

### **-JB Reamer Stop Instructions-**

Thank you for your support and choosing my Reamer Stop! Below are the instructions on using the JB 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, feel free to PM on Accurate Shooter or reach out to my contact information below. 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 416 stainless 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-**

**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-** 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.** Next, thread the Adjustment Sleeve forward until the face of it touches the back of the GO gauge. 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 1/8". After getting your Adjustment Sleeve set and your headspace gauge ~.050 above the reamer shoulder/belt, 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 LONG line on the Lock Nut. This will be your starting point. **Each mark on the Lock Nut is .001 and every LONG line indicates .005 of adjustment, with a total of .025 per revolution.** Take your Allen wrench, holding it by the short end, and thread the brass set screw in until it's finger tight against the Reamer Stop Body threads. This will make sure the Adjustment Sleeve doesn't come loose or become overtightened when it is bumped up against the back of the barrel. **\*DO NOT OVER-TIGHTEN THE BRASS SET SCREW. Over-tightening the brass set screw can lead to brass getting into the threads of the Reamer Stop Body, damaging the reamer stop threads, stripping out the threads on the set screw, or rounding the head of the set screw where the Allen key goes.\***

**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. With one hand, loosen the brass set screw and then loosen the Lock Nut (lefty loosey) the desired amount. **(Remember, each LONG line is .005, and each SHORT line is .001.)** While holding the Lock Nut on the desired line with one hand, thread the Adjustment Sleeve back against the Lock Nut until it's tight with the other hand. Hold the Allen wrench by the short end and use the long end to finger tighten the brass set screw. 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 -**

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**FIGURE I.**



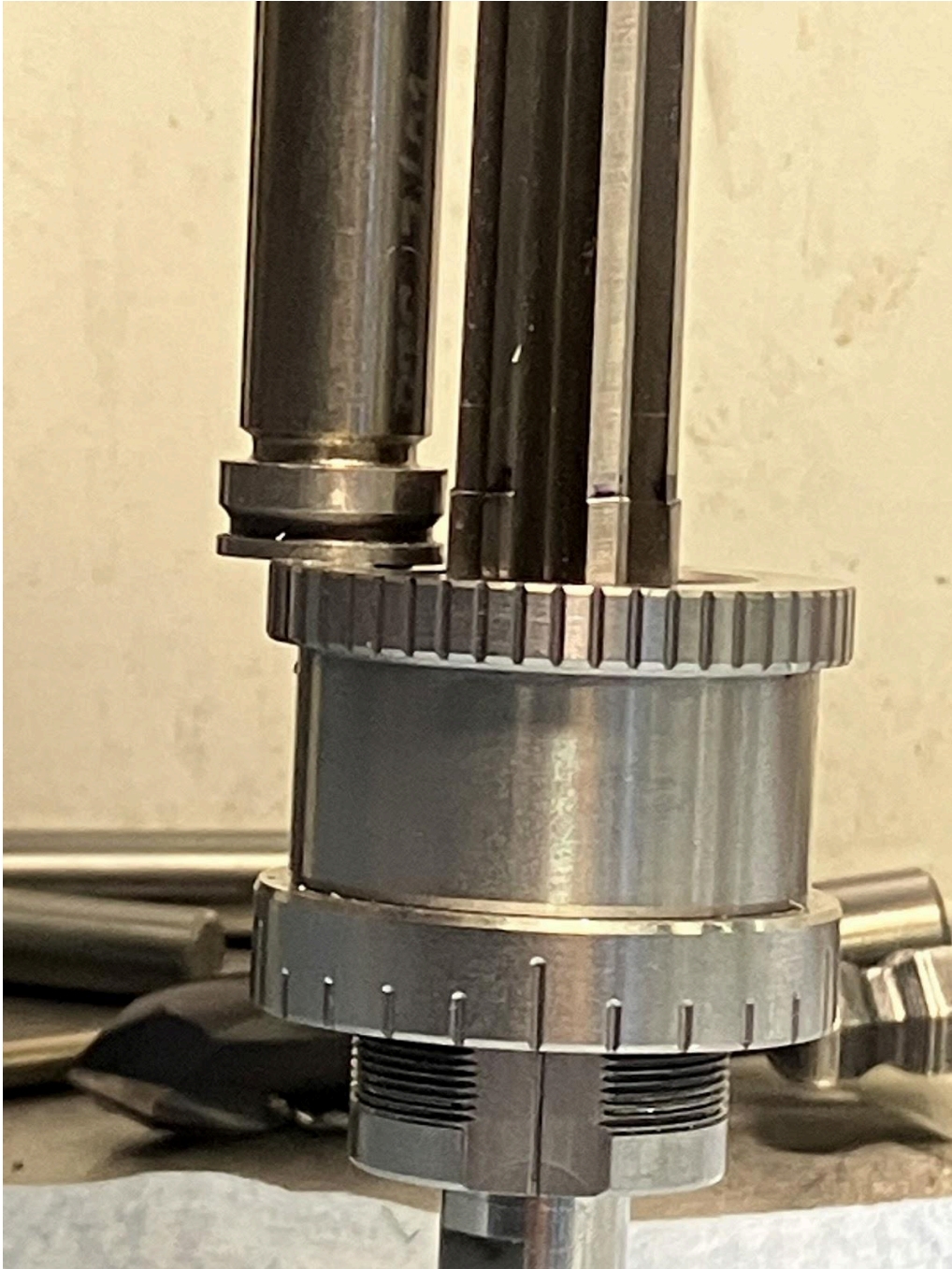


**FIGURE II.**





**FIGURE III.**



## PARTS DIAGRAM

