



## **Barrel Facing tool Information and Instructions** **- With New Style Pilot -**

This tool is designed to perform three tasks simultaneously; remove the extra wood from the end of the blank, square the end of the blank, and remove glue from the inside of the tube, which are all critical to pen making. This design can be mounted directly in the chuck of the drill press, hand drill or 3 jawed chuck. This style cleans glue more effectively from the tube than other types of pilots or reamers on the market.

The barrel facing tool comes with a 5/8" cutterhead or an optional 3/4" cutterhead. There are 3 inter-changeable pilots available. The 7mm pilot fits all standard pens, pencils, key rings, and letter openers, plus it can be

used on the 8mm perfume pens. The second and next largest size pilot fits the Amero-classic double twist ballpoint, the Ameroclassic pencil and the Eurostyle pens. The last and largest pilot fits the Ameroclassic rollerball and fountain pens. This is also the pilot that should be used on the style of rollerball that uses a 10mm tube.

To use your barrel facing tool in a safe manner, we suggest using a vise to hold your blank. Or, you can clamp a Pen Drilling Jig to your drill press. With your lathe or drill press turned on, slide the pilot into the tube. Apply moderate pressure against the cutterhead sufficient enough to remove the excess wood down to

the brass. Take care not to remove any brass. Some pens will not function properly if the brass tube has been shortened. Complete the other end in a similar manner.

To trim barrels in which the tubes are slightly larger than the pilot, simply hold the barrel with your pliers against one side of the rotating pilot. Be sure you do not rock the barrel.

To sharpen your tool, remove the pilot reamer and place the cutterhead in a vice to secure. The cutterhead is composed of hardened tool steel. We have found that a diamond file stock #2555 works quite well in touching up the cutting edges.

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