

# Instructions for use of the Stein Stem Facing Tool

The Stem Facing Tool will mill the bottom of threadless stems to produce a precise contacting surface which aligns the upper bearing of the headset to provide a smooth bearing operation and maximum bearing life.

1. Insert the proper bushing into the stem and very slightly tighten the clamping bolts. It will need to be about 1 MM below the face of the stem to be milled.
2. Insert the guide pin of the Facing Tool into the bushing. Tightening the stem clamping bolts just slightly will snug up the milling tool guiding pin and leave a smoother cut on the face of the stem.
3. Holding the stem in one hand, rotate the facing tool with the other. The tool is turned a few times to mill the face. **BE VERY CAREFUL AS THE CUTTING TOOL IS VERY SHARP!!**
4. Remove the tool and check to see if contact was made all the way around the stem.
5. Repeat as necessary.

The carbide inserts may be removed and rotated when the cutting edge becomes dulled. Contact us for replacement inserts. For stems with a 1" steering tube, a 1" diameter bushing is available.

Designed and manufactured by: J. A. Stein Company 2002 Pine Drive Prescott AZ 86305  
Phone 928 778 1112 FAX 208 279-5904 e-mail: [jastein@cablone.net](mailto:jastein@cablone.net) [www.jastein.com](http://www.jastein.com)