

BRTXTR

Beretta 391 Xtrema and 391 Xtrema 2 12ga. Shotguns

WARNING: UNLOAD AND PROPERLY CLEAR THE WEAPON BEFORE ATTEMPTING TO INSTALL ANY COMPONENT!!!

1. Remove the barrel, bolt assembly and trigger group from the receiver.
2. Remove the recoil pad from the stock.
3. Remove the stock locking nut and note the position of the offset spacer before sliding off the stock.
4. Place the 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 12mm wrench.
6. Clean the receiver threads with solvent and brush.
7. Apply threadlocker to the screw end of the SURE CYCLE system and install into the receiver. 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 7/16" WRENCH ON THE MILLED FLATS**
8. Slide the butt stock over the tube and align the threaded end through the hole in the offset spacer.
9. Firmly tighten the butt stock locknut and attach butt pad.
10. 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 lubricants 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.

