

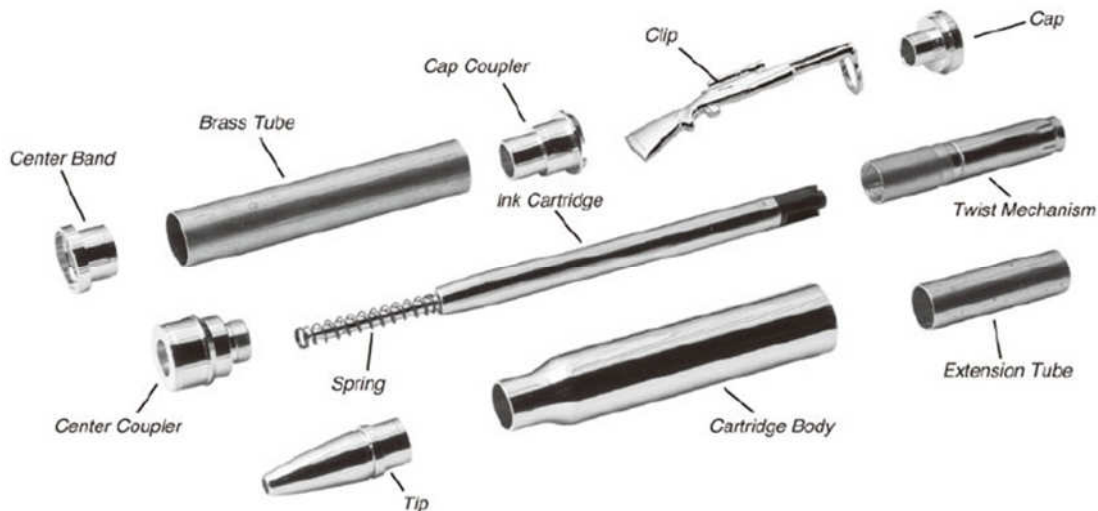
Assembly instruction for Twist Bullet Pen Kit

Required Accessories

- 7mm Pen Mandrel Kit
- 10mm Colt Drill Bit
- PTBKIT Bushing Kit Click Bullet Pen
- PBTk04 Pen Blank Trimming Tool Kit
- Pen Mandrel Support
- 2 Part Epoxy Glue or Instacure Glue (Cyanoacrylate)



PTBKIT Bushing Kit



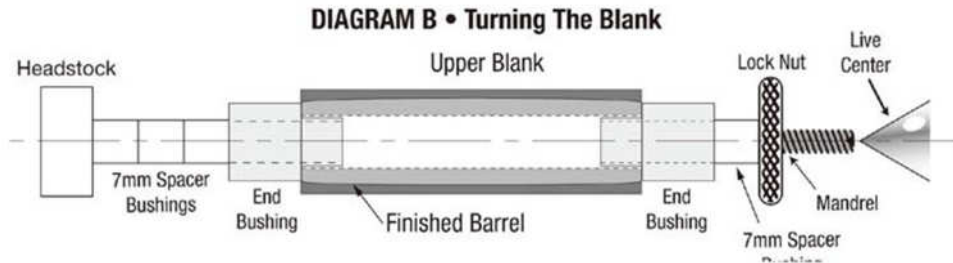
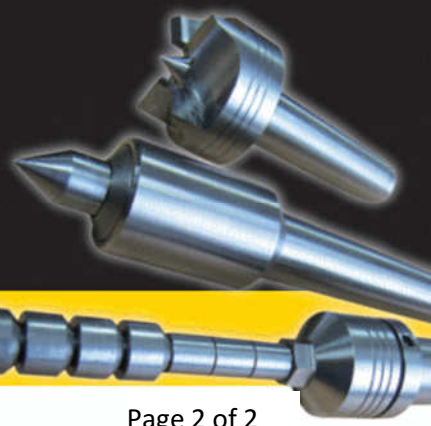
Preparing the Blank

- Cut 5/8" square blank to the size of the Upper Brass Tube. Add 1/16" to each end for squaring off.
- Drill a 10mm hole through the centre of the blank.
- Apply glue to the tube and insert it into the blank with a twisting motion to spread the glue evenly.
- Centre the tube within the blank and allow to dry.
- Use a barrel trimmer to square the ends of the blank to the brass tube

Turning the Blank

- Place spacer bushings on the mandrel. Place one end bushing on, followed by the prepared blank.
- Assemble the second end bushing. Follow with additional spacer bushings as needed.
- Thread the lock nut hand tight onto the mandrel. Do not overtighten, it could damage the mandrel. For best results use the Pen Mandrel Support.
- Bring tailstock snug to the mandrel and lock it into place. Tighten the lock nut for turning.
- Using sharp tools, turn the blank down and sand it to the size of the end bushings.
- Finish the blank with your choice of polish.

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Assembly

Line up the pen parts according to DIAGRAM C.

- Press the centre coupler into the large end of the cartridge until you have reached flange.
- Press the tip into the other end of the cartridge until you have reached flange.
- Insert the refill with the spring in place, and insert it into cartridge body through the centre coupler. Thread the twist mechanism onto the centre coupler
- Press the centre band into the brass tube
- Press the extension tube onto the small end of the cap coupler
- 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.
- Place the finial cap through the hole in the rifle clip.
- Align the clip with the notch in the can coupler and press the finial cap home.

