



ENGAGED INDUSTRIES

RECON XL .338 SUPPRESSOR

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

100% MADE IN USA

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.

Email: sales@engagedindustries.com Phone: 314-514-5539

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.

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.

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.

ATTACHING SUPPRESSOR TO A FIREARM

1. Unload your firearm in accordance with its manufacturer's user manual.
2. Verify the firearm caliber matches the caliber of the suppressor and the caliber insert 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 SEVERELY AFFECT FIREARM ACCURACY AND POTENTIAL DAMAGE TO SUPPRESSOR.)

4.

For Direct thread (DT) Simply thread the suppressor onto the barrel hand tight, then using a wrench torque suppressor to 30 ft/lbs of torque. 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.

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. 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 device, or the firearm.

WARNING: DO NOT fire non-jacketed frangible or prefragmented 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.

WARNING: 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, serious injury or death.

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

SUPPRESSOR MAINTANANCE:

Disassembly:

1. Soak the suppressor in HOT water for 15 minutes to loosen any Ceramic thread locking compound.
2. Firmly secure the outer tube in a Suppressor clamp or Suppressor Vise block. **WARNING! DO NOT CLAMP DIRECTLY IN VISE**, This may cause stress cracks in the suppressor and may cause catastrophic failure of the suppressor and can void your warranty.
3. Removal of DT mount Using a 1 3/8" wrench or socket wrench remove the mount from the outer tube by turning counterclockwise looking at the mount.

Cleaning:

Ultrasonic Cleaning: Titanium is safe for ultrasonic cleaning, which uses high-frequency vibrations to shake off carbon and lead. This is highly effective.

- Solvent Soaking:** Submerge components in a dedicated suppressor cleaner for **12–24 hours**.
- Specialized Solvents:** Products like Cat 206 (designed specifically for titanium/Inconel),
- Common Solvents:** **USE WITH CAUTION** Diluted **Simple Green** (standard version) is popular but be careful as this could damage outer finishes.

Important Precautions

- Avoid "The Dip":** While effective on lead, the mixture of vinegar and hydrogen peroxide creates **lead acetate**, which is highly toxic and difficult to dispose of safely.
- Protect Coatings:** Harsh chemicals and ultrasonic agitation can strip Cerakote or other aesthetic finishes from the outer tube.
- Rinse and Dry:** Always rinse parts thoroughly with water after using solvents and ensure they are **100% dry** (using compressed air or a hairdryer) before reassembly to prevent corrosion or shooting-related damage.

Assembly:

1. Install the mount by turning clockwise using a 1 3/8" wrench and torque to 30-35 ft/lbs

Caliber Compatibility Chart: (NOTE: Determine barrel thread and purchase thread adapter if necessary)

Cartridge	Diameter inches
8.6 Blackout (8.6×43 mm)	0.338
.338 Lapua Magnum	0.338
.338 Winchester Magnum	0.338
.338 Federal	0.338
8×56 R Mannlicher	0.329
8×57 JS Mauser	0.323
7.7×58 Arisaka	0.311
.303 British	0.311
7.62×54 R Russian	0.312
.300 Weatherby Magnum	0.308
.300 PRC (Precision Rifle Cartridge)	0.308
.300 Winchester Magnum	0.308
.30-06 Springfield	0.308
7.62×63 mm	0.308
.308 Winchester	0.308
7.62×51 mm NATO	0.308
.300 Norma Magnum	0.308
.300 AAC Blackout (7.62×35 mm)	0.308
.30 Nosler	0.308
.30 TC	0.308
.30 Rem AR	0.308
.284 Weatherby Magnum	0.284
.284 Winchester	0.284
7 mm Weatherby Magnum	0.284
7 mm Remington Magnum	0.284
7 mm PRC (Precision Rifle Cartridge)	0.284
7 mm SAUM	0.284
7 mm-08 Rem	0.284
7×57 Mauser	0.284
7×64 Brenneke	0.284
.280 Remington	0.284
.270 Weatherby Magnum	0.277
.270 Winchester	0.277
270 WSM	0.277
6.8 Western	0.277
6.8 SPC (6.8×43 mm)	0.277
6.5 Weatherby RPM	0.264
6.5 PRC	0.264

