

DILLON

RIFLE COMPANY

SUPPRESSOR MANUAL



TABLE OF CONTENTS

Installation & Alignment	2
Removal Procedure	10
Firing Schedule	10
Maintenace	11
Demil Procedures	18

INSTALLATION & ALIGNMENT

These suppressors are designed to be used with the calibers listed in their individual specifications. The suppressors are supplied with a direct thread adapter but may also utilize other brands of adapters/muzzle devices. The 9mm suppressor can utilize boosters (linear decouplers) for handgun cycling.

Caution: Clear your firearm before installing your suppressor, visually and physically ensure there is no ammunition in the chamber, on the breach face and in the magazine well.

Adapter installation: thread the provided adapter into the rear of the suppressor and torque to 20 ft/lbs. Ensure the barrel muzzle threads are clean and free of debris.

Thread the suppressor and adapter assembly onto the barrel and torque to 30 ft/lbs. Before each use ensure that your suppressor is tight, and the bore alignment is checked with one of the following recommended alignment rods.

Recommended alignment rod brands: Surefire, Geissele, and Accuracy Solutions

For non-supplied adapters use manufacturer's instructions and always use an approved alignment rod to check bore to suppressor concentricity before firing to avoid damage or injury. See alignment examples provided Figure 1.

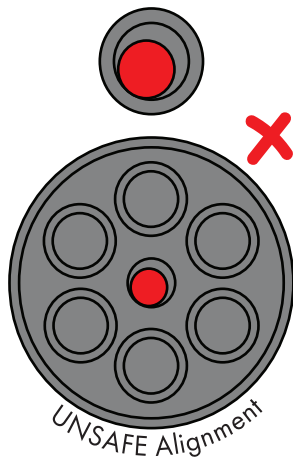
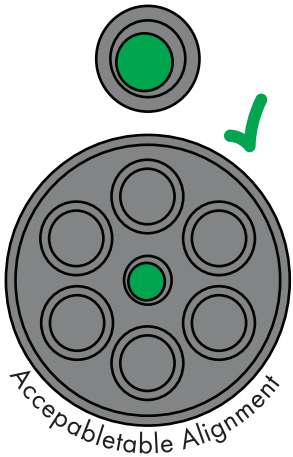
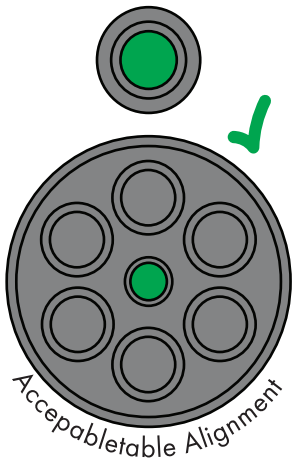
WARNING: Any mismatch of caliber or barrel threads may result in death, severe injury, or property damage and it will void any and all warranty on the product.

WARNING: It is the responsibility of the user to ensure the suppressor stays securely threaded to the barrel of the host firearm during use. Failure to do so may result in death, severe injury, or property damage.

GENERAL ALIGNMENT ROD CHECKS

(See rod manufacturer for specific instructions)

- Carefully insert alignment rod down bore of the suppressor and into the host firearm bore until the end of the rod is almost flush with the end of the suppressor.
- Observe alignment and confirm rod is positioned near the center of the suppressors exit bore. (refer to Figure 1 on the next page).



- If the mount and suppressor are in alignment the rod will not touch the suppressor's exit bore.
- If the alignment rod is making contact with the suppressor's exit bore, do not shoot your firearm with the suppressor mounted. Contact a qualified gunsmith for trouble shooting.
- See your alignment rod manufacturer for their specific instructions.

WARNING: Remove the rod before shooting! Failure to do so may result in death, severe injury, or property damage.

A strenuous multi-step inspection process is performed to ensure the tolerances of your suppressor and provided adapter are safe for your application.

If you are encountering difficulty when checking the alignment of your suppressor with one of the approved alignment rods, contact a qualified gunsmith for trouble shooting to determine if one of the following is the cause:

- Incorrect barrel threads
- The barrel threads machined are not concentric to barrel bore
- Dirt/debris
- Improper adapter installation
- Improper or defective muzzle device and/or adapter
- Damaged muzzle crown
- Suppressor manufacturing malfunction

If you are uncertain about the alignment, please contact Dillon Rifle Company:

Email: sales-support@dillonriflecompany.com

REMOVAL PROCEDURE

Clear your firearm before removing your suppressor, visually and physically ensure there is no ammunition in the chamber, on the breach face and in the magazine well.

Allow the suppressor to cool sufficiently for safe removal. Unscrew from muzzle. Depending on the amount of torque applied during installation, an adjustable flat wrench may be necessary to aid in removal.

For all non-supplied adapters, refer to manufacturer's instructions for removal.

