



PN 25583

Annular Cutter Assembly

Assembly Instructions

Rev: 3/20/13



Parts List

- **Annular Cutter (inside diameter matching the finish barrel OD size that you want)**
- **Pilot (threaded stem should fit closely through the cutter, pilot side should fit closely to barrel hole)**
- **Two 1/4-20 nuts to retain the pilot**
- **3/8" shank adapter to connect to power drill**



Instructions

1) Insure that the pilot and annular cutter are the appropriate size for the job at hand.

2) Insert the pilot through the front of the cutter and, from the back side, run one nut down until it is close to the rear face of the cutter but not tight. Hold this nut with a wrench and run the 2nd nut down to meet it. Use another wrench to tighten the 2 nuts together.



The pilot should now have minimal play from front to back but still be able to spin freely inside the cutter.



3) Line up the 2 set screws in the shank adapter with the 2 flats on the 3/4" annular cutter shank.



4) Tighten them up with a 1/8" hex wrench and check again that the pilot can spin freely (This will protect the inside of your barrel from wear during the cutting process).

5) Attach to a power drill and carefully cut the barrel to size. Turn it very slow (200-250 RPM). Also cut in small increments, retracting the cutter, removing chips, and adding cutting fluid often as you proceed to the desired depth.