

Reamer Holder Instructions

STEP 1: Loosen the three thumb screws on the front collar.

STEP 2 : Slide reamer into the front collar. The rear face of the reamer shank should be flush with the rear face of the front collar.

STEP 3 : Tighten the allen in the front collar to hold the reamer. Tighten only on the round portion of the reamer, not onto a flat. The reason for this is a weak link in the holding setup. If a reamer should grab, this will give first. Instead of snapping the reamer in the barrel or spinning the dead center in the tailstock.

STEP 4 : Slide center into the tailstock and set tight.

STEP 5 : Adjust the three thumb screws so the reamer is pulled firmly up against the dead center, then to align reamer pilot for a perfect entry into to bore with the three thumbscrews.

STEP 6 : Now continue to chamber as your setup on your lathe warrants.