6.5 Creedmoor	0.264
6.5×55 Swedish	0.264
6.5×47 Lapua	0.264
6.5 Grendel	0.264
6.5-284 Norma	0.264
6.5 SAUM (wildcat)	0.264
.257 Weatherby Magnum	0.257
.25-06 Remington	0.257
.257 Roberts	0.257
.250 Savage (.250-3000)	0.257
6 mm Weatherby Rocket (wildcat)	0.243
6 mm Creedmoor	0.243
.243 Winchester	0.243
6×47 Lapua	0.243
6 BRA (wildcat)	0.243
6 Dasher (wildcat)	0.243
5.8×42 mm Chinese (DBP87)	0.236
.224 Weatherby Magnum	0.224
.22-250 Remington	0.224
.220 Swift	0.224
.223 Rem (5.56×45 mm NATO)	0.224
.222 Rem	0.224
.22 Nosler	0.224
.22 Hornet	0.224
.218 Bee	0.224
5.7×28 mm FN	0.224
5.45×39 mm Russian	0.224
.22 WMR	0.224
.22 LR (Long Rifle)	0.224
.22 Short	0.224
.22 Long	0.224
.204 Ruger	0.204
.19 Calhoun (wildcat)	0.198
.17 Hornet	0.172
.17 Rem	0.172
.17 WSM	0.172
.17 HMR	0.172

Limited Lifetime Warranty

Engaged Industries LLC stands behind the quality and craftsmanship of our suppressors. We offer a Limited Lifetime Warranty to the original purchaser, guaranteeing that your suppressor is free from defects in materials and workmanship under normal use for the lifetime of the product.

What Is Covered: Defects in materials and workmanship under normal use. If a manufacturing defect is found, we will repair or replace the suppressor at no cost to you. If replacement is necessary due to a manufacturing defect, we may cover the cost of the ATF tax stamp for the replacement suppressor.

What Is Not Covered: Damage caused by misuse, abuse, or failure to follow operating and maintenance instructions. Unauthorized modifications or repairs. Normal wear and tear, cosmetic damage, or finish wear. Damage caused by use of improper ammunition or accessories. Loss, theft, or intentional destruction. This warranty is non-transferable and applies only to the original purchaser. 3rd party Mounting devices are not covered unless concentricity is verified on each firearm before use by a certified Engaged Industries dealer and pictures or runout results under .012" (12 thousandths) are emailed to sales@engagedindustries.com

How to File a Warranty Claim:

Contact our Customer Service team to obtain a Return Merchandise Authorization (RMA) number before sending your suppressor in for service. Provide proof of purchase and all required ATF documentation with your claim. Ship your suppressor to us as instructed by Customer Service. We will inspect the product and, if a defect is confirmed, repair or replace it at our discretion. Most claims are resolved within 10-14 business days, though ATF processing may delay replacements.

Limitation of Liability: Engaged Industries LLC is not liable for incidental, indirect, or consequential damages, or for personal injury, property damage, or economic loss arising from the use or inability to use the suppressor. For questions or to start a warranty claim, please contact us at 314-514-5539.

Governing Law: This warranty shall be governed by and construed in accordance with the laws of the State of Missouri, without regard to its conflict of laws principles. Any claim or dispute arising from or related to this warranty, including but not limited to warranty service, interpretation, performance, breach, or alleged breach, shall first be brought in the courts of Lincoln County, Missouri, which shall have exclusive original jurisdiction for all such matters. If the matter involves a federal cause of action or is otherwise required to be filed or removed to federal court, the parties agree that the United States District Court for the Eastern District of Missouri, Northern Division, with its courthouse located in Hannibal, Missouri, shall be the exclusive venue for such federal proceedings, to the extent permitted by law.