



### INSTRUCTIONS

- Venom 5 Rnd Box Kit
- Venom 10 Rnd Box Kit
- Venom 10 Rnd Rotary Kit
- Venom-SE 10 Rnd Box Kit / Wraptor Forend
- Venom-SE 10 Rnd Rotary Kit / Standard Forend
- Venom Preconfigured Shotgun Systems

### IMPORTANT

These instructions must be read in their entirety PRIOR TO BEGINNING THE INSTALLATION. Failure to do so may result in damage to your fire-arm, kit components, and MAY VOID YOUR SIDEWINDER WARRANTY.

### CUSTOMER SERVICE

If you are having problems with this product, DO NOT RETURN TO THE STORE! Please contact Adaptive Tactical customer service, Monday–Friday, 8:00am-4:00pm MST at **208-442-8000**

PAK-3009 1217

[WWW.ADAPTIVETACTICAL.COM](http://WWW.ADAPTIVETACTICAL.COM)





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# 1. Introduction

## SAFETY WARNINGS

**IMPORTANT:** These instructions must be read in their entirety **PRIOR TO BEGINNING INSTALLATION.** Failure to do so may result in damage to your firearm, kit components, and **WILL VOID YOUR SIDEWINDER WARRANTY.**

**WARNING!** Before beginning the installation of a Sidewinder Venom Kit, make sure the shotgun is **UNLOADED** and the mag tube cleared of live rounds. Read the instructions thoroughly and be sure that you understand them completely. Complete instructions may be found online at [www.adaptivetactical.com](http://www.adaptivetactical.com)

**NOTE:** Sidewinder Venom Kits are designed and engineered to work specifically with Mossberg 12-gauge shotguns. Do not attempt to retrofit your Venom Kit onto other firearms. Installation of the system onto another firearm will void the related factory warranty and could result in an unsafe or potentially deadly scenario.

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## IMPORTANT OWNER INFORMATION

**WARNING!** All firearms are potentially dangerous; improper use may cause great harm, personal injury or death. It is your responsibility to know the safe use, procedures and operation of your firearm, and to store, handle and transport your firearm safely. Proper training is available through accredited firearms safety training programs.

Refer to your Mossberg owner’s manual for instructions related to the specific operation and maintenance, care and safety instruction of the serialized or receiver portion of the firearm. If you do not have a factory owner’s manual, you may obtain one at no charge from

O.F. Mossberg & Sons, Inc.  
PO Box 497  
North Haven, CT. 06473  
(203)230-5300 [www.mossberg.com](http://www.mossberg.com)

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# 2. Customer Service / Warranty

## HELP WITH THIS PRODUCT

**IMPORTANT! DO NOT RETURN PRODUCT TO STORE!** If you are having problems, please contact Adaptive Tactical at 208-442-8000

For inquiries concerning Adaptive Tactical products:

Call **208-442-8000** between 8am and 4pm MST, Monday through Friday,

Ask your local firearms dealer,

Visit [www.adaptivetactical.com](http://www.adaptivetactical.com)

Please visit [www.adaptivetactical.com](http://www.adaptivetactical.com) for a list of frequently asked questions and troubleshooting information regarding this product. Instructional videos are also available online.

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## OPERATION AND MAINTENANCE

### Mossberg® Shotgun

These instructions do not replace the Mossberg® owner’s manual; refer to your owner’s manual for instructions related to the specific operation and maintenance of the firearm.

### Sidewinder Venom Replacement Parts

Replacement parts for Sidewinder Venom products are available for purchase online at [www.adaptivetactical.com](http://www.adaptivetactical.com)

### Cleaning Sidewinder Venom Components

To clean Sidewinder Venom components, magazine well and magazine tube, used compressed air to remove any loose debris. Surfaces can be wiped down with cleaners and/or lubricants designed specifically for firearms.

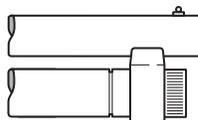
### Camouflage Finishes

Avoid using abrasive or solvent cleaners and/or lubricants on camouflage finishes.

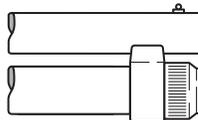
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## BEFORE YOU GET STARTED

1. Confirm you have purchased the correct model of Sidewinder Venom Kit to correspond to your shotgun.
2. Become familiar with the components of the firearm. Kit installation requires disassembly of interior components.
3. Take careful note of each step when disassembling your shotgun. Familiarity with the process will assist in the easy reassembly of the firearm and installation of your Sidewinder Venom Kit.



