



S U P P R E S S O R S

FIELD MANUAL
S22 - STEALTH - RECON - EXR
Aluminum Suppressor



Please follow the instructions in this field manual and strictly follow the warnings within.

MADE IN USA: 100% made in the USA. Nothing says proud to be an American like Stealth Project.

MANUFACTURERS DISCLAIMER: The manufacturer is not responsible for improper use of this product. This product can be dangerous, therefore it is the user's responsibility to understand and implement its proper use. If you do not understand instructions in this manual please contact the manufacturer for further clarification.

FIREARM SAFETY RULES

1. **ALWAYS** treat every gun as if it were loaded.
2. **NEVER** point any gun, loaded or unloaded, at any undesired target.
3. **ALWAYS** be sure of your target, what lies beyond, and the safety of bystanders before you shoot.
4. **ALWAYS** use clean, dry, original factory-made ammunition of the proper type and caliber for your gun.
5. **ALWAYS** use ear protection and safety glasses when shooting.
6. **NEVER** leave an unattended gun loaded. Guns and ammunition should be stored separately, locked if possible, beyond the reach of children, irresponsible adults, and unauthorized users.
7. **NEVER** allow your firearm or suppressor to be used by anyone who has not read and understood this owner's manual and the owner's manual to your firearm.
8. **ALWAYS** be sure the barrel is clear of any obstruction.
9. **NEVER** drink alcoholic beverages or take drugs before or during shooting, as your vision and judgment could be seriously impaired.

SHOOTING The S22, STEALTH, RECON, and EXR.

These model suppressors are not full auto rated. Shooting full automatic fire or successive semi-automatic fire will produce premature wear and can void warranty. Shooting limits are 20 rounds maximum for standard calibers and 8 rounds MAXIMUM for magnum calibers of rapid shooting followed by a cooling period to less than 120° F temperature before continuing to shoot, or 3 rounds per minute sustained shooting.

.22 LR has a rating of 100 rounds of rapid fire or 30 rounds per minute sustained on S22 specific suppressors

WARNING: Failure to follow installation and maintenance instructions detailed in this manual may result in serious personal injury and damage to the host firearm and/or purchased product. Firearm sound suppressors are user-attached firearm muzzle devices, and as such, are subject to improper attachment issues unless the procedures outlined in this manual are followed precisely. Do not attempt to use this product unless you have specific training and experience in the use of firearms. Because suppressed firearms make less noise than unsuppressed firearms, it is easy to forget that they are still firearms and capable of causing bodily injury and property damage. It is of vital importance to remember that a suppressed firearm is just as dangerous as an unsuppressed firearm, and that the same safe handling requirements still apply. Check the fit between barrel and suppressor before firing! The thread mount must be fully shouldered on the barrel. There should be no visible gap between the barrel shoulder and the face of the suppressor thread mount. If there is any gap, DO NOT fire the host firearm with the suppressor attached. Poor accuracy and product damage may result if the suppressor is not fully shouldered. Assembly and disassembly should never be performed while the suppressor is affixed in any manner to a host firearm. Always completely remove the Suppressor from the host firearm before assembly and/or disassembly is attempted.

ATTACHING SUPPRESSOR TO FIREARM

WARNING: Before performing maintenance, removing the suppressor, or installing the suppressor, open the action, ensure firearm is unloaded, and be sure the chamber is empty and visibly clear of ammunition. Failure to do so can result in property damage, injury or death.

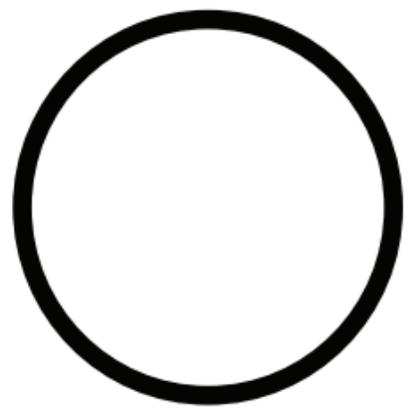
WARNING: NEVER install or remove a suppressor on a loaded firearm. If you are at all unsure as to the proper procedures to ensure that your firearm is unloaded, please consult your firearm manufacturer user's manual/instructions and contact a properly licensed dealer or the manufacturer of your firearm.

