



SURE CYCLE®

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

High Performance, Stainless Steel Action Systems



BRN-04 Installation Instructions Browning New A5 - 12 gauge shotguns

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

1. Remove barrel, bolt assembly, and trigger group from receiver.
2. Remove recoil pad. Using a ½" socket, remove the stock retaining nut and flatshim.
3. Push out the roll pin at the rear of the factory tube and unscrew the end plug. This will allow the spring and follower to be removed from the tube. After removing the spring and follower, screw the plug back into the factory tube, this will prevent the tube from deforming during removal.
4. Place receiver in a padded vise.
5. 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 end of the tube, keeping the plier jaws over the end plug. Clean the receiver threads with solvent and brush.
6. Thread the Sure Cycle system into the receiver by hand. **DO NOT USE ANY THREADLOCKER.**
7. Remove the 5/16" locknut and washer from the tube and lightly tighten using a ¼" wrench on the milled flats of the threaded plug. **DO NOT TIGHTEN THE STAINLESS TUBE WITH A PIPE WRENCH OR PLIERS**
8. Slide the stock over the tube. Place the original offset shim over the tube, and then secure the stock with the provided flat washer and locknut. Do not use the factory locknut. Attach the recoil pad to the stock.
9. Reassemble the trigger group, bolt assembly, and barrel to the receiver.

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.

Disassembly instructions for the Sure Cycle system

1. Remove the threaded end plug from the tube using a ¼" wrench on the milled flats. The plug is under moderate spring tension, so use caution when removing it. A pin pushed through the cross hole will prevent the spring from coming out the end of the tube.
2. Remove the action spring and follower from the tube.
3. To assemble the Sure Cycle, install the follower and spring into the tube and thread the plug back into the tube and firmly tighten it with a ¼" wrench on the milled flats. You will need to compress the action spring to start the threads of the end plug. It may help to compress the spring into the tube and capture it by pushing a pin through the cross hole and spring.

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