**Mossberg 500/88**  
Takedown Screw



**Mossberg 590**  
Magazine Cap

**NOTE:** If you are unsure or uncomfortable in performing kit installation in a safe manner, take your Venom Kit and shotgun to a competent gunsmith for proper installation.

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## WARRANTY / DISCLAIMERS

Improper installation of Venom Kit Parts, including but not limited to magazines, magwell, barrel, stock or any other supplied part or accessory will void the warranty for this product.

Due to the manufacturing variations in ammunition test all purchased ammunition for function and reliable performance when used in conjunction with the Sidewinder Venom System.

Except for defects in materials or workmanship, your Sidewinder Venom Kit is sold “AS IS” and “WITH ALL FAULTS.”

To the extent allowed by law, we specifically disclaim any expressed or implied warranties, including but not limited to warranties of merchantability and fitness for a specific purpose. We disclaim any responsibility for damage or injury that may result from any modifications or changes that are NOT part of the Sidewinder Venom System as delivered from the factory.

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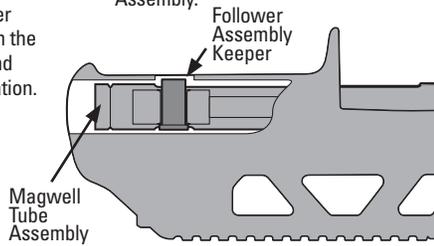
### 3. Preparing for Installation

#### UNPACKING YOUR KIT

Remove all of the components from the packaging and place on a flat surface.

The Follower Assembly and Follower Assembly Keeper are housed within the Forend/Magwell Tube Assembly, and must be removed prior to kit installation.

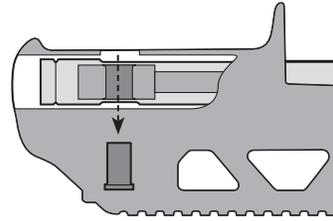
1. Turn the Forend upside down and pull the Forend forward until the Follower Assembly Keeper aligns with the corresponding slot in the Magwell Tube Assembly.



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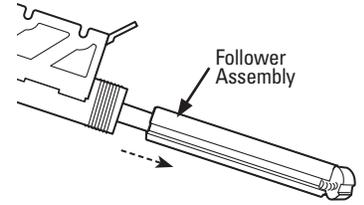
2. Remove Follower Assembly Keeper through the metal slot in the Magwell Tube Assembly, using a slight back and forth movement of the forend or pressing it out with your finger.

The Follower Assembly Keeper is a small part and easily lost; note its location.



3. Remove the Magwell Tube Assembly from the Forend.

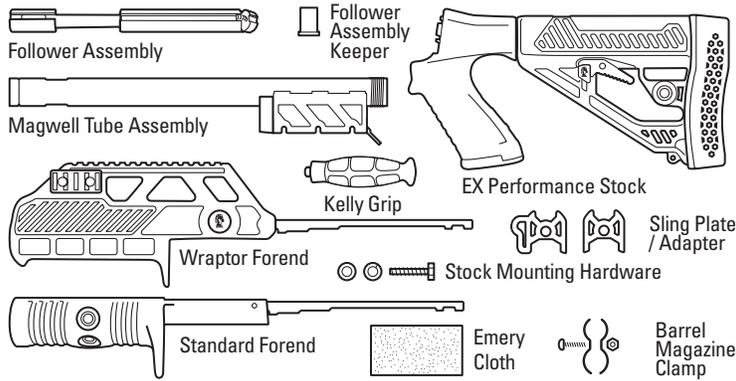
4. Tilt the Magwell Assembly so that the Follower Assembly slides out.



Depending on your particular Venom kit, you may or may not have a specific forend or stock (and related hardware) shown on the following page.

