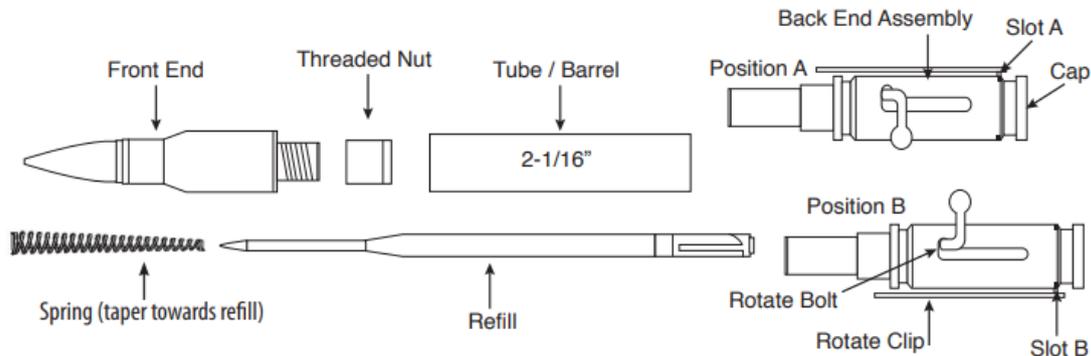


# RIFLE BOLT PEN KIT



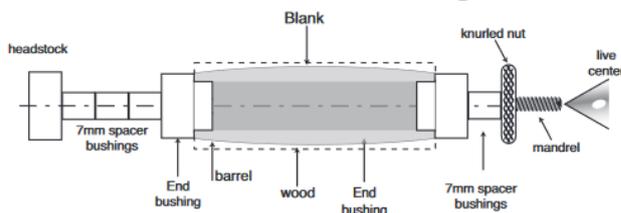
## Preparing the Blank

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 10mm hole lengthwise through the blank.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When the glue dries, Square the end of each blank. Use a Barrel trimmer with 10mm shaft or a universal pen blank squaring jig with a power disc sander. Take the wood down to the brass tube. Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly. Use the barrel trimmer shaft to clean the inside of the tube.

## Required Accessories:

- 7 mm, pen mandrel
- Drill bit 10mm
- Bushing set (2 pc)
- Barrel trimming set, use 10mm shaft
- Live Tailstock Center
- 2 part epoxy glue or insta-cure (cyanoacrylate) glue
- Minimum Blank size: 3/4" x 2-1/4"

## DIAGRAM B - Turning the Blanks



## Turning The Blanks

- Mount the bushings and blank according to Diagram B.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel).
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure. - refer to polish instructions.

## Assembly

- Position the bolt either in Position A or Position B. (Delivered in position A)
- Position A - Check to see if bolt is tightly in place. To tighten see Note 1
- Position B - Reverse the direction of the bolt. See Note 1 on loosening / tightening the bolt.
- Rotate the clip to slot B (press into slot)- do this by Unscrewing the Cap and rotating the clip.
- Re- attach the cap after re-positioned

### NOTE: Layout Finished parts according to Diagram A

- Press the threaded nut into either end of the barrel.
- Press the back end assembly into the opposite end of the barrel.
- Insert the spring over the refill.
- Place the bolt in an off position, insert the refill back end in first into the opening

NOTE: Please do not press the front end of this kit with the tip removed. If you do so the parts will not assemble properly and you will void our warranty

### NOTE1:

To loosen or tighten the bolt, loosen or tighten the set screw as shown below in diagram C. Take a long phillips screw driver with a small head, insert into the back end as shown. Rotate the bolt as necessary and tighten the set screw.

## DIAGRAM C