1. Unload your firearm in accordance with its manufacturer's user manual.
2. Verify the firearm caliber matches the caliber of the suppressor purchased or the caliber range of the suppressor.
3. (If applicable) Remove flash hider or muzzle brake from the barrel using an appropriate wrench. Remove the crush washer (NOTE: CRUSH WASHERS MAY NOT CRUSH UNIFORMLY; USING THEM MAY CAUSE MISALIGNMENT OF SUPPRESSOR CAUSING BULLET STRIKES AND SEVERLY AFFECT FIREARM ACC URACY AND POTENTIAL DAMAGE TO SUPPRESSOR.)
4. Simply thread the suppressor onto the barrel hand tight, then using a wrench torque suppressor to 15 ft/lbs of torque or as tight as you can with one hand. Be sure not to cross thread the threads of the firearm or suppressor, if the suppressor does not thread easily, STOP, verify the problem before continuing.

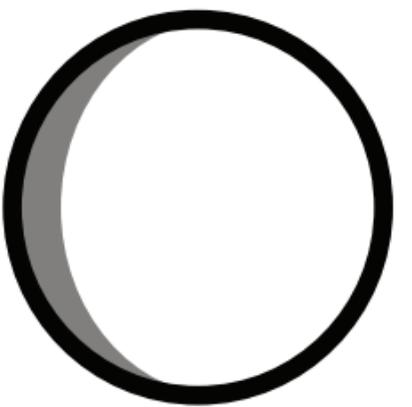
ATTACHING SUPPRESSOR TO FIREARM

5. Before loading firearm with the action open, check concentricity of the firearm barrel threads and the bore of the firearm barrel. This can be done by looking through the firearm barrel bore with the suppressor attached, looking in the breach end TOWARDS the muzzle end (suppressor end) and verifying concentricity.

Concentricity means you will see a perfectly round hole when looking through the bore, you should not see signs of misalignment. For example a shadow similar to a crescent moon anywhere around the outer edge of the bore means it is not concentric. (See example).



ALIGNED



**NOT
ALIGNED**

NOTE: (Suppressor concentricity needs to be done with each firearm intended for use with the suppressor). If you do not feel capable of confirming concentricity, take your firearm to your suppressor dealer. Most suppressor dealers that provide gunsmithing services have suppressor alignment check rods and other tools capable of fitting your suppressor to your firearm. Ammo used is up to the owner to decide, bullets fired through the suppressor must be stabilized. Make sure to use the correct loaded ammo per barrel twist rate to ensure the bullets will be stable. It is the responsibility of the user to know the recommended twist rate from the ammunition manufacturer and verify that the host firearm's barrel matches those recommendations.

WARNING: NEVER force the threaded fit on the suppressor as this could damage the threads on the suppressor, muzzle attachment, or the firearm.

WARNING: DO NOT fire non-jacketed frangible or pre-fragmented ammunition, this may cause damage to the product and will void the warranty.

REMOVING SUPPRESSOR FROM FIREARM

After firing: Verify the firearm is unloaded with the action open and visibly clear of ammunition. Simply remove by unthreading the suppressor from the barrel or muzzle device.

WARNING: When removing the Suppressor, use **extreme caution** as it may be hot to the touch after firing. Use gloves to avoid burns.

Never allow a hot suppressor to come into contact with anything. Allowing a hot suppressor to come in contact with anything could result in fire, personal injury or death or other injuries.

DISASSEMBLY AND CLEANING

WARNING: Remove the Suppressor from the host firearm following the installing and removing warnings before disassembly of the suppressor

- 1.** holding the wrench firmly on the proximal end (end that attaches to firearm) turn the other end counterclockwise to remove the endcap.
- 2.** holding the outer tube firmly, turn the proximal end counterclockwise to loosen the outer tube. Set the wrench aside and grip the proximal end of the suppressor core firmly and either side, slide the outer tube off, or twist and pull the outer tube in a counterclockwise motion to remove the outer tube. After significant use some soot will deposit in between the helical flighting, in this case, the outer tube will twist off counterclockwise like a screw.
- 3.** Using solvents, nylon or copper wire brushes, (Stainless Steel Brushes can diminish the life of the suppressor) clean the entirety of the suppressor core and inside of the outer tube. **DO NOT USE SANDPAPER TO CLEAN ANYTHING**, this can decrease the life of the suppressor.

ASSEMBLY

1. Using oil or grease, lubricate the outer tube where it contacts the suppressor core and endcap, also lubricate the threads on the endcap.

2. Slide the serial number end of the outer tube over the suppressor core first until it firmly contacts the seal of the suppressor core. **IMPORTANT:** Make sure there is no dirt or debris anywhere on the seal area, dirt and debris will cause your suppressor to not seal properly and have a gas leak decreasing its sound reduction.

