



BE1127 Barrel Vise Instructions

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Introduction

The BE1127 Bald Eagle Barrel Vise is designed to mount to a solid base and provide the necessary clamping force to secure a firearm barrel for maintenance or removal.

This vise is made of high-strength T-6061 aluminum alloy to firmly grip the barrel without damaging it. The simple two-nut, spring-loaded design allows the user to hold the firearm with one hand while quickly securing/releasing it in the vise with the other.

⚠️ WARNING

Always make sure firearm is not loaded prior to servicing, assembling, or disassembling. Follow firearm manufacturer's guidelines or consult instruction of an expert for assembly/disassembly procedures. Failure to do so could result in misfire and serious injury or death.

Inventory

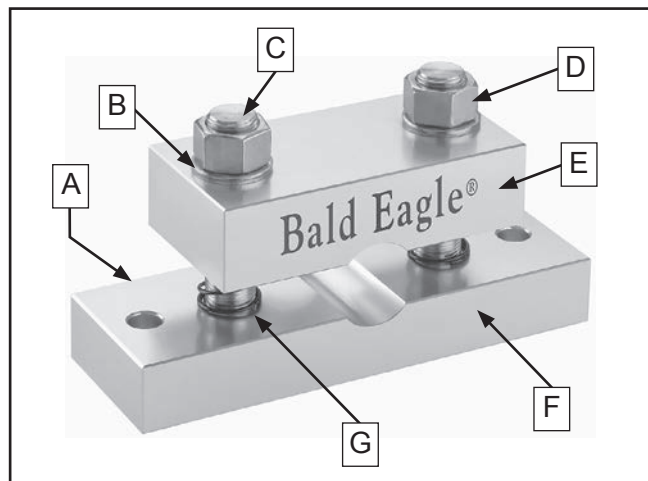


Figure 1. BE1127 Barrel Vise components.

Description	Qty
A. Set Screws $\frac{1}{4}$ -20 x $\frac{7}{8}$	2
B. Flat Washers $\frac{3}{4}$	2
C. Studs $\frac{3}{4}$ -16 x 4	2
D. Hex Nuts $\frac{3}{4}$	2
E. Vise Body (Top)	1
F. Vise Body (Bottom)	1
G. Compression Springs	2

Mounting Vise

Select a mounting location that will not slide or tip, such as a workbench or a trailer hitch (for mobile applications). When using a smaller or lightweight workbench, mount the vise considering the thread direction of the barrel. Greater force is required to remove barrels. For instance if the barrel is right-threaded, mount the barrel on the right hand side to prevent the workbench from tipping when removing the barrel (see **Figure 2**).



Figure 2. Mounting on a workbench.

Mount the vise flush with or slightly overhanging the surface edge, as shown in **Figures 2–3**. Ensure there is enough clearance to slide the barrel in as close to the action as possible and still do any service work on the barrel. Additionally, maintain enough clearance to rotate an action wrench and stock when assembling/disassembling the barrel from the firearm. Mount the vise using one of the two fastener configurations below.

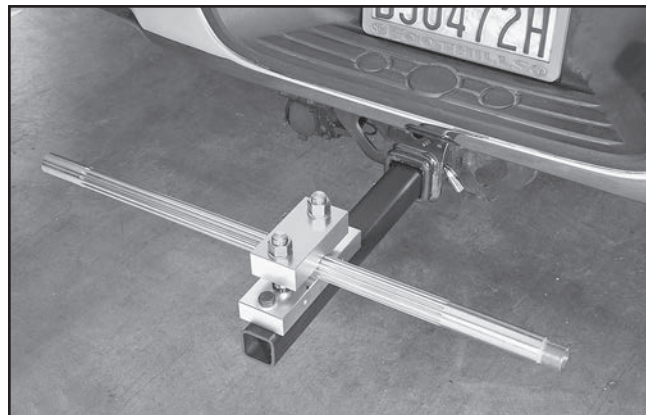


Figure 3. Mounting on a trailer hitch.

The base of this vise has mounting holes that allow it to be fastened to a workbench or other mounting surface. This prevents the vise from moving during barrel removal and causing accidental injury or damage to the firearm.

The strongest mounting option is a "Through Mount" (see **Figure 4**) where holes are drilled all the way through the workbench—and $\frac{7}{16}$ " hex bolts, washers, and hex nuts are used to secure the vise in place.

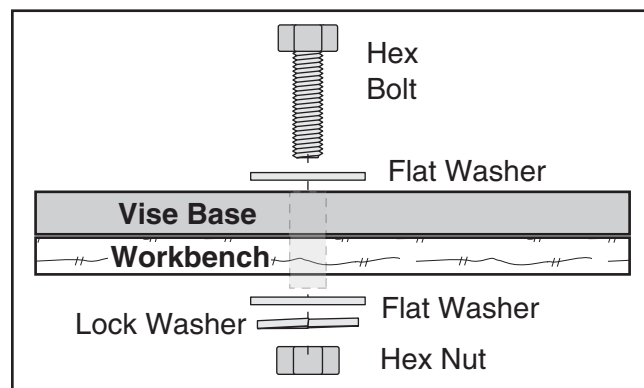


Figure 4. Example of a "Through Mount."

Another option is a "Direct Mount" (see **Figure 5**) where the vise is secured directly to the workbench with $\frac{7}{16}$ " lag screws and washers.

