

Carbide Insert Trimming System

Features:

- Large Cutter Head Assembly Trim up to 1-11/64" Dia.
- Replaceable Blades – 4 cutting surfaces per blade!
- Pilot Sleeves adapt to multiple tube sizes.
- Blade positioning eliminates gap between shaft and cutting surface.

Parts:

- Cutter Assembly
- .242" Pilot (fits 7mm tubes)
- 5 Pilot Sleeves – 8mm, 3/8", 10mm, 10.5mm, 12.5mm tubes – adapt to 8 tube sizes (9 total)
- Two 12mm replaceable Square Carbide Inserts – #PKTRIMSX
- Two Screws for Carbide Inserts
- T15 star wrench to lock in Insert Screws
- 2mm hex key to lock Set Screw for Pilot Shaft

Recommended Accessories:

- Drill Press or Portable Drill
- Vise or clamp for holding blanks (See Trimming Methods)

Preparing for Trimming:

- Check length of pilot and sleeve compared to length of tube. If either is longer than tube, use a scrap piece of wood with hole drilled to accommodate the extra length. Insert sleeve into hole so that it sinks below the end of the tube when trimming.
- Glue up blank according to instructions.
- When the glue is dry, blank is ready for Trimming.

Trimming Methods:

The purpose of trimming is to remove excess blank material so that the blank ends are 90° to the tube and the final barrel length is equal to the tube length. The following methods will promote achieving a good final product.

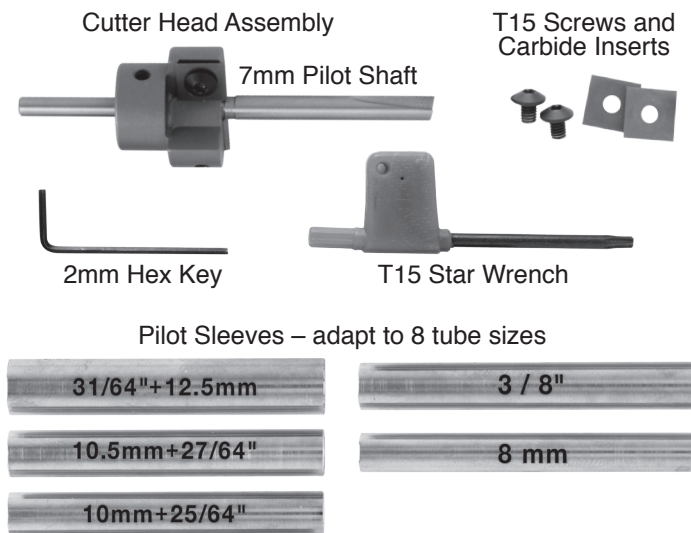
Drill Press:

- When using Drill Press, do not secure blank in a vise. Blank must be loose to align the internal tube with trimmer pilot. A Vise can force the trimmer to misalign with tube, causing angled end surfaces and internal distortions of the tube.
- It is recommended to hold the blank with a handheld Clamp or Pliers to avoid injury and allow pilot alignment. Blank should be held securely enough that it does not easily rotate.
- Using a Ratchetting Spring Clamp will hold blank firmly yet allow it to release if there is a catch – which reduces blowout.

Handheld Drill:

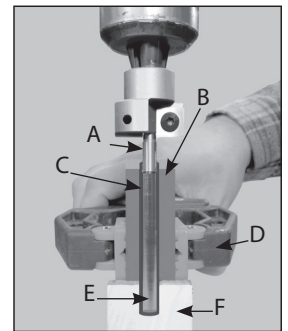
- When using Portable Drill, Blank can be secured in a vise.
- Hold vise firmly but loosely. If a catch occurs, holding the vise too tightly can cause blowout of the blank.

Diagram A / Parts



Trimming Procedure:

- Use light pressure when pushing trimmer into end of blank.
- If a catch occurs, stop drill to examine and reset blank. Restart trimming very lightly to get past area where catch occurred.
- Check progress frequently. Trim until you barely touch the brass on the tube. Reducing length of tube by even small amounts can affect final assembly and function.
- When done trimming, check tubes for accidental trimming. If present, use deburring tools to remove burrs that can interfere with pressing.
- It can help to measure final barrel length to verify barrel length is equal to tube specification listed in instructions.



Blank (B) is shown being held by ratchetting clamp (D) to allow Tube and Trimmer to self align. Pilot Sleeve (E) is shown inserted into Tube (C) in Blank. Trimmer Pilot (A) goes into sleeve. Scrap piece (E) shown with hole drilled to accommodate excess length of the Pilot Sleeve because Tube is shorter than Sleeve.

Changing Blades:

To switch blade to new side, use T15 key to loosen the screws holding the blade so that blade can spin freely. Rotate blade to new side. It is helpful to mark the used side with permanent marker and always rotate in the same direction. When all sides are dull, remove screws completely and replace both blades.

If needed, shaft can be replaced by loosening the hex key located in smaller section of Cutter Head. Use 2mm hex key (included). When putting new shaft in, line up recess on thin section of shaft with the set screw.

