

WIN01D

Winchester Super X1 12ga. 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.
2. Remove recoil pad, unscrew the stock lock bolt and remove the stock.
3. Push out the roll pin in the factory follower and remove the spring and follower from the recoil spring tube.
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 pipe wrench or drift pin.
6. Clean the receiver threads with solvent and brush.
7. Install and slide the bolt carrier assembly all the way to the back of the receiver.
8. Using an 11/16" wrench on the milled flats, unscrew the threaded plug from the rear of the SURE CYCLE and remove the spring and follower. **CAUTION:** There is spring tension on the plug. Use care when disassembling the system. **DO NOT** put a wrench or pliers on the stainless tube when removing the SURE CYCLE. **ONLY USE A DRIFT PIN OR 11/16" WRENCH ON THE MILLED FLATS**
9. Apply **REMOVABLE THREADLOCKER** to the threads of the SURE CYCLE. While the bolt assembly is in its rearmost position, screw in the SURE CYCLE tube until it touches the bolt carrier. Back out the tube until the slots in the face of the tube align with the back of the bolt carrier, and allow the bolt assembly to be removed from the receiver.
10. Insert the follower and spring into the tube. Compress the spring and screw the threaded plug into the SURE CYCLE.
11. Slide the stock over the tube and attach with the provided hardware. Take care not to rotate the tube while tightening the locknut.
12. Attach the recoil 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.