3. Make sure the endcap is clean and lubricated then thread it on hand tight.

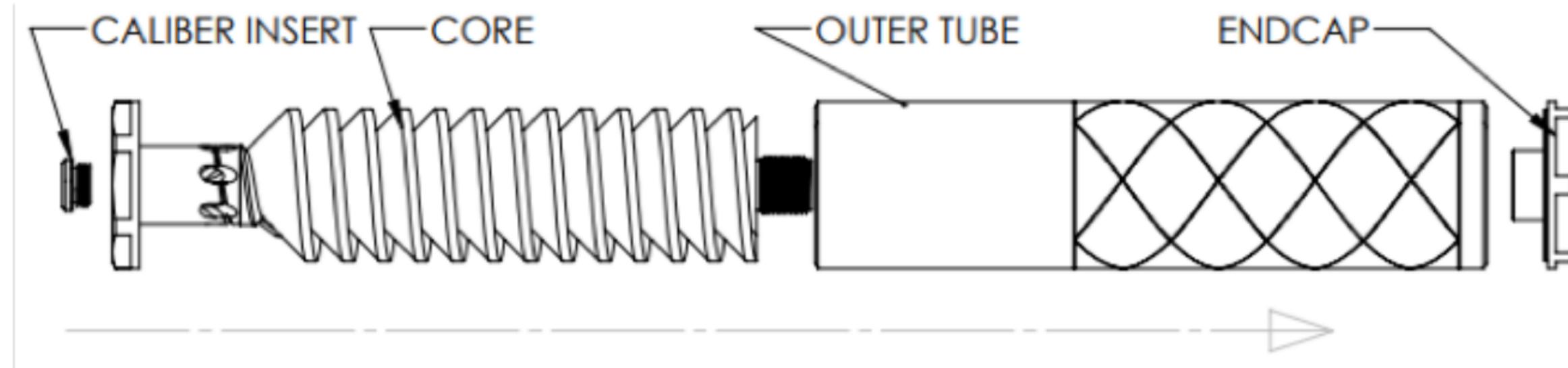
- S22 torque to 10 ft/lbs
- Stealth torque to 15 ft/lbs
- Recon and EXR torque to 20 ft/lbs

NOTE: (If a torque wrench is unavailable, hand tighten the endcap as tight as possible, then using a wrench on both model suppressors tighten the endcap 90° or ¼ turn.)

ASSEMBLY

4. Install caliber insert if it has been removed. To install use a wide face flat head screwdriver to screw the insert back into place lightly hand tight.

5. Thread the suppressor on your firearm barrel and the suppressor is ready for use.



LIFETIME LIMITED WARRANTY

The Stealth Project products are warranted against all manufacturing defects in materials and/or workmanship and damages caused by the normal use of this product for the life of the product from the date of purchase. Stealth Project will repair or replace free of charge any suppressor manufactured by, or at the direction of, Stealth Project LLC. The product is sold "as is" with no further implied contractual rights or warranties beyond those expressly stated herein.

This warranty applies to the original purchaser and is not transferable. This warranty applies only to purchases made in the United States of America. The warranty does not apply to certain conditions or acts. It is at the sole discretion and determination of Stealth Project LLC if a particular defect or condition is covered by this warranty. Conditions not covered include, but are not limited to: modifications, abuse, neglect, use of defective ammunition, use of improperly sized ammunition, and criminal conduct. Stealth Project LLC assumes no liability for damages or bodily injury caused by such acts or omissions as previously described. Abuse and neglect are defined as usage outside of the reasonable scope for which the product is intended, thus contributing to the accelerated and unreasonable premature wear of the suppressor itself.

LIFETIME LIMITED WARRANTY

Stealth Project shall not be liable for any consequential, incidental, or contingent damages whatsoever. Some states do not allow the exclusion of incidental or consequential damages, so the above limitation or exclusion may not apply to the original purchaser. This warranty gives the original purchaser specific legal rights, and the original purchaser may have other rights, which vary from state to state. Stealth Project will repair or replace the product (subject to availability) if defective under warranty. Go to stealthprojectllc.com or email sales and support at sales@stealthprojectllc.com for instruction on how to submit a warranty claim. **DO NOT SHIP THE SUPPRESSOR FOR REPAIR WITHOUT FIRST CONTACTING CUSTOMER SERVICE AND DO NOT SHIP IN ANY EVENT WITHOUT A COPY OF THE APPROVED BATF FORM.** When you ship the suppressor back to the manufacturer, please include a detailed statement concerning the type of defect or malfunction encountered and describe the ammunition used and type of host weapon the product was used on or attached. If for any reason your suppressor is not eligible for repair or replacement, you may purchase a replacement suppressor for 50% off the MSRP for a same or similar suppressor. Please contact our Customer Service Department for further details and requirements.

Thank you for your continued interest and support for Stealth Project and its products.



For more Information visit: **StealthProjectLLC.com**