

Flex Coat's New Concept Pre-Shaped Cork Reverse Pilot Bit

Description

Designed to bore out the inside diameter of pre-shaped cork grips twelve to thirteen inches in length and with a minimum inside diameter of $9/32$ " and maintain a centered hole. Flex Coat is offering these new concept bits in three sizes, $3/8$ ", $1/2$ ", and $5/8$ ".

The bottom edges of the bit have been ground to become the cutting edges and the pilot will be masking tape arbors wound onto the shank of the bit below the cutting edges. Enlarging the Inside diameter is done by pulling the bit through half way and then reversing the bit and finish boring by pulling the bit through from the other end. The boring meets in the middle of the grip and prevents chipping and ragged edges from the bit exiting the grip. The bit is not pushed through the grip.



Instructions

Step 1

Select the size bit that you need the grip bored to slightly smaller than the blank it is going to fit on. Final taper reaming can be done after the grip has been bored.

Step 2

Begin wrapping masking tape around the shank of the bit just below the cutting edges. You are building up tape arbors just like it is done to fit a reel seat onto a blank, you can chuck the bit into the drill and turn the drill on at a slow RPM to wrap the tape onto itself or you can hold the bit in one hand and the tape in the other. It is important that the tape be wound onto the shank of the bit with the bit turning in a clockwise direction. The arbors should be a good fit to the inside diameter of the pre-shaped grip. The boring process will be done with the drill set in forward cutting mode even though you are pulling the bit through the grip and not pushing the bit through the grip. Put tape arbors along the shank of the bit so that the length of the arbor section is about half of the length of the grip. The spacing between arbors should be no more than the width of the tape you are using. For example, if the grip is 11" long then the arbor section should cover about at least 5" or $5 \frac{1}{2}$ ".

Step 3

Slide the bit through the grip with the bottom of the bit protruding from the other end. Chuck up the bit in a hand held electric drill. Do not use a drill press. Pull the trigger on the drill, turning it on, and begin pulling the rotating bit into and through the grip. When you have cut your way to the midpoint of the grip turn off the drill. Take the bit out of the drill chuck and the grip. Slide the bit through the grip from the other end (the uncut end) and put the drill shank back into the drill chuck as you did in the beginning of this section. Turn the drill on and begin pulling the rotating bit into and through the grip as before. When you have passed the midpoint, turn off the drill and pull the bit on through the grip.