



SURE CYCLE®

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

High Performance, Stainless Steel Action Systems



BRT-03 Installation Instructions Pintail and ES100 - 12 gauge shotguns

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

1. Remove the barrel, bolt assembly, and trigger group from 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 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.
6. Clean the receiver threads with solvent and brush.
7. Screw the SURE CYCLE system into the receiver by hand. **DO NOT USE THREADLOCKER.** Lightly tighten the tube using a 11/16" 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 DRIFT PIN OR 11/16" 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 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.

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