



Magazine Tube Detent Swage Tool

Remington 12 Gauge Series
Pump & Semi-Automatic Shotguns

In the past, installing a magazine tube extension on one of the 870/1100/11-87 series of shotguns was as simple as removing the mag cap, prying up the magazine spring retainer and swapping out springs before screwing on the extension. With the advent of the detent style magazine spring & mag cap retention system this is no longer possible. Now one has to find a way to remove those detents so the follower can slide past them.

The most common solution is to grind them away from the inside; while effective, this looks terrible and creates two ready access holes in the mag tube for dirt & other debris. XS[®] Sight Systems Magazine Tube Swage will allow you to easily remove these detents without creating these holes.

Instructions

1. Unload the firearm. Double check that there is no ammunition in the firearm.
2. Completely read through these instructions before proceeding. If you have any questions, please call our toll free tech line and we will be glad to help.
3. Remove the magazine cap.
4. Remove the barrel.
5. Remove the magazine retention plug by pushing it in and turning a quarter turn (either direction). When you release pressure the plug should now slide up and out of the magazine tube.
6. Remove the magazine spring and follower.
7. Apply a thin layer of grease on the Magazine Tube Swage and inside the magazine tube on the detents using a Q-tip.
8. Insert the Magazine Tube Swage in the mag tube until it stops against the detents.
9. With a medium size hammer (need oz size here) drive the swage in until it the large shoulder on it stops against the end of the magazine tube.
10. Peen on and around the area of the two detents using a 1/8th to 1/4" diameter steel punch (the face of which should be as smooth as possible) and the same hammer used to drive the swage into the mag tube.
11. Heavy blows are not needed, grasping the hammer handle 1/2 way up the handle will give you all the power you need and allow to better control.
12. Continue peening on and around the two detents until the swage slides free.
13. Clean the inside of the magazine tube and check to see if the follower will slide past. If it stick or binds, a light dressing of the area with the sanding drum of a Dremel tool will finish up the process.
14. If, upon attempting to reassemble the barrel, you find the barrel lug binds on the magazine tube, lightly dress the dimple areas on the exterior of the magazine tube with a smooth fine file until the barrel can easily slide in place. Cold blue the dressed areas & oil.
15. You are now free to assemble the shotgun with the magazine tube extension according to the maker's instructions.