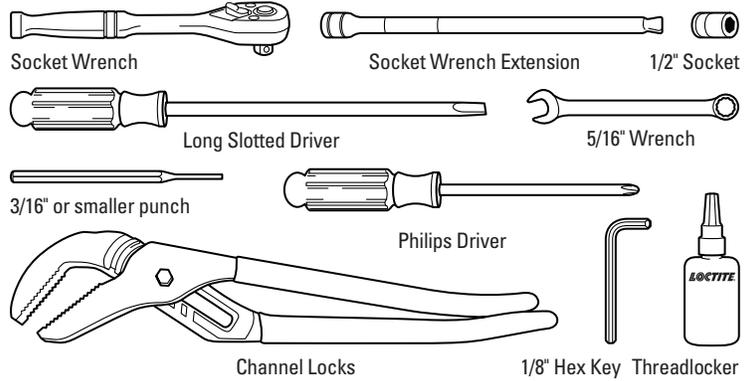
11

#### VENOM KIT COMPONENTS



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#### REQUIRED TOOLS FOR ASSEMBLY

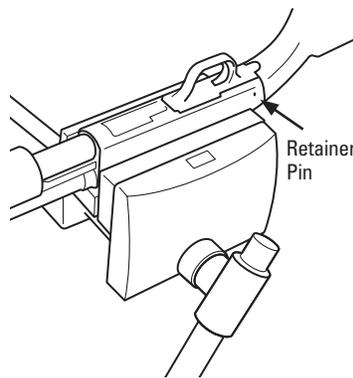


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#### WORKSPACE

The use of a vise to secure the receiver during shotgun disassembly and kit installation is recommended. Firmly clamp the receiver in the vise – bottom side up – leaving the barrel and the Retainer Pin unobstructed by the vise. Illustrations in this manual show this workspace.

**NOTE:** Take caution when tightening vise not to scratch the receiver. Using a soft material between the vise's jaw surfaces and the receiver ("Soft Jaws") will help protect the receiver from being scratched.



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### 4. Shotgun Disassembly for Kit Installation and Preconfigured System Maintenance



**WARNING: Use Caution!**

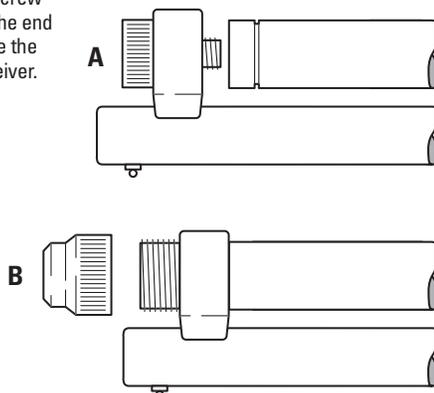
Verify firearm safety is on and the barrel is pointed in a safe direction. Confirm that the shotgun is unloaded by opening the action and making visual and touch verification as directed in your shotgun owner's manual.

1. Remove shotgun stock; installation of the Venom Kit and cleaning of your Preconfigured Shotgun System requires stock removal.

In most cases the recoil pad will be attached by two screws, and the stock by one main bolt. Refer to factory manual if necessary.

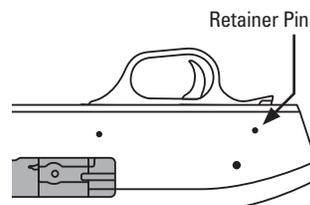
15

2. Unscrew the 500/88 Takedown Screw (A) or 590 Magazine Cap (B) on the end of the magazine tube and remove the barrel by pulling it out of the receiver.



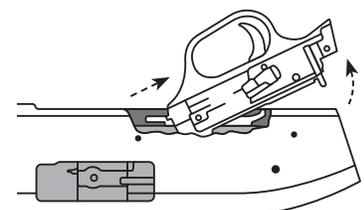
3. Remove Retainer Pin utilizing an appropriately sized punch (3/16" or smaller).

The Retainer Pin is a very small part and easily lost; note its location.



4. Remove the Trigger Housing Assembly from receiver by lifting the rear portion upward first and sliding back.

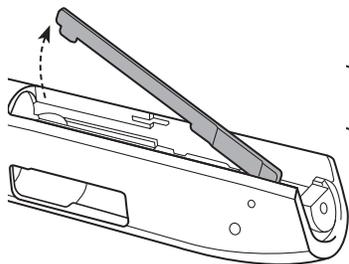
**DO NOT PULL THE TRIGGER!** Serious damage to the trigger group may result.



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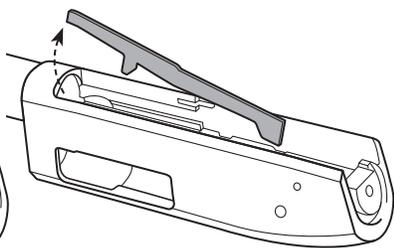
5. Remove the Cartridge Stop and set aside for later use.



