



SURE CYCLE®

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

High Performance, Stainless Steel Action Systems



BRN-01 & WIN-02 Installation Instructions

Browning Gold, Silver & Maxus and Winchester Super X2 & X3 and FN SLP - 12 & 20 gauge shotguns

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

INSTALL ACTION SPRING INTO SURE CYCLE TUBE

The enclosed Sure Cycle system contains two stainless steel action springs. The heavy spring (14") is designed to deliver maximum performance with high-velocity and magnum loads. The light spring (15") should only be used with low-velocity target loads. You cannot damage the Sure Cycle or your shotgun by firing magnum loads with the light spring installed in the tube; however we recommend changing springs to obtain best results. To install the action spring:

- A. Remove the threaded end plug from the tube using a 9/16" wrench on the milled flats.
- B. Place the appropriate action spring into the Sure Cycle tube.
- C. Thread the plug back into the tube and firmly tighten it with a 9/16" wrench on the milled flats.
- D. Proceed with the installation instructions to complete the assembly.

INSTALL SURE CYCLE SYSTEM INTO RECEIVER

1. Remove barrel, bolt assembly, and trigger group from receiver.
2. Remove recoil pad. Using a 3/4" socket, remove the stock retaining nut, round spacer and flat shim.
3. Depress the plastic plunger at the rear of the factory tube slightly and remove the cross pin. This will allow the spring and follower to be removed from the tube.
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 on the end of the tube. Clean the receiver threads with solvent and brush.
6. Thread the Sure Cycle system into the receiver by hand. **DO NOT USE ANY THREADLOCKER.**
7. Remove the 5/16" locknut and washer from the tube and lightly tighten using a 9/16" wrench on the milled flats of the threaded plug. **DO NOT TIGHTEN THE STAINLESS TUBE WITH A PIPE WRENCH OR PLIERS**
8. **IMPORTANT:** Inspect the link attached to the rear of your bolt. If there is a vertical tang located near the rounded end it must be ground or filed off prior to installing the bolt. Failure to remove this tang will cause the Sure Cycle tube to be damaged. See illustrations below:



Vertical tang on bolt link



Bolt link after tang has been removed

9. Slide the stock over the tube. Place the original offset shim over the tube, then secure the stock with the provided flat washer and locknut. Discard the factory spacer and locknut. Attach the recoil pad to the stock.
10. Reassemble the trigger group, bolt assembly, and barrel to the receiver.

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.