



Brownells Premium Aluminum Oxide Stones fit the No. 2 Shotgun Barrel Hone, and are intended for use in 12 gauge and larger shotgun barrels only. Five grits are available; Lisle No. 2-S Rougher, 150, 400, 500 and a 150 grit for chrome lined barrels only.

Assembly of the Hone:

The No. 2 barrel Hone arms have an "ear" on each side of the lower end with a small angled protrusion at the very bottom. Assemble the arms into your tool body with the protrusion facing out, and the rubber o-ring holding the arms in place. Do not mix grits of stones. If the stone assembly has been properly installed onto the arm, the arm will be on the left side of the stone's central lug with the arm facing toward the tool body when viewed from the rear. Adjust the spring tension on the arms with the knurled adjustment nut to give positive, moderate tension of the stones to the bore.



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

Remove the barrel(s) from the gun and secure in a padded bench vise with the bore horizontal so you have access to whichever end of the barrel you will be working on. Clean the bore using appropriate brushes and solvents. Clamp the Hone's shank into the chuck of your $\frac{1}{4}$ " or $\frac{3}{8}$ " electric hand drill, or assemble the Hone to your Brownells Barrel Hone Extension Shaft (#080-915-000).

Prior to placing the Hone in the bore, coat the bore and the Hone with a good grade of cutting oil, such as Brownells Do-Drill™. The cutting oil will help prevent metal particles from "loading up" which significantly reduces the cutting effectiveness of the stones. Since each barrel will present unique problems with hardness and chamber roughness, or rust pitting to smooth out, there is no way to predict how much honing time will be required for each grit before using the next finer grit. Clean out oil and grit from the bore before switching to a finer grit stone set, using a good quality solvent. Clean the barrel and chamber thoroughly before shooting.

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 PROFESSIONAL SERIES BARREL HONING STONES

READ & FOLLOW THESE
INSTRUCTIONS

BROWNELLS

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