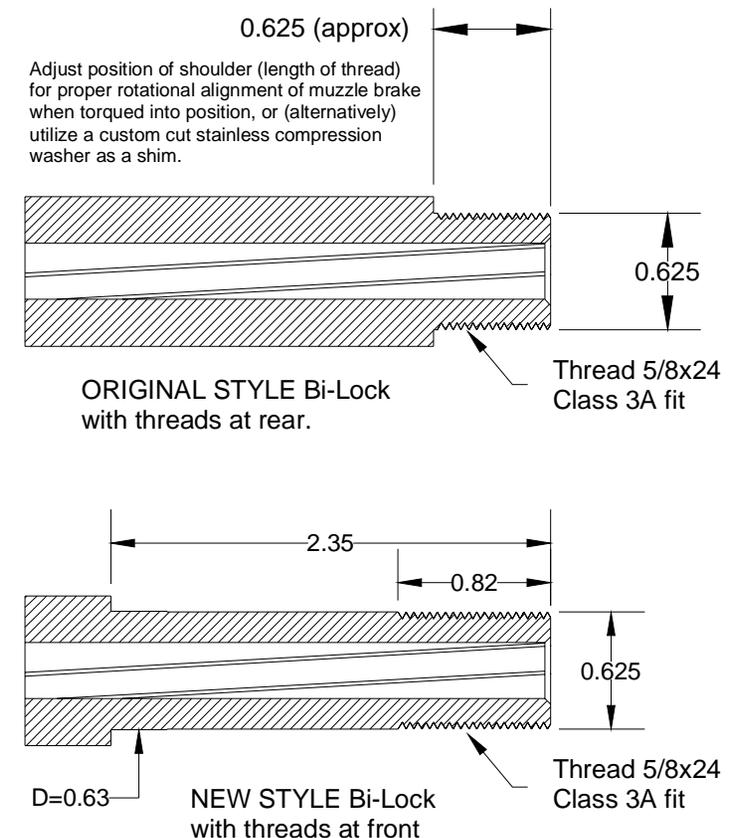
1. The Bi-Lock mount attaches to threads on the muzzle of the rifle. Unless specially ordered otherwise, the Bi-Lock mount is supplied to mount on 5/8x24 NEF Class 3 threads. Our experience has shown that threads smaller than 5/8 inch are more likely to stress relieve the muzzle of the weapon, introducing inaccuracy.
2. Thread the muzzle of the rifle as specified in Fig 1 (P.6) for the Bi-Lock used with 5/8x24 threads (Class 3A fit). For proper alignment, it is essential that the threads be absolutely concentric with the bore of the weapon and that there is a sharp shoulder at the rear of the threads that is 90 degrees to the bore axis. Barrel threading must be performed on a lathe with the barrel turned between centers. The barrel threading procedure is critical, and errors will result in misalignment. (See drawing P. 6). Gemtech can thread the barrel, properly install the Bi-Lock™ mount, and gauge the installation for a nominal fee.
3. Some hand fitting may be necessary. For the original style Bi-Lock, the correct rotational orientation of the muzzle brake is with the lug horizontal and the muzzle brake ports slightly above center. There are several methods of achieving this orientation. Orientation of the new style Bi-Lock is non-critical.
 - a) The simplest is to trim the 90 degree shoulder area on the barrel while in the lathe so that when torqued on, the Bi-Lock™ mount will be oriented properly.
 - b) The second method is to custom cut a stainless steel compression washer to act as a shim. If using this method, it is important that the washer be fabricated with both sides parallel. We recommend against the use of an aluminum compression washer, because the different rate of expansion will change dimensions and tension during heating caused by shooting. This can affect group size as a function of barrel temperature.
 - c) We suggest against trying to trim the back of the Bi-Lock™ mount to achieve proper fit.
4. Whichever method of insuring rotational position is utilized, proper orientation must allow for torquing the Bi-Lock™ into final position. We have found that the process of final tightening will rotate the Bi-Lock™ an additional 15-20 degrees.



WARNING



☞ Failure to follow installation instructions detailed in this flyer can result in potential for serious injury to the user and damage to the weapon.



BARREL MUZZLE THREADING
Specifications, Bi-Lock TPR-S/M24 Mount

FIG 1

5. Thread Adhesives: There are two acceptable thread adhesives to prevent unscrewing during sustained (fully automatic) fire. These are Loctite® 620 and Rocksett. Rocksett has the higher temperature rating. For bolt action weapons, Loctite® 272 is acceptable.
6. Degrease all surfaces with acetone or MEK (methyl ethyl ketone). Apply the spacing shim (if used) and the appropriate thread adhesive. Screw on the Bi-Lock™ mount.
7. Using a torque wrench, torque the Bi-Lock™ mount into position utilizing between 20 and 30 ft-lbs. Allow the thread adhesive to set up for at least 72 hours before use. A special installation tool is available from Gemtech which will accept a 1/2 inch drive torque wrench. This tool may either be purchased or rented from Gemtech.

Gemtech Mounting Services

If you prefer to have the TPR-S Bi-Lock mounted by Gemtech, this service can be provided for a nominal charge. Gemtech can also provide barrel threading services. Please contact us by telephone for shipping instructions. Before shipping, be certain to remove all optical sights, sight bases, and stocks. At the time of this printing, Pricing is as follows:

| | |
|------------------|--------------------|
| Thread Barrel: | \$85 |
| Mount Bi-Lock: | \$25 |
| Return Shipping: | Actual UPS charges |

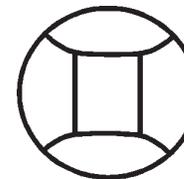
Call for UPS/FEDEX shipping address.

THREAD MOUNTING SUPPRESSORS

For thread mounting (non Bi-Lock QD) suppressors, threading is the same as for the "Old Style" Bi-Lock shown on P. 3, top illustration.

Bi-Lock Mounting Instructions

GEMTECH Suppressor Model TPR-S



GEMTECH
Div. of Gemini Technologies, Inc.
P.O. Box 140618
Boise, Idaho 83714
(208) 939-7222

ISSUED: February 25, 2003