



Draw filing is generally used to prepare long flat surfaces, such as octagon barrels or the flat sides of shotgun and rifle receivers, for final polishing prior to bluing. Round barrels can be draw filed to remove pitting or roughness prior to hand or machine polishing. The Brownells Draw File is long enough to hang onto for draw filing, but since it has no tang or handle, is more controllable than standard files used for this purpose. The "safe" back of this file is great to back-up abrasive cloth or paper in hand polishing operations where it is important to keep edges sharp and crisp.

As with any filing operation, a proper working area and supplies are important. The workbench should be heavy and vibration-free. The vise should be firmly attached to the bench, provided with proper soft jaws, and the tops of the jaws should be at elbow height, to reduce fatigue. Good lighting is essential to proper draw filing. A fluorescent fixture directly above the vise will provide basic light. A "gooseneck" desk lamp, with a 60 or 75 watt bulb, will give proper shadow effect to see imperfections in the work. A file cleaner should be used toward filings from the draw file. Common blackboard chalk, rubbed into the teeth of the file before starting work will help prevent "pinning", where metal filings clog the file's teeth and cause deep scratches.



WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

HOW TO USE

The draw file should be held with the long axis at right angles to the work piece. The hands are held on each side of the file, thumbs against the safe edge, facing the worker. The draw file works best when it is held so the teeth cut as it is pulled toward the user. Never push a file backwards -- the teeth only cut going in one direction. Pushing the file backwards, rather than lifting it from the work piece and repositioning it, will dull the teeth. Pushing down hard on the file when it is being used will create an uneven, wavy surface. Stopping the file's stroke in the middle of the long work piece, such as a barrel, will also cause an uneven surface.

When draw filing around barrels, very narrow overlapping flats are filed onto the barrel, each one about $\frac{1}{16}$ " to $\frac{1}{32}$ " wide. These will be removed by hand or machine polishing after the draw filing is completed. The safe edges and tooth form of this file permit draw filing right up to the ribs of shotguns, or sights on rifles. To keep lettering and factory markings legible, be sure to use extremely light strokes.

When polishing with the Brownells Draw File, use a good grade of abrasive cloth or paper. The safe back of this file is a perfect polishing surface since, unlike a regular file, there are not teeth to cut through the abrasive cloth and scratch the work.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner. **IMPORTANT!** If the firearm is a fully or semi-automatic design, start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.

BROWNELLS[®] DRAW FILE

#080-512-000



READ & FOLLOW THESE
INSTRUCTIONS

BROWNELLS[®]

SELECTION. SERVICE. SATISFACTION.[®]

200 S. Front St. Montezuma, IA 50171

800-741-0015 or 641-623-4000 • www.brownells.com

World's Largest Supplier of
Firearms Accessories and Gunsmithing Tools.[™]