

## BRN02

### Browning B-80 12ga. & 20ga. Shotguns

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

1. Remove barrel, bolt assembly and trigger group from the receiver. Remove butt pad.
2. Using a socket, remove the butt stock lock nut, spacer and shim. Remove butt stock.
3. Depress the plastic plunger at the rear of the factory spring tube slightly and remove the cross pin. Slowly allow the spring plunger to exit the tube.
4. Remove the factory spring and follower from the tube.
5. Place the receiver in a padded vise.
6. Using a propane torch, heat the factory tube approximately one inch away from the receiver for 1 minute. While heating, unscrew the tube from the receiver using a pipe wrench or drift pin.
7. Clean the receiver threads with solvent and brush.
8. Screw the SURE CYCLE system into the receiver by hand. **DO NOT USE THREADLOCKER.** Lightly tighten the tube using 7/16" wrench on the flats milled into the thread extender. **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.**
9. Slide butt stock over the tube and attach with hardware placed in this order: factory shim > Sure Cycle washer > Sure Cycle lock nut. Discard the factory spacer and lock nut. It may be necessary to rasp or ream the hole in the butt stock slightly to clear the tube.
10. 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 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.**

