

SONS OF LIBERTY GUN WORKS



NOX Muzzle Device Installation Guide

Ensure all firearms are unloaded and no ammunition is present in the area while working on your firearm.

Contents: NOX muzzle device, shim pack.

Tools Required: ½" drive torque wrench, degreasing chemicals (acetone), upper receiver vise fixture or barrel blocks, ¾" crowsfoot wrench or tool,



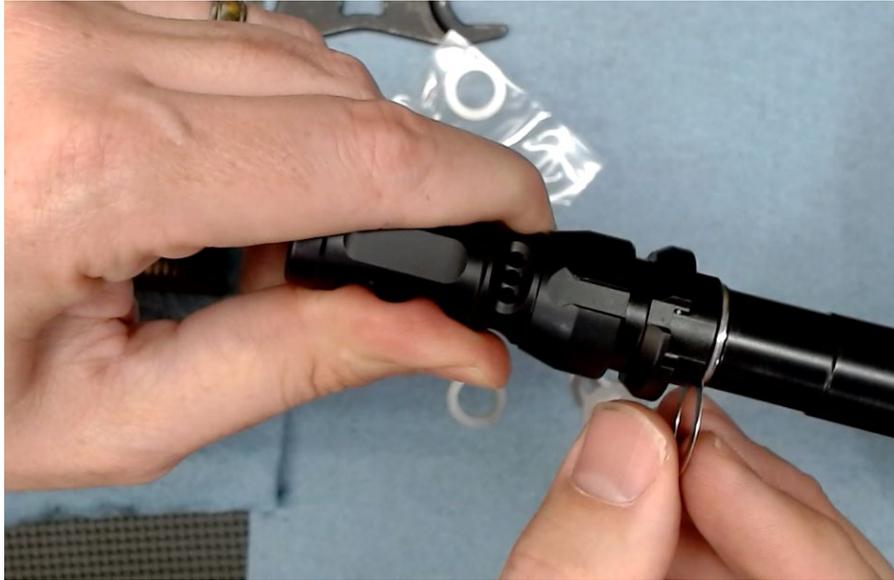
Step 1: Secure your upper receiver in an appropriate fixture so that sufficient torque can be applied to the muzzle device without damage to your assembly

Step 2: Identify if your barrel requires the use of the thickest shim. Barrels with a recess cut below the peak of the threads do not require the thickest shim to be used, however it is certainly fine to still do so. Please note this shim has one side where it is beveled, make sure the beveled side points away from the muzzle device.

TIP: For ease of finding the correct quantity of shims, spin the muzzle device on without any additional shims until it bottoms out. Back off the muzzle device until the designed timing is achieved, then rotate it off an additional approx. 15 degrees.

With the muzzle device just shy of its final intended alignment, slide combinations of the provided shims in from the side between the muzzle device and barrels shoulder (or the face of the thickest shim) until they just fit behind the muzzle device in this position.

Remove the muzzle device, place the shims you tested out over the threads, and test fit the muzzle device for alignment. It should hand tighten to just shy of your intended timing position at this point (roughly 10-15 degrees). Repeat as necessary to find the correct combination of shims.



Step 3: Degrease the muzzle threads and inside of the muzzle device thoroughly and allow them to completely dry. Once dry, carefully add the required shims back over the muzzle without touching the threads with your fingers (or anything else potentially containing any oils/ contaminants).

Step 4: Add Rocksett to the muzzles threads and hand tighten the muzzle device into position.

Step 5: Fit the 3/4" wrench onto the flats at the rear of the NOX, insert your torque wrench into to the 3/4" wrench, and tighten the muzzle device to the designed position (timing).

NOTE: It is important not to exceed 30 ft/lbs during this process. If you begin to approach 30 ft/lbs and it's not timing properly, stop, clean all of the threads of the Rocksett, and start over with a different combination of shims.



NOTES:

Degreasing the threads prior to installation is critical. The overwhelming majority of muzzle devices coming loose is due to improper surface prep (degreasing).

If pinning and welding the muzzle device in position, using a threadlocking agent is not required and is likely counterproductive.

If using Rocksett, allow it to cure fully (24 hours) before using the firearm, or stressing the mount. You may mount a suppressor to test for alignment immediately, but do not tighten the suppressor onto the newly installed mount more firmly than the torque you used to attach it, or you may take it out of alignment before the Rocksett has fully cured.

Rocksett does have a shelf life, and if you observe any cloudiness or separation in it, it may not hold as intended. If in doubt, replace it.

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