



Permanent Installation of muzzlebrakes and flash hidrs

Rifles must have a barrel length of at least 16 inches with an overall length of 26 inches to be legal unless you possess the proper SBR (short barreled rifle) permits. If you do own such a permit, a Form6 transfer must be completed or you must physically be here during the project. For those that have an SBR permit or just want the part to be permanently attached please read on.

Permanent attachment is achieved in 3 ways here to comply with BATFE requirements. They are:

- **Welding** – part is welded to the barrel and the weld is dressed down. I do not like to do this because of the heat distortion and finish damage.
- **Silver Soldering** – part is soldered on with high temperature Silver Solder (I use Brownells silvaloy 355) with an oxygen-acetylene torch. BATFE has informed me that if the part can not heated and removed with the average home propane torch or plumber's torch that it is considered permanent attachment. I do this for slip on and threaded parts, usually before refinishing. The heat is not too bad and the finish can be salvaged if it gets damaged. Stainless rifles will usually require a bead blasting to return the finish to its original state.
- **Blind Pinning** – involves drilling a hole into the muzzlebrake or flash hider and the outside circumference of the barrel. This hole does not go all the way through the other side. A pin is made slightly shorter than the hole is deep, and inserted to lock the part in place. The pin will typically be further secured with solder or epoxy. Since it can't be driven through and out, or grabbed to pull it out, it is considered permanent. There is no finish damage with this procedure other than a little touch up blue around the hole.

With the part permanently attached, it becomes part of the barrel and therefore counts as inches in length. A barrel could be 14 inches in length with a 2 inch permanent brake for 16 inches total as an example.

Parts that slip over the front sight and pin in place are not made permanent here.

Attempting to remove a permanent part is illegal and will damage the barrel. If you decide to have a permanent part attached, make sure it is really what you want before having it done.

All barrel lengths from Great West Gunsmithing are a 16¼ inch minimum. This extra ¼ inch is for your protection and mine. It allows for a difference in measuring sticks and allows for any touch up work to be done to the part later if needed. *All barrel lengths are measure from the closed bolt to the end of the muzzle.* That's the proper method of measuring the barrel length. When your rifle returns, the barrel will be legal length by that measurement.