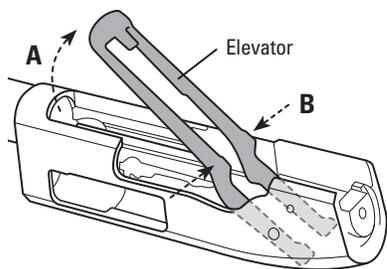
18

6. Remove the Cartridge Interrupter.

**IMPORTANT!** Cartridge Interrupter **WILL NOT BE RE-INSTALLED!**

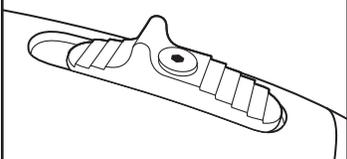


8. Pivot the front portion of the Elevator upward out of the receiver (A), then squeeze the two arms which form the open end of the Elevator together (B) sufficiently to disengage and remove from receiver.



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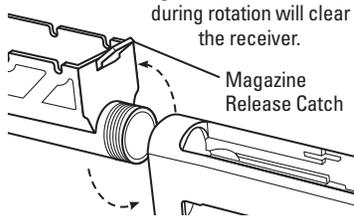
**NOTE:** For 500 and 590 shotguns, the safety button located on the upper rear of the receiver must be fully rearward in the 'ON' (SAFE) position to remove the Elevator.



## 5. Venom Kit Installation

1. Remove debris or threading compound from Magazine Tube threads in receiver.

Thread the Venom Magwell Tube completely into receiver. Depressing the magazine release latch during rotation will clear the receiver.

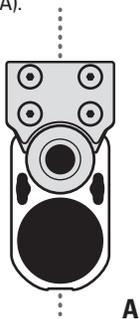


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2. Confirm proper alignment of the Venom Magwell Tube (Figure A).

**IMPORTANT!** DO NOT CONTINUE TO TIGHTEN the Magwell Tube when it comes to a stop.

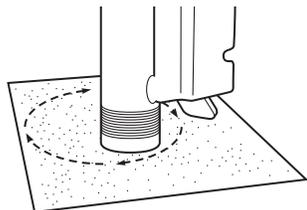
If when installed the Magwell Tube is NOT vertically aligned, proceed to the next page.



A

3. Uninstall the Magwell Tube Assembly. Place Emery Cloth on a hard, flat surface. In a circular motion rub tube end on Emery Cloth. Sand evenly; avoid sanding at an angle.

Remove a small amount of material and then reinstall the Magwell Tube Assembly.

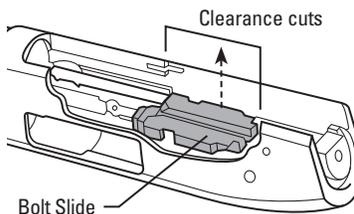


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**IMPORTANT!** Proceed with the following modification **ONLY IF CENTER LINES ARE NOT ALIGNED.**

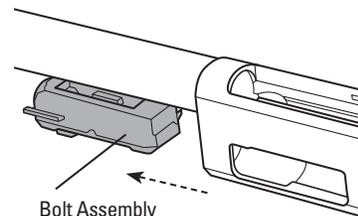
**CAUTION!** Remove material incrementally. Excessive sanding will remove too much material and make the Magwell Tube Assembly unusable and **will void your product warranty.**

6. Move the forearm/action slide assembly rearward so that the bolt assembly and bolt slide are three quarters of the way rearward. When the bottom of the Bolt Slide is aligned with the clearance cuts in the sides of the receiver, lift the Bolt Slide upward and out of the receiver.



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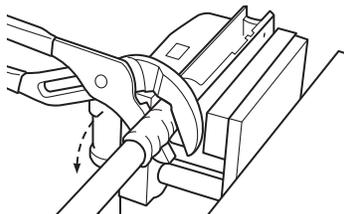
7. Remove the Bolt Assembly by sliding it forward and out of the receiver assembly through the barrel opening at the front of the receiver.



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9. Use channel locks to remove factory Magazine Tube from receiver. To prevent scratching the tube, wrap it with leather prior to applying channel locks.

Remove internal Limiting Plug and Magazine Spring. These components and the magazine tube **WILL NOT BE USED** for Kit installation.

