

.50 Caliber Bullet Action

Required Accessories:

- 7mm pen mandrel
- 2piece Bushing Set
- 3/8" Drill Bit
- Universal Barrel Trimmer 3/8 shaft
- Live Tailstock Center
- 2-part epoxy glue or instacure glue
- Minimum Blank size: 7/8" x 1-3/4"

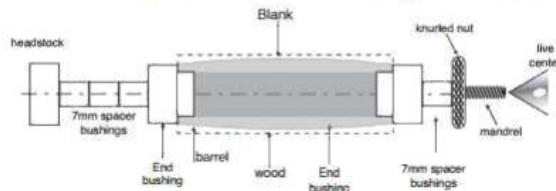
Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 3/8" hole lengthwise through the blank.
- Spread the glue over the tube.
- Insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise in the blank.
- When the glue dries, square the end of each blank.
- Use a Barrel trimmer with 3/8" shaft or a universal pen blank squaring jig with a power disc sander.
- Take the wood down to the brass tube. Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly.
- Use the barrel trimmer shaft to clean the inside of the tube.

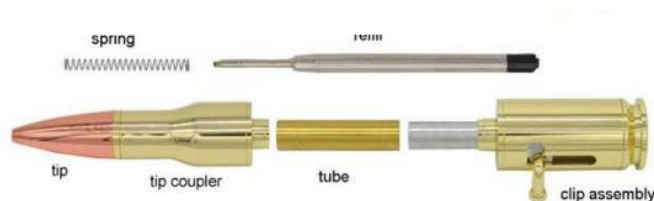
Turning the Blanks:

- Mount the bushings and blanks on the mandrel 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.

DIAGRAM B - Turning the Blanks



Pen Assembly



NOTE: Layout Finished parts according to the diagram above.

- Press the tip coupler into either end of the barrel.
- Press the clip assembly into the opposite end of the barrel.
- Affix the spring over the refill, set the bolt to the "out" position, then insert the refill into the opening.
- Screw the tip into the tip coupler.
- To operate the pen, press down with your thumb on the bolt into the bay for use.