

## **BOLT COLLAR INSTRUCTIONS**

***In the picture above, from top to bottom are a Rem., Win., and Sako bolts. They are the most common but the collar will work on other bolts the same way. The allen is offset and designed that way to make access to front bolt nose cuts easier. These bolts are assembled and would have to have a stub arbor in the back to mount in a four jaw to dial in on your lathe.***

***The collar is installed after you have dialed in and recut the rear of the bolt lugs. Sliding the tail stock back, or retracting the live center with the hand wheel, position the collar with the allen towards the face of the bolt. Then screw the point of the allen in to the gas port, on a Rem. bolt, locking firmly. On other bolts put the point of the allen into a roll pin hole for the ejector. Bring the live center back and take light cuts until the collar has a full true O.D..***

***Now mount your steady rest and clamp into position to run on the collar. Then and only after checking to make sure everything will turn without any mishaps, lube the collar and tips, spool up the lathe and set the steady rest tips with the lathe running. Shut down the lathe, back out the tail stock and setup for the facing cuts on the front of the bolt.***