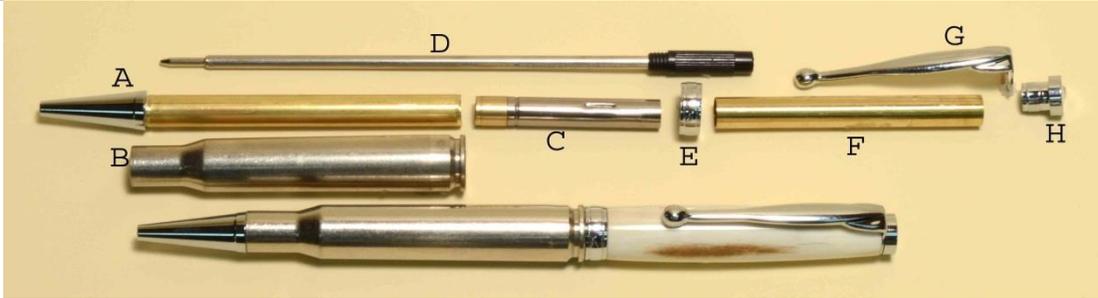


Arizona Silhouette .30-06 Bullet Twist Pen Instructions – Cross Style Refill

Materials Provided:

Nib With Bottom Tube (A)	Top Brass Tube (F)	Twist Mechanism (C)
Center Ring (E)		Cap Finial (H)
“Cross” Type Refill (D)	Powder Coated Once Fired Shell (B)	Clip (G)



You Will Need:

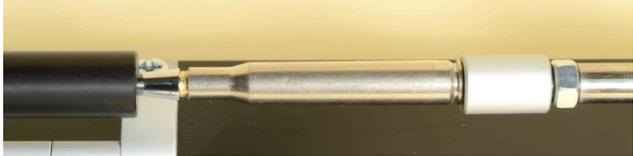
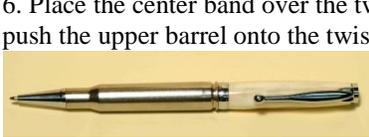
Pen Blank – 3/4” x 3/4” x 2 1/2”	7mm Drill Bit	Two Part Epoxy
Barrel Trimming Tool	“A” or 7mm Mandrel	Pen Insertion Tool
DB0007 Bushings	Pen Press and Chamfering Tool	Appropriate Sanding Material

Pen Blank Instruction:



1. Drill upper pen blank material with 7mm drill bit and glue pen tube into blank.
2. Square the end of the blank after glue has cured.
3. Place larger (center) bushing .419” on to mandrel followed by your prepared pen blank then the smaller (cap) bushing .332”
4. Turn your upper pen blank down to the bushings and apply a finish of choice.

Pen Assembly Instruction:

 <p>1. Take nib with attached bottom tube and use a pen insertion tool to smooth out the inside of the brass tube.</p>	 <p>2. Use two part epoxy and add a <u>SMALL</u> amount of epoxy where arrows indicate.</p>
 <p>3. Place the powder coated shell over the brass tube and press it into place. NOTE: make sure that the brass tube does not extend out past the end of the shell (if it does, sand it flush)</p>	 <p>4. Install the twist mechanism into the brass tube using a pen press approximately 3/8”. Insert the refill into the twist mechanism and check to see if it is deployed to the proper depth. Adjust as necessary.</p>
 <p>5. Press the cap and clip into your finished upper barrel.</p>	 <p>6. Place the center band over the twist mechanism and then push the upper barrel onto the twist mechanism and your .30-06 bullet pen is complete!</p>