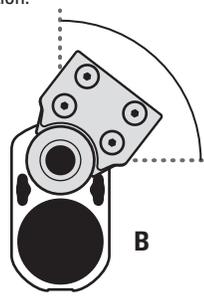


**CAUTION!** The Magazine Spring retainers and springs are under significant spring pressure. When removing these items, use caution to prevent injury to yourself or others around you.

Shotgun disassembly complete. Proceed to Venom Kit Installation instructions.

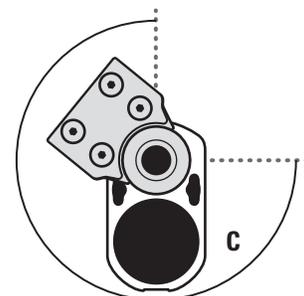
21

If the Magwell is in the range indicated by Figure B below, **DO NOT SAND!** Un-thread (back up) slightly and vertically align the Magwell. Remove Magwell, use Threadlocker and re-position Magwell in vertical position.



B

If the Magwell is in the range indicated by Figure C below, material must be removed from the end of the Magwell Tube Assembly using the included sand paper. See Step 3.



C

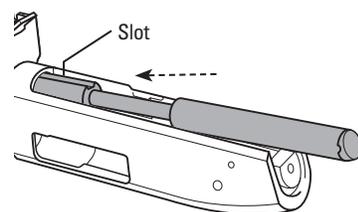
23

Repeat until Magwell is vertically aligned with receiver; refer to Figure 2A. Utilize sand paper to remove any metal burs from inside and outside tube surfaces.

**NOTE:** To avoid damaging or crimping tube end, take caution not to force the Magwell Tube Assembly into the correct vertical position.

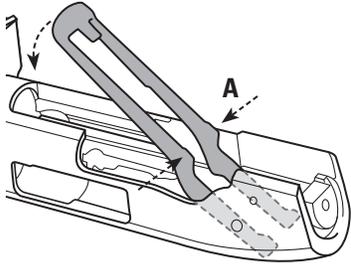
4. With the compressible angled tip facing the rear of the receiver, insert Follower Assembly into rear of Magwell Tube (will require firm pressure to insert).

The Follower Assembly Keeper slot should be facing the same direction as the bottom opening of the receiver.



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5. Install Elevator back into receiver. Elevator is held in position by spring tension into corresponding holes in receiver; squeeze center (A) to apply pressure to ends and reinstall into receiver.



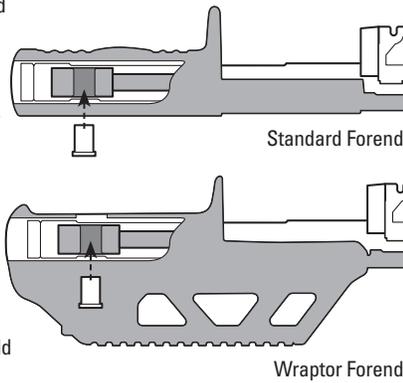
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9. Insert the Follower Assembly Keeper through the hole in the Mag Tube and into the corresponding slot in the Follower Assembly and forend.

With the receiver fixed upside down in the vise, the slot will not be readily visible. Feeling along the top of the forend will help to locate the slot.

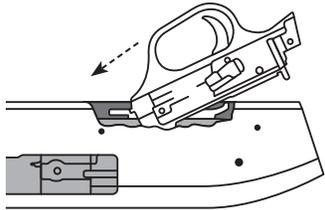
A slight back and forth movement of the forend may be required to align the Follower Assembly Keeper into the forend slot.

Once the Follower Assembly Keeper is seated properly, use a finger to hold it in place, and slide the forend back.



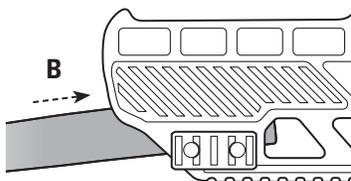
28

12. Hold the Cartridge Stop in place firmly against the receiver walls with one hand and grasp the Trigger Housing Assembly with the other. Insert the lugs on either side of the front corner of the Trigger Housing Assembly into the slots on each side of the receiver, then ease the rear of the housing assembly down and into position. **DO NOT FORCE!**



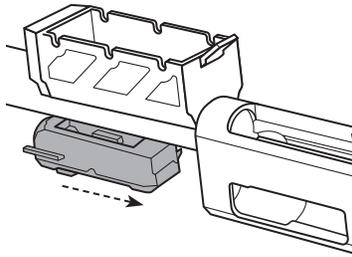
30

- B) Insert the barrel into the forend.



