

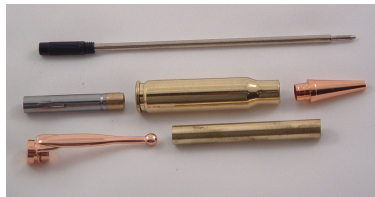
.308 Rifle Cartridge Pen Kit Instructions

This is a very sleek pen that is easy to turn, and requires no tenons. The lower barrel/cartridge has the 7mm brass tube already inserted. All you do is turn the upper barrel and then assemble as you would any 7mm Pen Kit.



KIT INCLUDES:

Genuine Spent .308 Rifle Cartridge
Smooth locking twist mechanism
Cross™ style refill - Black Ink
Slimline Copper Fittings.



REQUIRED ACCESSORIES:

7mm pen mandrel
Cartridge Pen Bushings (2-pc set)
Drill bit – 7mm
7mm Barrel Trimmer
2-part epoxy glue, or CA glue

PREPARING THE BLANK:

These instructions assume that you already know how to glue up a pen blank and are familiar with your lathe and the turning process. So from here we will continue with instructions that you will find more useful.

BUSHINGS

If you have purchased our bushing set you will find the Small bushing is designed for the clip end of the pen and the Large bushing will match the diameter of the primer end of the rifle shell. This will produce a “comfort” style cap. If you desire a more defined taper simply use a 7mm bushing for the clip end of the pen.

POLISHING THE BULLET CASING

The casing is sent to you as a spent casing. It may have slight scratches and chambering marks, or residual adhesive on the casing used during the manufacturing process.

(They are made one at a time by hand) Polishing will remove scratches and adhesive, enhancing the casing before assembly. Mount the casing on your mandrel. Wet sand with 320 wet dry sandpaper. Follow with 600 grit wet dry sandpaper, then 800 grit and then polish with BRASSO or another good metal polish.

ASSEMBLY:

Press the copper tip into the rifle cartridge (small end). Press the twist mechanism into the rifle cartridge (primer end). *Don't press too far, or your pen refill will protrude past the tip when in the closed position.*

NOTE: When pressing in the transmission make sure it is perfectly straight and aligned. If it is cocked you may bend it or crush it. This is because the brass around the casing is so thick it does not expand. A little Vaseline will help.

The transmission depth should measure about **1-1/8"** from the base of the bullet to the refill end of the transmission.



Assemble the clip end of the pen as usual and slide it over the twist mechanism to complete the kit.

Kit Designed & Distributed by :
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