-JB Reamer Stop Instructions-

GEN II: LOT 24B AND ONWARDS

Thank you for your business and choosing the JB Reamer Stop from Bauduin Accuracy and Machine! Below are the instructions on using the reamer Stop. This tool is designed to be used with reamers that have a 7/16" (0.4375) shank and has been checked that it will work with reamers from .17 Remington up to .338 Lapua. If you have any issues, questions, suggestions, please see my contact information at the end of the instructions. Please see the images below for visual examples and the parts diagram of the JB Reamer Stop. Thank you!

-CLEANING-

The reamer stop will come with a small amount of anti-seize applied to the threads. This prevents galling and makes for a smooth operation. There is no need to disassemble the reamer stop when it's new. After using the reamer stop, clean all parts to remove any chips, cutting oil, and any other debris from the threads. Clean it with brake clean, mineral spirits, alcohol, or equivalent. Re-apply a small amount of anti-seize to the threads before reassembling. If you choose to, you can apply a thin coat of oil to the outside, however all parts are made of stainless steel and are fairly corrosion resistant. If you don't plan to remove the reamer stop, you can leave it locked on the reamer shank to maintain the desired headspace.

-HOW TO USE-

REAMERSTOPS FROM LOT 24B onwards have two length bodies, short and long. Start with the short body and follow the instructions below. If there's not enough adjustment with the short body, switch to the long body and repeat the instructions

REAMER STOPS FROM 24B onwards do not have a locking set screw in the adjustment sleeve

1- Insert your chosen chambering reamer into the reamer stop from the front. Slide the reamer all the way into the counterbore of the reamer stop body until it stops against the shoulder at the rear of the counterbore. For reamers small enough to pass through the body without stopping (ex. 0.223 Rem), slide the reamer through the body until you start to see the fluted part of the chamber reamer. At this point, lock the set screw down using the provided Allen wrench. Tighten the set screw down by holding the long end of the wrench with the small end inserted in the set screw. Make the screw hand right or around 20 inch lbs.

2- FOR ACTIONS WITH RECESSED BOLT NOSE (REMINGTON STYLE) OR CONE BOLT Set the shoulder of the GO headspace gauge, or the top of the belt on the belted gauge, roughly .050 above the shoulder (or belt) on the chamber reamer. **See Figures I, II, and III for visual examples.**

FOR ACTIONS WITH A FLAT BOLT NOSE (ex. BAT Vampire, BAT HR, KELBLY ATLAS) Measure the depth of the bolt face **(FIGURE IV)** on your bolt and add .050 to that number, take that number (**example: 0.200**) and use either a fine tipped sharpie or Dykem and your calipers to make a line **EXAMPLE 0.200** down from the GO headspace gauge shoulder onto the gauge's body. For a belted reamer, put the mark **EXAMPLE 0.200** below the top of the belt on the GO headspace gauge. Line up the sharpie mark on the GO gauge with the shoulder of the reamer, or the top of the belt on a belted reamer. **See Figures V and VI for visual examples.**

Next, thread the Adjustment Sleeve forward so when the back of the GO gauge is resting on the face of the Adjustment Sleeve the GO gauge is in the approximate location as described above. If there isn't sufficient room to move the Adjustment Sleeve and Lock nut further back to achieve headspace, loosen the set screw and slide the reamer out some. If there's still not sufficient forward travel in the Lock Nut and Adjustment Sleeve after moving the reamer further out, switch to the LONG reamer stop body. After getting your Adjustment Sleeve set with your headspace gauge, run the Lock Nut up to the Adjustment Sleeve until it stops. Thread the Adjustment Sleeve and Lock Nut further out until the reference line on the threaded reamer stop body is set on a whole number on the Lock Nut. This will be your starting point. **Each mark on the Lock Nut is .001 and every .005 is marked with the corresponding amount of travel, with a total of .025 per revolution.** There's an 1 / 8" hole in the front of the adjustment sleeve that can be used to further tighten the adjustment sleeve against the Lock Nut. Use a round, non marring, piece of drill rod, back end of a drill bit, etc to tighten and loosen the Adjustment Sleeve.

3- Insert your chamber reamer into your reamer holder and begin your finish chambering process.

4- When you're getting close to the Adjustment Sleeve contacting the back of your barrel, make sure there are no chips on the face of the reamer stop or on the face of your barrel tenon. Blow off the face of the reamer stop and barrel with shop air/compressed air or wipe off with a clean rag. Also make sure your tenon face is burr free. When you make contact with the back of the barrel, lightly turn the tailstock until it stops. Every machine is a little different and you will have to learn your tailstock and get a "feel" for when the reamer stop is against the barrel tenon. Failure to make contact with the back of the barrel will give inconsistent results. Furthermore, pushing too hard can potentially cause galling of the reamer stop and/or barrel face and in extreme cases move the barrel in the fixture/spider/chuck.