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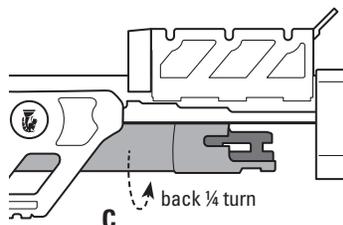
6. Reposition the Bolt Assembly back into the shotgun by sliding it into the barrel opening at the front of the receiver.



**NOTE:** Reference Mossberg manual if encountering difficulties in Steps 5 & 6.

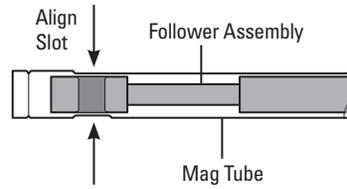
13. Align the trigger pin hole in the housing assembly with those in the receiver. Insert the trigger housing Retainer Pin and push in fully until flush with the side of the receiver.

Reinstall barrel into receiver.

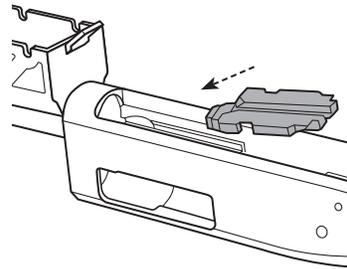


## INSTALL FOREND

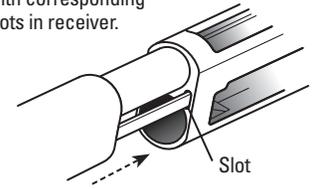
7. Align the Follower Assembly Keeper slot with the opening in the top of the Mag Tube.



10. Reposition bolt slide on top of bolt and forend action bars.



8. Slide action bar and forend assembly onto Magazine Tube. Align action bars with corresponding slots in receiver.

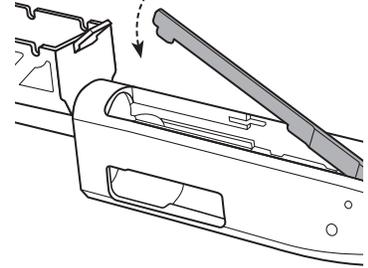


**NOTE:** Venom Kits feature two types of forend; Standard or Wraptor. Refer to the appropriate image for instructions for your specific forend.

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11. Reinstall Cartridge Stop into the corresponding slot in receiver.

**IMPORTANT!** DO NOT re-install the cartridge interrupter.



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## INSTALL BARREL

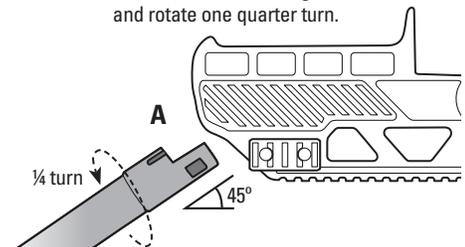
14. Standard Forend:

Partially open the breach by sliding the forend rearward. Reinstall the barrel into receiver.

- Wraptor Forend:

Partially open the breach by sliding the forend rearward.

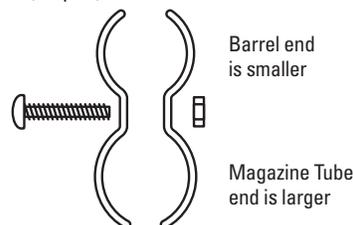
A) Hold barrel at 45° angle to forend and rotate one quarter turn.



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15. Assemble Barrel Magazine Clamp.

Place the screw through the drilled hole in one clamp. Thread the screw through the threaded hole in the other clamp. Thread nut on screw. Do not tighten until clamp is positioned on the shotgun and flush with the barrel lug (Step 17).



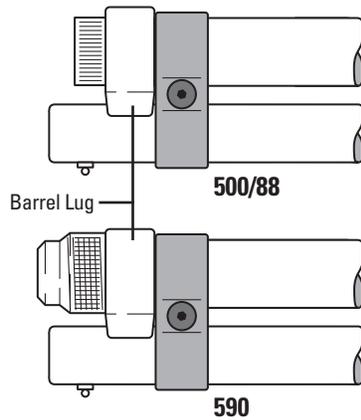
**IMPORTANT!** The Barrel Clamp must be installed. Failure to install the barrel clamp may result in the magtube being sheared off. Damage resulting from failure to use the barrel clamp is not covered by your warranty.

