



SURE CYCLE®

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



High Performance, Stainless Steel Action Systems

BRN-03 Installation Instructions Browning Gold 10 gauge shotguns

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

1. Remove barrel, bolt assembly, and trigger group from receiver.
2. Remove butt pad, unscrew the butt stock lock bolt and remove buttstock from the receiver
3. Place receiver in a padded vise.
4. 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 locking pliers on the far end of the tube. Springs and follower will come out with the tube.
5. Clean the receiver threads with solvent and brush.
6. Screw the SURE CYCLE system into the receiver by hand. **DO NOT USE THREADLOCKER.** Lightly tighten the tube using a 7/16" wrench on the flats milled into the threaded plug. **DO NOT** put a wrench or pliers on the stainless tube while tightening or removing the SURE CYCLE. **ONLY USE A DRIFT PIN OR 7/16" WRENCH ON THE MILLED FLATS.**
7. Slide butt stock over the tube, place factory spacer over threads and attach the butt stock with the provided hardware. **DO NOT OVER TORQUE.**

WOOD STOCK MODELS – Place the large aluminum spacer over the threaded end of the SURE CYCLE **BEFORE** sliding the factory spacer over the tube. The factory spacer is assembled over the threaded end after the aluminum spacer is in place. The aluminum spacer **MUST** be in place to properly attach the butt stock to the receiver.

8. Attach butt pad. 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.