



Raybar, Poly-Choke® Sunspot and Bradley shotgun front sights have a sight bead that rests on an integral base or shoulder. For best results the sight bead must be "regulated" so the face of the sight's shoulder is centered on the shotgun's rib or barrel, and square with the shooter's face. Your Brownells Shotgun Bead Facing Cutter is a hand held tool that will trim excess material from the bottom of the shoulder and allow the sight bead to be regulated correctly.



### 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.

If an existing sight is being changed, remove it and check that the threads match those on the new sight to be installed. If you are replacing a damaged sight, the shank of the old sight may have to be drilled out and the threads cleaned up or chased. If the installation is completely new, the barrel, or rib, will have to be drilled and tapped at the appropriate place using the correct drill and tap that matches the new sight bead.

### HOW TO USE

Clean the threads in the barrel, or rib, and thread the sight bead into the hole. Tighten the sight bead using finger pressure only. If the sight bead is more than 1/8 turn away from being square with the barrel, or rib, lightly trim the bottom shoulder of the sight with the appropriate Shotgun Bead Facing Cutter until the bead indexes correctly.

Shotgun Bead Facing Cutters are sized as follows:

- #3. Fits 3-56 and 3-48 threads.
- #6. Fits 6-48 threads.
- #6. O.S. Fits .146"-8 oversize threads.
- #8. Fits #8 thread.

To use the Shotgun Bead Facing Cutter, secure the sight base in a pair of smooth, parallel jaw pliers or clamp the sight in a padded bench vise. Insert the threaded portion of the shank into the hole in the center of the Facing Cutter so the blades are resting against the bottom shoulder of the sight. (Never hold the sight in your hand. The cutter blades are extremely sharp and can cause serious injury.) Exert only light hand pressure and turn the handle in a *clockwise* rotation. **CAUTION** - Never turn the Sight Base Cutter *counterclockwise*; this will roll the edge and dull the cutters. Remove only a small amount of metal from the bottom of the sight's shoulder at one time and try the sight after each cut to make sure you do not overcut. When the

# BROWNELLS SHOTGUN BEAD FACING CUTTER

READ & FOLLOW THESE  
INSTRUCTIONS

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base is trimmed correctly, you will be able to screw the sight in, using finger pressure only, and it will end up being 1/8 of a turn, or less, from being square with the barrel or rib. Remove the sight from the barrel and clean both the male and female threads. Place a drop of Loctite™ #242 on the threads to prevent the sight from vibrating out and install the sight. Use a small, adjustable, open end wrench or smooth, parallel jawed pliers to tighten the sight to its proper position. Allow the Loctite to cure completely before reassembling or using the firearm. If the firearm is a single barrel gun without a raised sight rib or sight bead base, the newly installed shank of the sight bead will protrude into the bore of the shotgun. Allow the Loctite to cure completely and use a fine needle file or electric hand grinder equipped with a fine stone to dress off the protruding shank. Be careful not to cut into the inside of the barrel. Finish the job by polishing the bore thoroughly.

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.