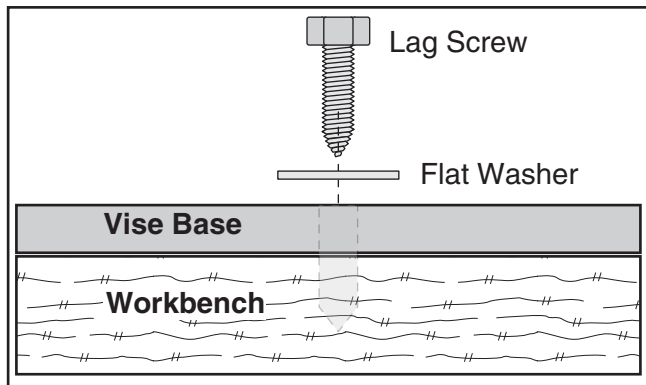


Figure 5. Example of a "Direct Mount."

Operation

This barrel vise is designed to secure $\frac{7}{8}$ "–1- $\frac{1}{2}$ " firearm barrels while performing various maintenance tasks, such as cleaning or exchanging barrels.

If the surface area of the firearm barrel is uneven and prevents proper gripping due to tapering or obtrusions such as sights or ribs, molding clay can be used to fill voids and create a constant clamping surface area.

Consult the manufacturer's instructions for specific directions on assembling and disassembling barrels with bodies.

To secure barrel with vise:

1. Follow instructions on previous page to mount vise.
2. Holding firearm firmly, slide barrel into barrel vise as close to action as possible.

Note: *Placing action as close to vise as possible decreases amount of stress placed on barrel and barrel bushing. This lessens the chance of barrel springing if removing barrel.*

3. Tighten the two hex nuts evenly, keeping top body of vise parallel with bottom body of vise until clamped finger tight (see **Figure 6**).

Note: *If barrel has a protective finish, place a thin piece of leather between vise and barrel to protect finish from marking. Use leather or similar gripping fabric to prevent barrel from slipping in vise if disassembling firearm.*

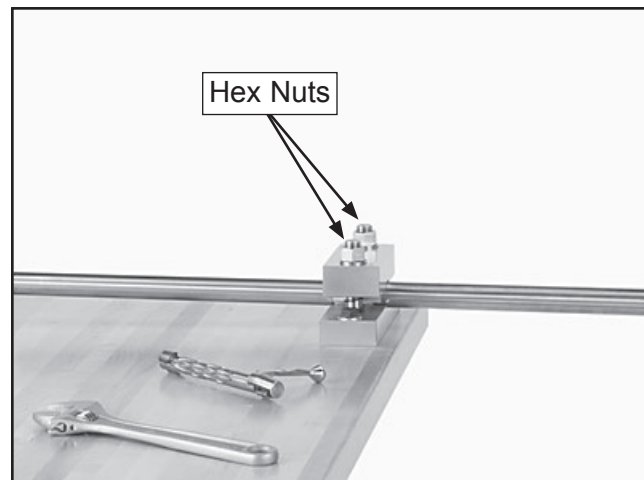
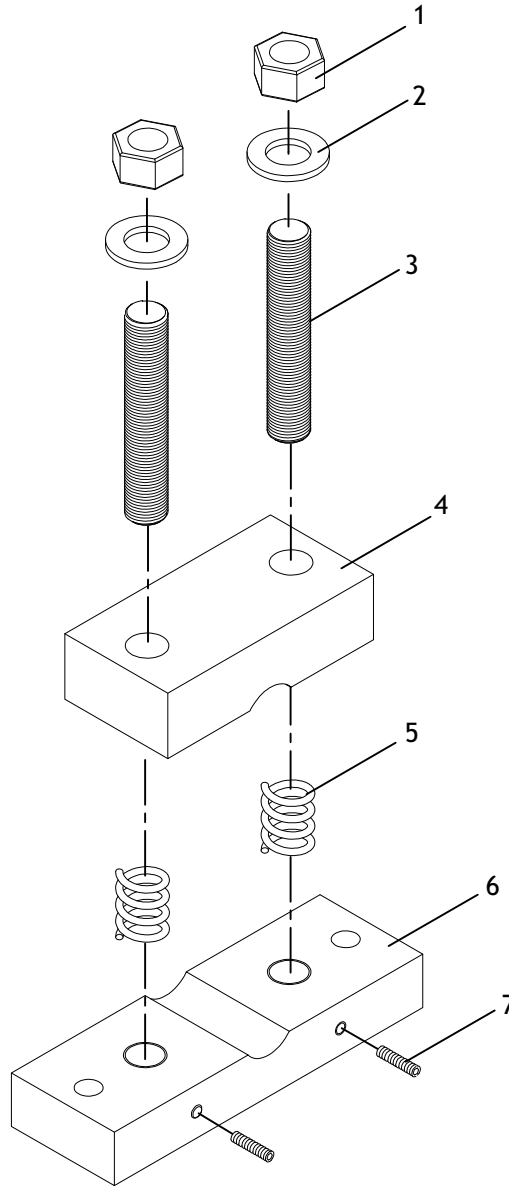


Figure 6. Securing barrel in vise.

4. Evenly tighten each hex nut with a 1" socket, maintaining parallelism between top and bottom body of vise until barrel is firmly secure. Avoid overtightening! Overtightening may crush thinner barrels.
5. To remove barrel from vise, hold onto firearm/ barrel and loosen the two hex nuts until barrel can be removed.

BE1127 Parts Breakdown



REF PART #	DESCRIPTION
1	PBE1127001 HEX NUT 3/4-16
2	PBE1127002 FLAT WASHER 3/4
3	PBE1127003 STUD-FT 3/4-16 X 4
4	PBE1127004 VISE BODY, UPPER HALF

REF PART #	DESCRIPTION
5	PBE1127005 COMPRESSION SPRING
6	PBE1127006 VISE BODY, LOWER HALF
7	PBE1127007 SET SCREW 1/4-20 x 7/8