



ALTRA ARROWS

ASSEMBLING THE ARCOS SYSTEM IN 166 AND 204 ALTRA ARROWS



Altra Arrows and components are designed around a tight tolerance precision fit. Because of these tight tolerances it may be necessary to clean or lightly sand the arrow shaft to achieve the optimum fitment. *These instructions will guide you to achieve that perfect fit.*

1

Cut the arrows to desired length with an arrow saw. Using an arrow squaring tool once the arrows have been cut to length is optional but recommended for having the best component-to-arrow fitment and alignment.



2

Test fit the insert and outsert in the arrow shaft separately to ensure proper fit of components prior to installing the inserts with glue and/or low temp hot melt. The outsert should fit to where it can be rotated on the arrow shaft so that you will be able to screw the outsert onto the insert.

If the fit is too tight to where the outsert is not able to rotate, proceed to step 3.

If the outserts fit with the ability to rotate, then proceed to step 4.

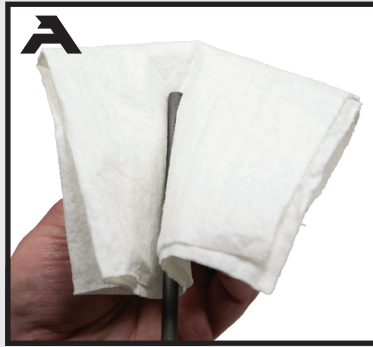


3

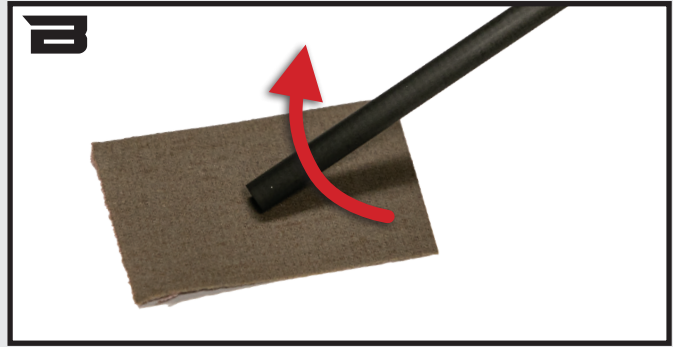
A tight fit is not a bad thing, however if the outsert fitment is too tight, it can prevent the components from assembling properly. The outsert may have a tight fit on the arrow shaft for several reasons:

- The end of the arrow may have flared out during the cutting/squaring process.
- There may be carbon dust/manufacturing residue on the shaft.
- The shaft diameter is on the high end of the tolerance with the component diameter being on the low end of tolerance.

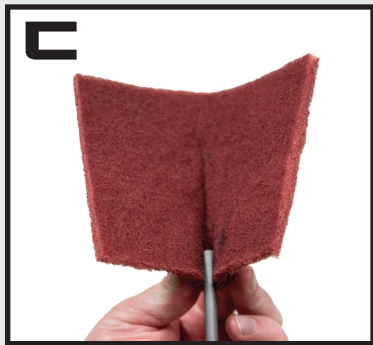
The following actions may be taken to help relieve the extra tight fit:



Clean the outside of the shaft with alcohol to remove any residue.



Lightly chamfer the edge of the carbon arrow to eliminate any flaring that may have occurred during cutting/squaring process. This can be done by placing a 320 grit or higher piece of sandpaper on a flat surface, holding the arrow at a slight angle, and lightly rotating the front edge of the arrow shaft on the sandpaper.



Lightly sand the first 1/2" of the shaft using a 320 grit or higher sandpaper or Scotch Brite pad by wrapping the end of the arrow shaft with the sandpaper or pad, applying light pressure then rotate the shaft. Be careful not to sand too much as this could leave the outsert with a very loose fit. The shaft should be sanded with light pressure and should be cleaned and checked often through this process to dial in the outsert fit.

Glue the insert into the arrow with your preferred adhesive. Wipe away any excess adhesive and let dry.



Install the outsert onto the shaft/insert and lock it into place by turning the outsert clockwise to thread the outsert on the shaft. If the fit of the outsert is now tight after installing the insert, there may be leftover adhesive on the shaft from installing the insert. Refer to Step 3, actions A or C to achieve proper fit of the outsert on the shaft.

