



Instructions and information for the KA-1212BR breacher ass'y

KA Publication PM08-002
Last updated 9/01/13

The KA-1212BR breacher ass'y is a precision-machined 12-port brake/breacher designed to improve the performance of most standard 12ga shotguns. The unit is compatible with most pump, single-shot, or semi-automatic systems and can usually be installed with a minimum amount of tools and effort.

The breacher is designed to provide several performance improvements; (1) reduction of recoil, (2) reduction of muzzleflash, (3) redirection of muzzleflash away from sights, (4) more consistent patterning (5) allow breaching of doors by use of specialty ammo and direct muzzle contact. By diverting blast laterally from behind the escaping slug/shot wad, there is less effect on the shot column or slug once it achieves free-flight after leaving the brake. This diversion of blast also helps reduce the amount of debris directed back at the operator when used in a breaching capacity. The 'teeth' on the end of the breacher allow the attachment to keep the shotgun held in place when used in the breaching capacity. KA will not be held responsible for any damages/loss resulting from the use of the KA-1212BR in breaching/contact applications as it is a hazardous activity, our goal is only to make it less hazardous.

Installation Instructions for KA-1212BR breaching attachments

Note: Read the entire instructions before proceeding. There is useful information throughout this guide and it is helpful to know all aspects of the installation procedure before starting the installation.

1. First and foremost, ensure that the firearm is unloaded. Any repairs/modifications performed on a firearm require that the utmost safety precautions are taken. If possible, the barrel should be removed from the shotgun entirely.
2. The barrel will need to be measured to ensure that the outside diameter of the barrel corresponds with the KA-1212BR breaching attachment that you have purchased. Due to some variations in dimensions and tolerances from some shotgun manufacturers, it would be prudent to ensure the dimensions are correct before working on the barrel.
3. The barrel will need to be cut to the desired length if the barrel is to be shortened from its original dimensions. Be advised, federal regulations regarding the National Firearms Act of 1934 prohibit the unregistered manufacture or modification of a shotgun in any way which would result in a barrel length under 18" or an overall weapon length of under 26". It is advisable to not shorten a barrel to less than 18.25" to err on the side of caution unless you are planning on using high-temp (>1100°F) silver solder or any other method that counts as "permanent attachment" by the BATF (we do not recommend brazing as it requires heating the barrel and KA-1212BR to a much higher temperature). Optimally the barrel should be cut in a lathe to ensure an even, precise cut that will allow a perfect fit and no gaps between the brake and the end of the barrel. Measure the inside diameter of the barrel, it should not be more than .742". If the barrel I.D. is greater than .742" DO NOT install the brake, contact us for technical support.
4. The cut (or original length) barrel will now need to be re-measured at the last .750" length of the barrel. The barrel may need lapped to provide the necessary .001-.002" tolerance needed to provide a tight yet effortless install. If the brake fits loosely (i.e. can be wobbled) then STOP and DO NOT install the breaching attachment, contact us for technical support as the barrel may be different sized than standard and may require a more precisely sized breaching attachment.
5. Scribe a line along the centerline of the barrel where the bead or sight will be located. The breaching attachment should slide completely onto the last .750" of the barrel without requiring any forcing/hammering. If using silver solder, at this time make sure that the metal is properly prepared and apply flux to the inside of the mounting collar on the KA-1212BR and to the outside of the barrel. Slide the KA-1212BR back in place and index/align it on the barrel so that the 6-48 bead hole is in line with the scribed line on the barrel.

6. Set the barrel assembly up in a vise or other fixture so that the barrel is standing vertically with the muzzle end down and resting in the KA-1212BR. This will help the solder to flow evenly and will help prevent flow into the bore. Once secured in the vise/fixture, make sure that the scribed sight line is still in line with the 6-48 bead hole. Carefully and evenly apply heat, primarily to the mounting collar, not to the barrel or the rest of the KA-1212BR. Apply solder to the joint until the seam is filled all the way around.

7. Allow the finished ass'y to air cool until it is safe to handle. DO NOT water quench, this will affect the temper of the barrel and KA-1212BR, and may cause the solder bond to break/weaken. The finished ass'y will now need to be inspected and refinished. Be sure to carefully inspect and clean the bore to remove any flux and to ensure that no silver solder flowed into the inside of the brake or barrel.

8. At this point the firearm may be test-fired. The report of the shotgun will sound different and may be louder, but should be consistent. If you notice any change in the sound of the report from shot to shot, unload the shotgun, remove the barrel and inspect for obstruction or other abnormalities before proceeding. If properly installed, the performance of the shotgun should *improve*. Inspection by a qualified gunsmith or by King Armory is advisable if there are any *negative* changes in the performance or patterning of the shotgun. After the first 25 rounds, recheck the brake for tightness and fit.

9. When cleaning the shotgun barrel, be sure to run the bore brush and patches through the brake as well. The brake rapidly burns off remaining propellants when fired which reduces muzzle flash, but also causes the interior of the brake and its ports to occasionally develop deposits of soot, lead, and plastic due to the rapid heating and cooling of the escaping gases/debris and the close fit of the brake to the passing slug/wad. Failure to keep the brake reasonably clean can result in reduced performance and possible damage to shotgun or even injury/death to the user. Although the brake is designed to clear itself of excessive soot/debris, due to variations in propellants and ammunition, some brands of shells may cause more buildup than others so manual cleaning is recommended after every outing or 250 rounds, whichever comes first. A .22-.25 caliber bore brush is very helpful in cleaning soot and fouling out of the ports. The brake may be cleaned with any regular bore cleaner and bore brush.

Tips and Helpful Hints

-If the brake binds when slid onto the barrel, lap the barrel with 220 grit abrasive cloth until the recommended .001"-.002" clearance is achieved. Barrel diameter may vary a little due to manufacturing tolerances or finish so some lapping may be necessary in certain applications.

-When removing the factory bead sight to cut the barrel or to install the KA-1212BR, it is advisable to use a straight-edge or scribe on a lathe to mark a reference line on top of the barrel running from the original bead location to the new location for the bead/sight. This will make indexing the KA-1212BR a lot easier as you will just need to line the bead hole in the brake up with the reference line on the barrel. This will ensure that the sight is installed straight and is a lot easier than "eyeballing" the sight location.

Questions or Comments?

If you need to contact us for anything we can be reached at 615-568-7901 from 9AM-7PM MST from Mon-Sat or by email at tech@kingarmory.com. This product is warrantied against manufacturing defects for life, if it fails for any reason, contact us for a RO# and ship it directly back to us for prompt replacement. Thank you for your business and for supporting American jobs and technology.