



Brownells Stuck Choke Removal Tool is a heavy duty, expandable wrench for use when your normal choke removal methods fail. It allows removal of chokes stuck due to over-tightening, rust or dirt. Although the choke may be damaged during removal, careful use of this tool should not harm the barrel.



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.

Although the Stuck Choke Tube Removal Tool can be used in the field, it is intended to be a bench tool. If a choke tube has been installed in the barrel with the tightening/removal slots stripped out, you may be able to remove the tube in the field with the Removal Tool without damage to the construction area of the choke tube. To remove a badly stuck choke tube (rusted, damaged etc.), we recommend the barrel be taken to the work shop and clamped firmly into a padded bench vise that will increase your leverage on the barrel and also help prevent any incidental damage to the barrel's finish.

HOW TO USE

To use this tool you will need both a $\frac{3}{16}$ " and $\frac{5}{16}$ " hex wrench.

- 1) Double check to make sure there is no ammunition in the chamber, carrier, or magazine.
- 2) Insert the $\frac{5}{16}$ " hex wrench into the upper hex bolt, insert the $\frac{3}{16}$ " hex wrench into the lower hex bolt and loosen both bolts. This will allow the knurled jaws to come together and touch under the pressure of the "O" ring.
- 3) Insert the Tool into the choke tube until the "O" ring resets against the muzzle end of the tube.
- 4) Tighten the lower bolt with the $\frac{3}{16}$ " hex wrench until you feel the jaws of the tool *just* touch the inside surface of the tube.
- 5) Tighten the upper bolt with the $\frac{5}{16}$ " hex wrench until the opening between the jaws is about parallel.
- 6) Continue tightening the lower hex set screw until you feel the knurled teeth on the jaws "bite" into the walls of the choke tube. Use only enough pressure to prevent the Tool from slipping in the tube.
- 7) Unscrew the tube from the barrel without putting side pressure on the tool. **IMPORTANT NOTE:** Use caution and good judgement as you

apply turning pressure against the Removal Tool. Any side pressure may distort the barrel wall at the choke tube recess and may even cause the barrel of a very thin-walled installation to fracture.

- 8) When installing a new tube into the barrel, remember to use Choke Tube Lube, available from Brownells.

If the choke tube is stuck because it is bulged from firing a shell with an obstruction in the bore or from the use of steel shot in lead shot only tubes, the Stuck Choke Removal Tool may not be able to remove the choke tube. In this situation, your only remedy may be to shorten the barrel and rethread it for choke tubes. Remember, Federal law requires that shotgun barrels be longer than 18" - not including any extended choke tube. Also, on rethreading any barrel for choke tubes, double check that the bore size and barrel wall thickness are appropriate for the type of the tube being fitted.

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[®] STUCK CHOKE TUBE REMOVAL TOOL

READ & FOLLOW THESE
INSTRUCTIONS

BROWNELLS

SELECTION. SERVICE. SATISFACTION.[®]

200 S. Front St. Montezuma, IA 50171
800-741-0015 or 641-623-4000 • www.brownells.com

World's Largest Supplier of
Firearms Accessories and Gunsmithing Tools.[™]