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**16.** Position Barrel Clamp just behind barrel lug. When it is in the correct position – flush with the barrel lug – tighten Barrel Clamp in place using a 1/8" Hex Key and 5/16" Wrench.

**NOTE!** The Barrel Clamp should not interfere with movement of the forend during firearm use.

**NOTE!** For Kits featuring the Wraptor forend, forcefully and rapidly actuate the forend forward and backwards five or six times. This allows the forend to "nest" on the barrel clamp, keeping the forend from rocking side to side and stabilizing the forend into battery.



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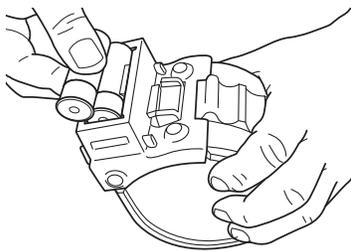
## 7. Box & Rotary Magazine Loading / Unloading

**CAUTION:** Sidewinder Magazines are designed for use with only 2.75", 12 gauge magnum shotgun shells/ammunition in new or like new condition. Do not utilize oversized, undersized, non-traditional, damaged, or reloaded ammunition. We disclaim any responsibility for damage or injury whatsoever occurring in connection with, or as a result of, the use of faulty, or non-SAAMI standard, or "remanufactured" or hand-loaded (reloaded) ammunition.

**NOTE:** Some shotgun ammunition brands use more buffer material than other manufactures (small white beads inside shells). The presence of excess buffer material can negatively impact the performance of the magazines. To ensure consistent performance, clean out loose buffer material often or utilize ammunition without or with limited amounts of buffer material. See cleaning instructions for recommended cleaning procedures.

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**B.** Rotary magazine; right hand shooters will load shells with the brass to the rear and the round portion of the rotary magazine facing right (as shown). Left hand shooters will load shells with the brass to the rear and the round portion of the rotary magazine facing left.



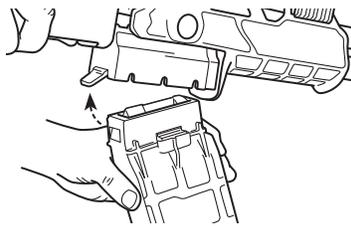
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**4.** To unload magazine, point magazine in a safe direction, depress Shell Release Button. Use caution as rounds are held under spring tension and may launch.



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**2.** Insert the loaded magazine into the bottom opening of the Magazine Well firmly until the locking latch is engaged. The magazine should always be inserted with the brass facing towards the rear of the shotgun (nearest to the receiver). Verify that the magazine is securely in place prior to firing.



**5.** To clean the magazine, slightly depress the magazine shell follower and shake out or blow out loose debris. Wipe down magazine surfaces with plastic safe cleaners and lubricants.

**CAUTION:** Rotary magazine should NOT be disassembled. The internal components are under pressure and are unable to be reassembled without specialized tools.

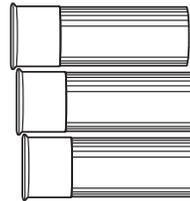
**17.** Reinstall shotgun stock; refer to the factory manual if necessary.

**NOTE:** If you have purchased a Venom-SE Kit, please refer to the EX Performance Stock Installation section near the end of this document.

Assembly is complete. Remove the assembled firearm from the vise. With the safety on and firearm unloaded verify that the functions of the firearm are operating correctly.

**1.** To load, hold shells parallel to the magazine; load one round at a time by pressing shells down into the top magazine opening.

**NOTE:** For best performance, the brass rims should be loaded in front of the rim of the previous round in the magazine. Do not alternate rims during loading.

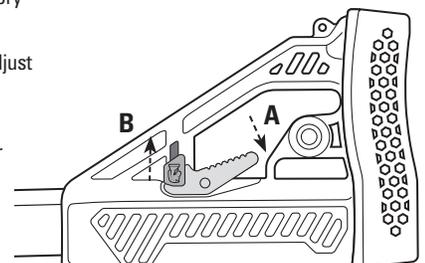


**WARNING!** A live round may still be in the mag tube when the magazine is removed.

Use caution; verify the firearm safety is on and the barrel pointed in a safe direction. Remove the live round from the mag tube; confirm the shotgun is unloaded by opening the action and making visual and touch verification as directed in your shotgun's owner manual.

