

# Bullet Twist Pen Kits Assembly Instructions

## Required Accessories:

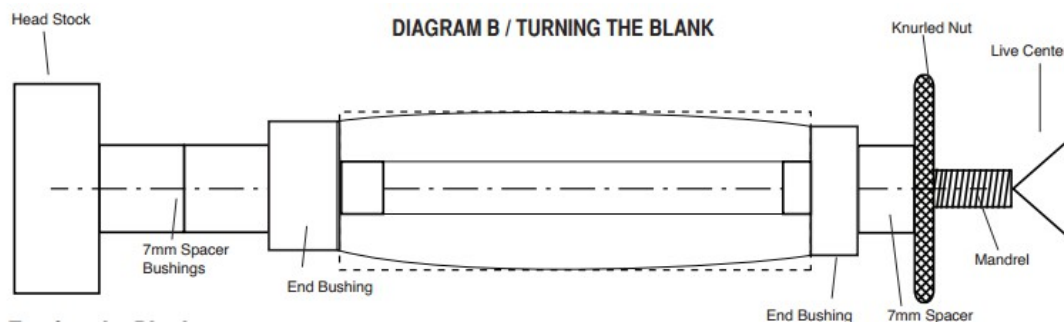
- 7mm, Pen Mandrel
- Drill Bit 10mm
- Bushing set(2 pc)
- 10mm Barrel Trimming set
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 5/8 x 2-14" L

## Preparing the Blank:

- Cut min 5/8" sq blank to length of tube(s) and add 1/16" for squaring off.
- Drill a 10 mm hole lengthwise through the blank.
- Spread glue over the tube, insert into the blank with a twisting motion to spread the glue evenly inside.

Center the tubes lengthwise inside the blanks.

- When the glue is dry, square the ends of the blanks. Use a 10mm barrel trimmer shaft, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly. Use a barrel trimmer to clean the inside of the tube.



## Turning the Blank

- Mount the bushings and blanks 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

1. Press the center coupler into the large end of the cartridge until you have reached flange.
2. Press the tip into the other end of the cartridge until you have reached flange.
3. Insert the refill with the spring in place, and insert it into cartridge body through the center coupler. Thread the twist mechanism onto the center coupler
4. Press the center band into the brass tube
5. Press the extension tube onto the small end of the cap coupler
6. Now, press this assembly into the other end of your blank. Be sure to place the notch in the finial adaptor where you want the clip to be located.
7. Place the finial cap through the hole in the rifle clip.
8. Align the clip with the notch in the can coupler and press the finial cap home.

## Diagram A

