



The Uni Throating reamer appears the same as any other—a removable pilot up front followed by a 6-flute cutter at the desired throat angle. Rearward of here, things get a little different. On the straight portion of the cutter body a heat treated steel bushing (just under '06 diameter in this case) with a tapered nose is fitted to microscopically tight tolerances: it will both rotate and slide freely fore and aft, but exhibits zero lateral movement. Underneath this bushing, the flutes come to an end and the threaded shank begins, at 40 TPI. Rear of the bushing a pair of brass lock nuts is fitted: the forward one of these is graduated with 5 equidistant marks around its circumference, each equivalent to .005" and readily readable to .001". The rear nut is knurled.

In practice, the reamer is gently inserted into the "control" chamber while being rotated in the backward (non-cutting) direction until contact is made with the lands. You may also do this in a dummy chamber cut to the correct dimensions. The lock nuts are then given a rough adjustment and secured, and the process is repeated until the correct length is achieved. If you want to go deeper, back the lock nuts off the requisite number of thousandths and re-secure. You now have a throater that will cut an identical throat in every chamber it enters. There are two points of lateral control, the forward pilot and the nose of the bushing, which engages the shoulder of the chamber to assure a good measure of concentricity.

Dave has set this reamer up so that it may be used in a lathe in the traditional way, or screwed onto the end of a T-Handle extension, in which form it may be used with the action still on the barrel. This particular unit is usable on all calibers from the short throats used in hunter bench rest on up through the various magnums, belted and otherwise. It is available in any caliber, with any throat angle you wish, and it is useful for any throating work you may require. Needless to say it is extremely useful wherever a higher degree of repeatability is essential.