5- Check headspace using your chosen method. Loosen the Adjustment Sleeve and move the Lock Nut the desired amount, then thread the Adjustment Sleeve back against the Lock Nut until it's tight. Verify the Lock Nut is locked down and not easy to move and that it's still on the correct setting. **I recommend sneaking up on your desired headspace and making several "cuts" with the reamer. This will verify things are correct and build confidence in the system.**

6- Once desired headspace has been achieved, the JB Reamer Stop can be left locked in position and used to set headspace on the next chamber without needing to make any necessary adjustments (unless the reamer is worn or something gets inadvertently moved.) The prototype of this design was used to chamber a dozen .223 Rem barrels. The JB Reamer Stop repeatedly held headspace +/- .001 on all of the chambers. This is extremely beneficial for production runs of your most popular reamers. **THANK YOU!**

- CONTACT INFORMATION -

Bauduin Accuracy and Machine LLC
Jerry Bauduin
304-914-6444
jerry6br@gmail.com
Jud96 https://forum.accurateshooter.com

FIGURE I.

FIGURE II.

FIGURE III.

FIGURE IV

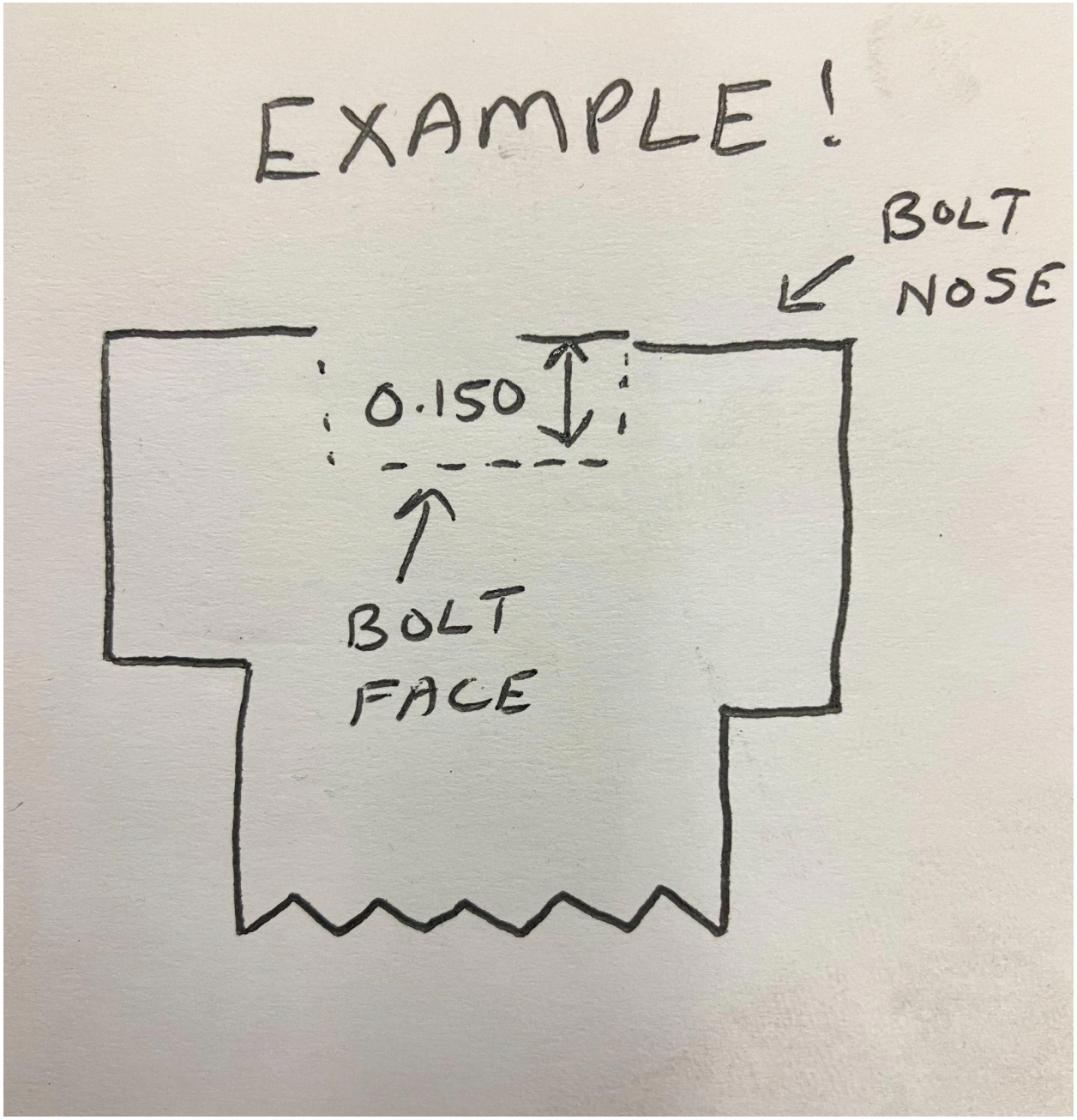

FIGURE V

FIGURE VI

PARTS DIAGRAM