

# Arizona Silhouette

## All .308 Bullet Twist Pen Instructions – Cross Style Refill

(Silver Vein Powder Coated Bullet is illustrated)

### Materials Provided:

Nib (A)	Lower 7mm brass tube (B) to be inserted into powder coated shell (C)	Powder Coated Once Fired Shell (C)
Center Ring (D)	Twist Mechanism (E)	“Cross” Type Refill (F)
Top Brass Tube (G)	Clip (H)	Cap Finial (I)



### 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 .330”
4. Turn your upper pen blank down to the bushings and apply a finish of choice.

### Pen Assembly Instruction:

	<p>1. Rough up the very ends of the pen tube and then use two part epoxy and add a <b>SMALL</b> amount of two part epoxy where arrows indicate.</p>		<p>2. Insert the brass pen tube with the epoxy glue on the ends of the tube into the powder coated shell and press the nib section onto the end of the shell.</p>
	<p>3. <b>NOTE:</b> 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. Chamfer the inside of the pen tube and 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 .308 Silver Veined Powder Coated bullet pen is complete!</p>