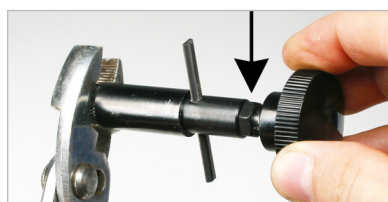
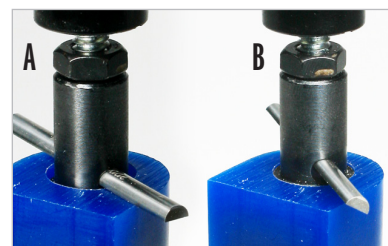


# Contenti

## INSTRUCTIONS FOR THE MATT REAMER

No. 170-487

**1. ADJUST THE WING BLADE** Slide the wing blade through the reamer hole, then insert the reamer into your wax tube. For general use, position the blade so that the flat side of the blade lies flat against the face of the tube (as shown in figure A). For more aggressive cutting, position the blade at a slight angle to the face of the tube (as shown in figure B). Tighten the plastic knob by hand to prevent the blade from moving, then remove the reamer from the wax tube.



**2. TIGHTEN THE BLADE** Holding the knurled end of the tool with pliers, tighten the plastic knob firmly by hand. To prevent the knob from working loose during use, tighten the locking nut (indicated by the arrow in the photo at left) with an adjustable wrench.

**3. SMOOTH THE TUBE END** Insert the reamer into the wax tube and rotate the reamer clockwise and counterclockwise while applying slight pressure. The reamer is designed so that the wing blade will cut in both directions, sheering off a thin film of wax with every stroke. Continue rotating the reamer (applying even pressure) until the surface of the wax tube is perfectly flat and smooth. *Before proceeding to the next step, it is recommended that you smooth the other end of your wax tube and any other wax tubes you have. This will save time switching the boring bit and wing blade between every step.*



**4. INSTALL THE BORING BIT** To remove the wing blade from the reamer, loosen the locking nut with an adjustable wrench and then loosen the plastic knob by hand. Remove the wing blade and replace it with the boring bit. Position the bit as shown in the photo at left, lining up the desired size marking with the edge of the reamer. Size markings on the boring bit correspond to US standard ring sizes 5-15. *Tighten the boring bit by following the procedure in step 2.*

**5. BORE THE WAX TUBE** Insert the reamer into the wax tube and rotate clockwise while applying slight pressure.\* The hole will be enlarged quickly and precisely, leaving a uniformly smooth finish on the inner walls. Continue turning the reamer clockwise until the hole is a few millimeters deeper than the desired width of the finished ring. *\* It is recommended that you measure the inside diameter of the hole after the first few turns to ensure that the size is accurate. Then, make any necessary adjustments.*



**6. FINISH THE RING BLANK** Mark the desired width of your ring blank and cut it off using a jeweler's saw. To finish the rough side of the ring blank, place the smooth side of the blank against the smooth end of the wax tube. To attach the ring blank to the tube, use a heated wax tool and spot weld the seam in several places (as indicated by the arrows in the photo at left). Locate the welds where they will not interfere with the final design of the ring. Replace the boring bit with the wing blade, positioning it at a slight angle to the face of the ring blank (see step 1, figure B). Insert the reamer into the wax tube and rotate clockwise while applying gentle pressure. Continue rotating until the surface of the ring blank is perfectly flat and smooth. Be careful not to detach the ring blank from the wax tube.

*NOTE: The body of the Matt Reamer is precisely ground to fit into the hole of wax tubes with very little play. In cold weather, some wax tubes may shrink slightly, making it difficult to insert the reamer. Warming the wax tube for a few minutes will solve this problem.*