FIRING SCHEDULE

The suppressors are designed for limited full auto firing (90-120 rounds fired in bursts),

a 10-minute cool down to ambient temperature should be allowed.

CAUTION: Excessive full auto fire can cause excessive debris and heat to build up in the suppressor and firearm and cause damage to both, such as, but not limited to, ammunition cookoff and baffle strikes.

MAINTENANCE

Cleaning the suppressors is a simple but important part of ownership. Much like maintaining the air filter on your car or air conditioner, fouling will accumulate with use over time and needs to be addressed for maximizing the effectiveness of the system. Regular cleaning and proper maintenance will increase the performance and lifespan of the suppressor. The exact round count at which to clean the suppressor is highly

dependent on the combination of the host weapon, barrel length, and ammunition choice; a good general guideline is to run a cleaning cycle on the P.I.P. (Purposely Induced Porosity) at the muzzle end of the suppressor around the 1,500-round mark for centerfire rifle cartridges and 1,000-rounds for centerfire pistol cartridges. A full head-to-toe cleaning cycle of the suppressor is recommended around the 5,000 round mark regardless of caliber.

There are several effective suppressor cleaners that are safe for the titanium construction of the suppressor line as well as the PVD coating. These include (but are not limited to) C.A.T 206, Breakthrough Suppressor Cleaner, and Bore Tech Decimator. To date, our testing has shown C.A.T. 206 to be the most effective solvent for cleaning.

The process for cleaning is a simple two or three step process based on the equipment you have available to you.

Note: We highly recommend the use of an ultrasonic cleaner (these are readily available for a reasonable price) to increase the effectiveness of cleaning, but it is not required.

Soaking

1. Find a suitable vessel in which to place the muzzle end of your suppressor to allow it to be saturated in the solvent of your choice. Clear cups are a cost-effective option, but a glass mason jar, solvent safe plastic cup, or a Breakthrough Suppressor Cleaning Kit work perfectly well.

2. Fill your vessel up approximately 2"-3" with your solvent of choice and place your suppressor muzzle down inside. Allow the P.I.P. (Purposely Induced Porosity) muzzle end of the suppressor to soak in the cleaner anywhere between 4 and 12 hours, depending on the severity of fouling. If required, it is ok to soak beyond the recommended cleaning schedule. If able, slight agitation every-so-often is helpful but not necessary.

3. OPTIONAL BUT RECOMMENDED STEP: If you are using an expensive solvent, fill an ultrasonic cleaner with at least 2" of water then place the suppressor still inside the vessel holding the solvent used in the previous steps into the sonic bath to agitate it. If you are using a cost-effective solvent, place your suppressor in a sonic bath filled up with at least 2" of the solvent of your choice. Follow the manufacturer's instructions.

Some solvents may be incompatible or dangerous for use with your ultrasonic cleaner. Run the sonic bath machine for approximately 30 minutes on the vibration cycle. This cycle is more powerful than static soaking and will aid in breaking up fouling that is far beyond what would be accrued by the recommended schedule.

Rinsing

1. Remove the suppressor from your solvent vessel and thoroughly rinse with water from both the front and rear of the suppressor.
2. Once most of the retained solvent is flushed, plug the muzzle end of the suppressor with the palm of your hand and fill the suppressor approximately halfway with clean water. Plug the mounting end with your other palm and vigorously agitate the water

trapped inside. Pour the water out and repeat this process until the liquid leaving the suppressor looks unchanged.

3. OPTIONAL BUT RECOMMENDED STEP: Place your suppressor back into the sonic cleaner and run a short cycle to remove whatever stubborn residue is left on the inside.

4. We recommend allowing the suppressor to fully dry out before use to minimize the possible inhalation of chemicals from gas blowback. Use of compressed air to expedite this process can be helpful.

This cleaning cycle mostly focused on the muzzle end of the suppressor. A full head-to-toe cleaning cycle of the suppressor is recommended around the 5,000 round mark

regardless of caliber. This simply involves filling the suppressor fully with solvent versus the lower level in the above steps. When used in conjunction with the lower round count cycle, your suppressor should stay effective for many rounds to come.

Note: If using the 9mm suppressor heavily on a pistol caliber carbine, it may be necessary to do an inverted version of the cycle outlined above before switching to pistol suppression. This will clean out the locking recesses of the booster cage within the blast chamber. Failure to do so may result in misalignment of the piston and cause damage to the suppressor. Because the user has direct access to this portion of the suppressor, it is recommended they use brushes, picks, and other tools to aid in and expedite this process.

DEMIL PROCEDURES

Suppressors are classified as a code "D" item. It is required by law that to eliminate a code "D" item, it must be reduced to the level of scrap that prevents restoration or repair to a usable condition to meet the requirements of the DoD Demilitarization (DEMIL) Program. DoDM 4160.28, Vol 2, "Defense Demilitarization: Demilitarization Procedures," November 1, 2022 (whs.mil).





www.dillonriflecompany.com