



The installation or removal of bead-type shotgun sights is greatly simplified with the use of Brownells Shotgun Sight Installers. The adjustable collet jaws of the Installers grip standard size brass, aluminum or stainless steel beads tightly without causing distortion or damage.



WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

HOW TO USE

INSTALLATION: Clamp the shotgun barrel horizontally in a padded bench vise. Inspect the threaded hole into which the sight bead will be installed. Clean the hole of drilling and tapping chips, cutting oils, old Loctite™ or epoxy. Make sure the bead you install is the same thread size as the existing hole in the shotgun rib or barrel. Many firearms use metric or non-standard thread sizes for which replacement beads are not readily available. To correct this problem, re-thread the rib or barrel to a standard size to match the bead you intend to install. Clamp the bead firmly in the jaws of the appropriate sized **Installer**. Position the jaws as close to the shoulder of the bead as possible. Test fit the bead into its threaded hole and either deepen the hole, or carefully shorten the threaded shank of the sight, if needed. The shoulder of the bead should be just at the surface of the barrel. Remove the bead from the barrel or rib and put one small drop of thread locking compound on the threads. Replace the bead into the rib or barrel and allow the thread locking compound to fully cure. If the bead has been installed in a plain barrel and the threaded shank protrudes into the bore, carefully file or grind it off until it's flush with the inside surface of the bore. If necessary, clean up the last few inches of the bore, close to the muzzle, with a **Shotgun Barrel Hone**.

REMOVAL: Clamp the shotgun barrel horizontally in a padded bench vise. Slip the appropriate sized **Shotgun Sight Installer** over the bead. Turn the knurled sleeve to tighten the jaws of the **Installer** over the bead. Tighten the jaws enough to prevent the jaws from slipping when the bead is

turned out of its hole. If the **Installer** cannot grip the bead tightly enough to break the threads loose, Loctite™ or another thread locking compound has probably been used to lock the bead in place. Apply heat to the rib or barrel at the point where the bead has been installed. Use a propane torch to apply the heat and do not exceed 300-350° F. Most thread locking compounds and epoxies will soften in this heat range. Use only a minimal amount of heat, just enough to do the job, to avoid discoloring the barrel or melting the solder joint on a soldered-on rib.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner. **IMPORTANT!** Start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.

BROWNELLS® SHOTGUN SIGHT INSTALLER

READ & FOLLOW THESE
INSTRUCTIONS

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