



SURE CYCLE®

U.S. Patent No. 6,418,833



High Performance, Stainless Steel Action Systems

BNL-01, 02, 03, 04 & 05 Installation Instructions **SBE, SBE II, M1, M2 & Montefeltro shotguns**

WARNING: UNLOAD WEAPON BEFORE ATTEMPTING TO INSTALL ANY COMPONENT!!!

**The enclosed Sure Cycle system is set up for all Super Black Eagle models.
All SBE model installations – proceed to Step #1 below**

If you are using this system in **NON 3-1/2" CHAMBERED MODELS** (i.e. M1S90, M2, Cordoba, etc.) you must change the bolt buffer in the end cap:

- A. Remove the threaded end plug from the tube using a 11/16" wrench on the milled flats. The plug is under moderate spring tension, so use caution when removing it.
 - B. Pull out the black buffer in the base of the plug. Install the longer buffer provided with your Sure Cycle system into the hole in the plug. Twisting the buffer while pushing will make the installation easier. Be sure to seat the buffer all the way to the bottom of the hole.
 - C. Thread the plug back into the tube and firmly tighten it with a 11/16" wrench on the milled flats.
 - D. Proceed with the installation instructions to complete the assembly.
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1. Remove barrel, bolt assembly, and trigger group from receiver.
2. Remove butt pad from the stock. Remove the locking nut and the stock. Note the position of the offset spacer.
3. Place receiver in a padded vise. Using a propane torch, heat the factory tube approximately one inch away from the receiver for 1 minute. While heating, unscrew the factory tube from the receiver using a pipe wrench or drift pin.
4. Clean the receiver threads with solvent and brush.
5. Screw the Sure Cycle system into the receiver by hand. **DO NOT USE THREADLOCKER** Lightly tighten the tube using a 11/16" wrench on the flats milled into the threaded plug or a pin through the hole in the tube. **DO NOT PUT A WRENCH OR PLIERS ON THE STAINLESS TUBE WHILE TIGHTENING OR REMOVING THE SURE CYCLE. ONLY USE A DRIFT PIN OR 11/16" WRENCH ON THE MILLED FLATS**
6. Slide the stock over the tube and align the threaded end through the hole in the offset spacer. Firmly tighten the locknut and attach butt pad.
7. Reassemble the trigger group, bolt assembly, and barrel.

The Sure Cycle system requires no lubrication. **DO NOT** use any type of oil, grease or other lubricant in the system. If necessary, disassemble the Sure Cycle and clean the components with a mild detergent and hot water. Dry thoroughly before assembling the system.

You are now ready to enjoy your new SURE CYCLE system.

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