



Mad Minute Suppressors
Field Instructions
Tempest II
.30 CAL
Direct Thread

OPERATIONAL LIMITATIONS

1. 21x30 round magazines of semi-auto fire with intermittent 10-15 round bursts without cooling
2. 5x30 round magazines of full-auto fire without cooling
3. Aggressive firing sequences that result in red glow mid suppressor – If orange glow is reached, terminate firing immediately and allow to cool to suppressor's natural color before resuming firing – return to armorer for inspection at next opportunity
4. Firearm manufacturer's limitations or above, whichever is least severe – always refer to the firearm manufacturer's recommended limitations before firing

MAINTENANCE LIMITATIONS

1. Do not exceed 630 rounds without cleaning (see cleaning instructions below)
2. Do not exceed operational or maintenance limitations without full inspection by the armorer or Mad Minute

CAUTIONS-WARNINGS

1. DO NOT EXCEED OPERATIONAL OR MAINTENANCE LIMITATIONS
2. Material damage or bodily injury could occur if instructions, cautions, and warnings are not observed
3. Ensure your firearm is in a cleared and safe condition before installing, removing, or performing any maintenance on the suppressor
4. A small amount of residual powder and machining shavings may have remained inside the suppressor's internal lattice – this is normal, it is not a safety hazard, nor will it impact performance – this residual material will clear from the suppressor in the first 5 to 10 shots
5. Before installing the suppressor, ensure the threads of the suppressor and the barrel are clear of debris and clean - the suppressor must be tightened to the weapon barrel using approximately 20-30 ft-#s of torque, or the weapon manufacturer's recommended torque – the flats on the suppressor support a 13/16" standard wrench – if spacers are required for proper seating of the suppressor (no gap between the barrel shoulder and the threaded end of the suppressor with the suppressor tightened by hand), use only spacers supplied by Mad Minute, or an equivalent – do not use crush or cut washers as they do not support alignment requirements
6. Use only ammo consistent with the firearm manufacturer's instructions
7. Suppressors get hot quickly – do not handle the suppressor until cool or without sufficient heat protection
8. Carbon and copper will build up on the internal surfaces of the suppressor and threads, especially under extreme firing sequences – over prolonged use, these deposits may cause a degradation in suppressor performance – to avoid long-term build-up, the suppressor should be cleaned at regular intervals (see maintenance and cleaning instructions below)



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9. When first using the suppressor, it may smoke slightly with aggressive firing sequences – this is normal as residual machining fluid is heated – smoking should stop within 30-60 rounds
10. Remove the suppressor from the firearm prior to performing any maintenance on the suppressor
11. Firearm discharge may result in build-up of toxic material internal to the suppressor – do not perform maintenance on the suppressor without proper protection and ventilation
12. The condition of the suppressor should be assessed regularly – the operator should conduct a quick assessment of the condition of the bore, alignment, and tightness – any degradation should be reported to the armorer - a more thorough check of the internal condition of the suppressor should be conducted by the armorer at established maintenance intervals – minor localized wear is normal with extreme firing sequences and will not affect suppressor performance or safety – if significant damage is observed, the suppressor should be retired and damage reported to Mad Minute for resolution

MAINTENANCE

1. Perform maintenance on the suppressor only if authorized by your commander and supported by operational and maintenance doctrine
2. Pay close attention to threading directions – Direct Thread suppressors are right-turn on and left-turn off, following same directions as your original muzzle device
3. Use only tools and solutions approved by the armorer – firearms cleaning solutions that remove build-up of copper and carbon are recommended to support cleaning (see cleaning instructions below) – these solutions may be used with a sonic cleaner for maximum effect
4. Follow Pre-op Inspection, Assembly, and Cleaning instructions below

PRE-OP INSPECTION AND ASSEMBLY

1. Refer to the weapon, barrel, and original muzzle device manufactures' instructions for removal of the original muzzle device
2. The suppressor should be examined by the operator and/or armorer prior to installation – the suppressor should not be installed or used if significant damage is observed – threading of both the barrel and suppressor should be clear and clean prior to installation
3. With the weapon in a clear and safe condition, place the thicker (1/8" thick) spacer on the barrel and then turn the suppressor on lightly by hand until the suppressor stops – attempt to spin the spacer with your finger, if you can't spin it, then tighten the suppressor further using a standard 13/16" wrench and 20-30 ft-#s of torque (at this point, the suppressor is fully installed and the weapon is ready to be fired and zeroed) – if, however, the spacer can be spun, remove the suppressor, install a second spacer, and then re-install the suppressor by hand using light force until the suppressor stops, then tighten the suppressor further using a standard 13/16" wrench and 20-30 ft-#s of torque (at this point, the suppressor is fully installed and the weapon is ready to be fired and zeroed)



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DISSASSMBLY

1. Ensure the weapon is in a clear and safe condition
2. If the suppressor is hot, allow to cool before attempting removal – significant force may be required after aggressive firing sequences – follow the barrel or weapon manufacturers' instructions for muzzle device removal to avoid damage to the barrel and weapon

CLEANING

1. Use a container or sonic cleaner that will allow for complete submersion of all suppressors you are attempting to clean
2. Mix the cleaning solution with water to two times the strength recommended by the solution manufacturer – this will accelerate the breakdown of copper and carbon and will not harm the suppressor – Mad Minute uses Hornaday® One Shot® Sonic Clean Gun Parts Formula cleaning solution
3. Place the suppressors in the container until they are completely submerged – turn the suppressors 2-3 times to ensure the solution penetrates all internal areas of the suppressors – alternately seal the container and shake gently to allow air bubbles to escape from the suppressor
4. Remove the suppressors after 24-48 hrs. and drain – use of sonic cleaners with cleaning solutions will accelerate cleaning – Mad Minute uses Lyman® Sonic Cleaners
5. Remove residual copper and carbon from bore, threading and shoulders using standard firearms cleaning tools
6. Once clean, inspect the suppressor for damage - retire if significant damage is noticed
7. At earliest convenience, re-attach to the weapon and fire 5 rounds to clear the suppressor

If you have any question or issues, please contact me.

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