## 8. Stock Installation (Venom-SE Kit Only)

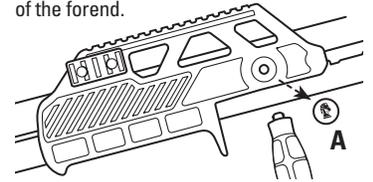
1. Remove the stock currently on your shotgun. Refer to the shotgun factory manual if necessary.
2. Use the Adjustment Lever (A) to adjust the stock to the longest setting.
3. Pull the Adjustment Lever Tabs (B) on each side to disengage the rear stock, and slide it off of the rear of the stock tube.



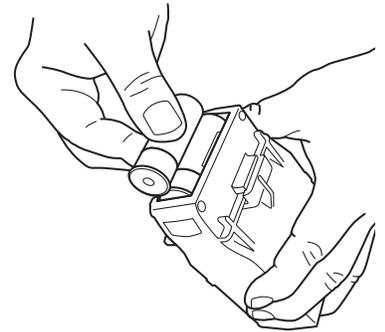
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## 6. Kelly Grip Installation

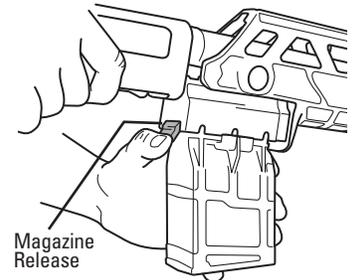
The included Kelly Grip may be used to speed up pumping action or improve reach. Simply screw the threaded end of the grip into desired location. Do not over tighten. To install on the Wraptor forend, remove the round Warhorse logo cap (A) on the left or right side of the forend.



**A.** Box magazine; place shell rim in magazine rim slot. Depress shell past shell retainer. Repeat until magazine is full.



**3.** To remove magazine from Magazine Well, verify firearm safety is on and the barrel is pointed in a safe direction, grasp the magazine and depress the Magazine Release. Pull the magazine downward out of magazine well.



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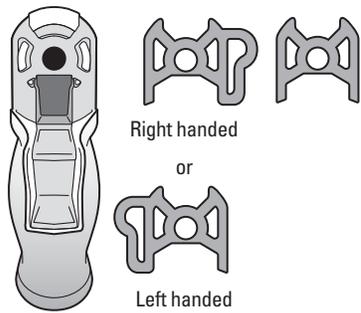
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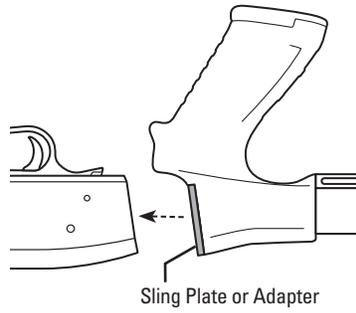
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4. Position Adapter or ambidextrous Sling Plate on the front of the stock.

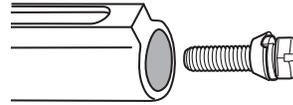


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5. Align the front of the stock (plus Adapter or Sling Plate) with the rear of the receiver and hold in position.

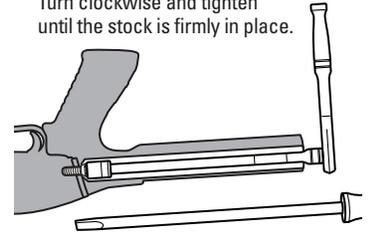


6. Remove Stock Mounting Hardware from hardware bag. Assemble and insert into stock tube. Use a Socket Wrench with Extension and 1/2" Socket (or Long Slotted Driver) to push assembled Mounting Hardware to the end of the stock tube and through the front of the stock and Adapter/Sling Plate.



**NOTE:** Carefully align and position stock prior to tightening to avoid stripping threads in the receiver.

7. Engage the Socket Wrench (or Long Slotted Driver) with the mounting Bolt. Turn clockwise and tighten until the stock is firmly in place.



8. Pull Adjustment Lever Tabs (see 3B) and slide the adjustable portion of the stock back onto the stock tube. Use the Adjustment Lever (2A) to adjust the stock to the preferred setting.

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