

BRILEY

Auto Shotgun Rear Sight Fitting Instructions

Briley adjustable rear sight for auto shotguns is designed to assist the shooter when having to shoot targets with slugs at long distances. It has an express style rear blade with a small notch. This allows the shooter to still see the rib while shooting shot at closer static or aerial targets

A drawing is provided to help with the fitting of this rear sight which will absolutely need to be done by a qualified gunsmith. Tools required to do this installation will be the following:

- ¼ inch end mill.
- .1875 inch end mill.
- Small center drill.
- .0625 drill.
- #31 drill.
- 6 x 56 tap.

A fixture may be required to clamp the barrel in your milling machine due to the taper of the barrel. You will also need to level the barrel accurately before any machining is done. When drilling the rib for the threaded hole calculate the maximum depth you can drill without going through the barrel. Remember that the rib is hollow and the top of the barrel is closer to the top of the rib at the center of the rib. You can find this dimension by measuring from the top of the rib where you will drill the hole to the bottom of the barrel. Measure the barrel diameter at that same position and subtract it from your first measurement. This should give you an idea of how deep you can drill. When tapping do not start the thread by hand but rather use the drill chuck to assist with alignment in starting.

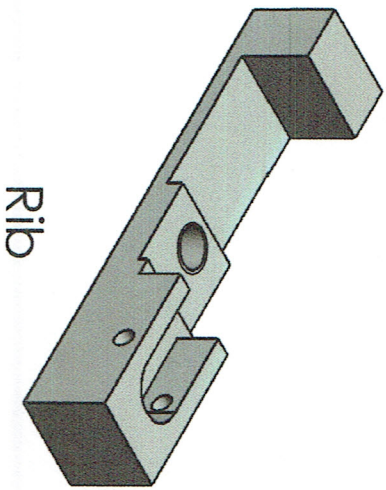
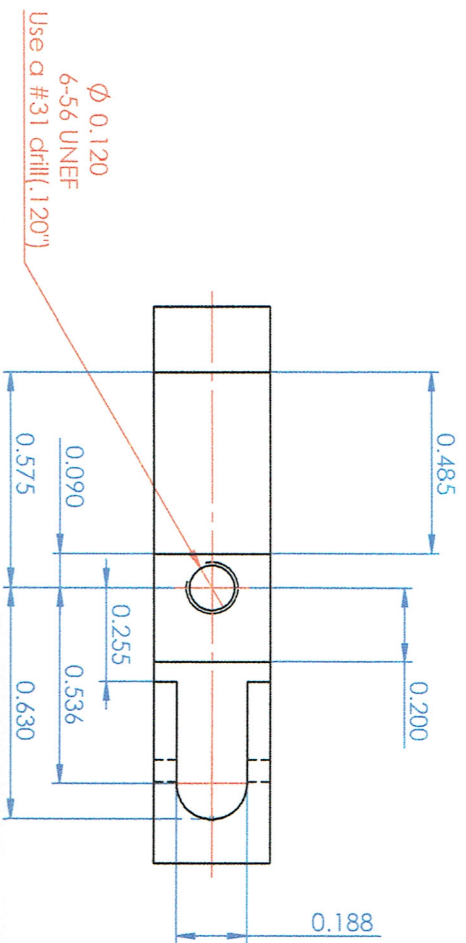
Carefully finish the thread by hand using a small tap wrench as the thread is extremely fine and can be easily damaged. It will be required to shorten the elevation screw accordingly.

When you have completed the installation the sight in its fully down position and using a Briley front sight should shoot POI at 50 yards. While the thread length is quite short there is more than enough adjustment if required to elevate it. If your gun is not shooting POI at 50 yards Briley Manufacturing can assist you with correcting the front sight height. We will need an accurate group to be shot at exactly 50 yards. The POI shift (error in inches) from the aimed point together with the sight radius measurement and distance to the target will allow us to calculate the adjustment required.

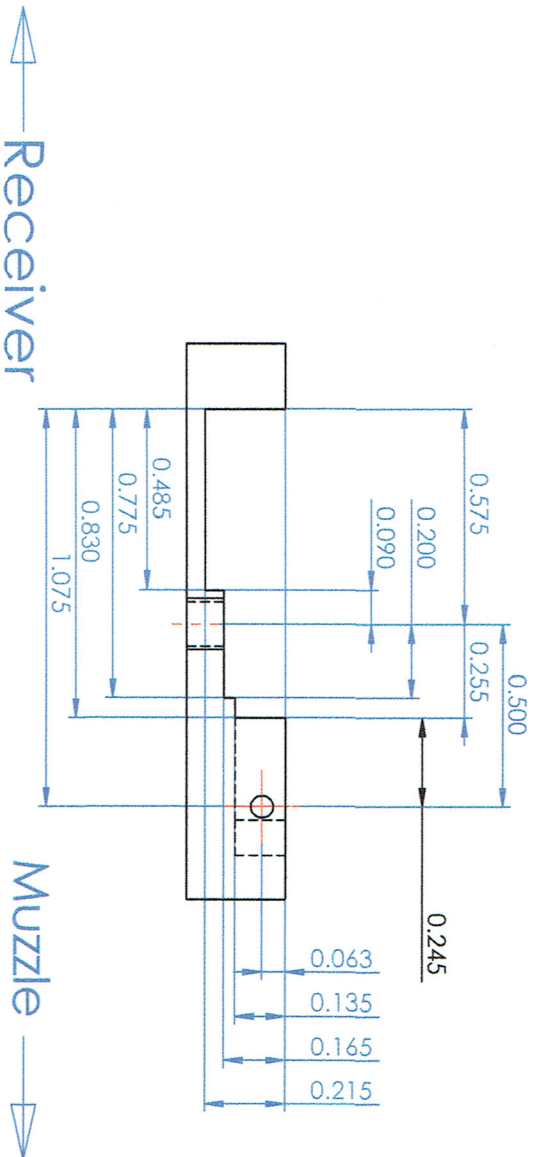
www.briley.com

email: smp@briley.com

Tel: 800-331-5718



Rib



Briley Manufacturing

TITLE:

Rear Sight Cut
Shotgun Rib

SIZE	DWG. NO.	REV
A	XXXXXX	0