



BRILEY

Briley Auto Shotgun Front Sight Installation

Briley front sight for auto shotguns is designed to be used with the .080" diameter Hi Viz™ light pipe, both round and triangular version. The sight can be fitted on the rib at the front of the barrel just behind the muzzle or if the rib tapers away before the muzzle then just behind the taper. A drawing is included to assist in the dimensions needed to be cut. The drills shown in the dovetail are an accurate method you can use to measure the dovetail cut. One can also use gauge pins as long as they are small enough to fit into the dovetail. You will require the following tools:

- Quarter inch end mill.
- 65° Dovetail cutter.
- 1/16th drill.
- Small center drill.
- Loctite, preferably 271 or 680.

Barrel will need to be clamped and leveled in your milling vice. Do an initial clean up cut on the rib not exceeding .010" in depth and then cut as shown in the drawing. The rib material is usually dead soft so it is recommended that you cut the dovetail two or three thousandths of an inch undersize. Use a 65° file (available from Brownells) to slightly bevel the edge of the dovetail to initially allow the sight into the dovetail. After degreasing the cut, apply Loctite™ and using an aluminum punch carefully drift the sight into position. It is recommended that the sight also be pinned using the 1/16th supplied roll pin. Drill a hole in the middle of the dovetail in the light pipe channel. Be sure to calculate the depth that you can drill into the rib without damaging the barrel. Cut the roll pin to the required length and drift into place. Make sure it does not interfere with the

insertion of the pipe. If the sight ever needs to be removed the roll pin can be easily drilled out.

Additional lite-pipes can be purchased from either Briley manufacturing or Hi Viz™ and the version required would be:

TriComp & Remington ETA Replacement LitePipe

www.briley.com

email: smp@briley.com

Tel: 800-331-5718

