

## Double Bullet Kit Instructions

You should have all of the parts pictured here. The only difference is if you have the .308 double or you have the .308 / 30.06 double.

Follow the instructions below and you should have no trouble assembling this kit.



### Polish Before Assembly

Our kits are furnished with once fired casings. They may require polishing to suit your taste. You can expect to see some dings, or scratches and this is considered normal. These can be minimized by polishing or in some cases hiding a small ding with the clip of the pen if you so desire. (Some prefer an aged look or natural patina and skip this step).

Polishing can be accomplished in many ways. Here are just a few suggestions we have found to work very well. A good metal polish will simplify the task. “Brasso” is good but there are better and quicker products. We find the best polishes are found in the auto parts dept. of most stores. These are designed to work on chrome, brass, copper, etc. and cut quicker and leave a higher shine. “Mothers” is a good brand and can be purchased every where.

Polishing can be done by hand, or with a “Dremel Tool” but if you are doing production work you can use your lathe and pen mandrel if you have one. Mount the casings (2) at a time on the mandrel and use the polish with a paper towel to make the casings bright and shiny.

If you do not have a pen mandrel & lathe you can make a jig out of a piece of 1/4” threaded rod with a wing nut, a nylon nut & a couple of 7mm bushings. Put the rod in a drill, and clamp the drill in a bench vise and you have a great little polishing rig. See photo page (3)

Others prefer a buffing wheel and their favorite buffing compound.

Still others will wet sand with automotive sandpaper going from 320 grit all the way to 2,000 grit and then use a metal polish. This can be done on a lathe or with the jig mentioned above.

The final look of your pen depends entirely on the look you like.

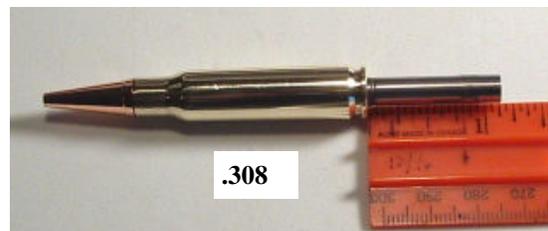


# Assembly Instructions

Assembly is straight forward. Using a bench vise, pen press, quick clamp, or your favorite parts press, follow the steps below.

- (1) Press the tip into the lower casing. For the .308 / 30.06 kit, this will be the 30.06 for the lower casing. For the .308 double kit choose the best looking casing as the tip end. (Remember small dings or scratches can usually be hidden under the clip, so look the casings over before assembly).
- (2) Install the transmission. Depth is critical so go slowly and make several tests with the refill until you find the proper depth that will allow the refill to extend for writing and still retract all the way into the tip when closed. Photos below will give approx. starting points.

**Tip:** Make sure the (black cap) on the refill is fully seated on the refill tube. Sometimes it may not be seated all the way (mass produced) and you will wonder why some refills seem to be different lengths. With the refill removed from the pen, gently press the (black refill cap) against the edge of a table to check it. Or line up all the refills next to each other to check them for length. Make sure you screw the refill all the way into the transmission, this will affect length as well.



- (3) Press the cap & clip on the upper casing. Now push the upper casing onto the transmission and your project is complete.

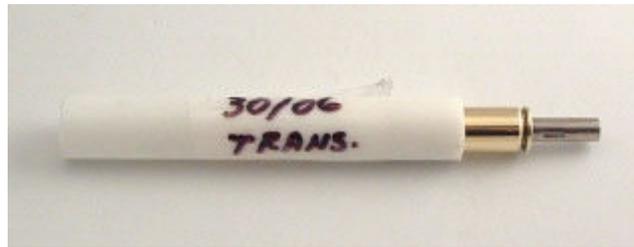
If you are doing production work you may want to make a jig for pressing in the transmission so you don't have to check every pen for proper depth. I have included instructions to make a simple jig that will speed up your production time dramatically. Just keep in mind you will need to make one for the .308 or .30/06 kits respectively.

## Transmission Depth Gauge

This is a simple jig to make. After you have assembled one pen and have your proper depth for the transmission, all you have to do is cut a piece of 1/2" PEX tubing, (available at all Home Centers in the plumbing dept.) to the proper length.

The proper length will be measured from the tip of the pen to the top of the transmission.

To use the jig, press in the tip first with your pen press, then start the transmission in the casing, slide the casing into the PEX tubing and press until the tip & transmission are flush with both ends of the tubing. (A bench vise works great for this) Check to make sure you have the proper jig length. Once you are satisfied it is correct all of the other bullet pens will be the same. (Don't do this with the refill installed)



## Polishing Jig

If you don't have a lathe and pen mandrel, you can make a polishing jig that will polish (2) casings at a time and will speed up the process for production work. Get a length of 1/4" threaded rod. A 12" piece can be purchased at Lowe's or Home Depot for about \$1.00. Get a nylon lock nut and thread it on one end of the rod. This will be the chuck end of the jig. Use (2) 7mm bushings for spacers, and lock everything in place with a wing nut.

I cut the rod to 7 1/2" in the photo below. This will allow for (2) .30/06 casings at a time. Mount the jig in a drill and clamp the drill in a bench vise and you are ready to polish.

