

30-06 / 308 DOUBLE BULLET CARTRIDGE and 30-06 SINGLE BULLET CARTRIDGE PEN INSTRUCTIONS

Thank you for choosing **Bear Tooth Woods** for your new bullet cartridge pen. This pen is made using real, once fired, bullet cartridge(s). Small dings are likely from being fired. If the bullet cartridge is brass, it will tarnish naturally and can be polished with a brass cleaner if desired.

Follow the instructions for either the double bullet cartridge pen (2 bullet cartridges in your kit) or the single bullet cartridge pen (1 bullet cartridge). The bullet cartridges have been machined and the brass tubes installed. Only the pen parts need to be pressed in. This pen uses a standard CROSS style refill.

To press the pen components into the bullet cartridges, an ARBOR press is best. Any method to press the components can be used with care to align the parts properly.

CAUTION – FAILURE TO PROPERLY ALIGN THE PEN COMPONENTS AS YOU PRESS THEM INTO THE BULLET CARTRIDGES CAN DAMAGE THE PEN COMPONENTS. BE SURE YOU ALIGN THE PARTS SO THEY PRESS STRAIGHT INTO THE CARTRIDGE.

Unlike other pen barrel materials where the brass tube is glued to the full length of the material, the 7mm tube inside the bullet cartridge is only glued at each end of the bullet cartridge. If you have to remove a pen component that you have improperly pressed together, you may find the glue holding the 7mm tube may come loose. If the tube comes loose from the cartridge, you can re-glue the tube using CA or epoxy.

For a diagram showing the components used in this pen kit, refer to the instructions for a SLIM pen kit found on the BEAR TOOTH WOODS website.

30-06 / 308 DOUBLE BULLET CARTRIDGE INSTRUCTIONS (BULLET CARTRIDGE ON UPPER AND LOWER PEN BARREL SECTIONS)

Follow these instructions if your kit has 2 bullet cartridges – one for the upper and one for the lower pen sections. You only need to press the parts together to complete the pen.

1. There are 2 cartridges in this kit. One is a 30-06 cal. (longer) and the other a 308 cal. (shorter). You can use either cartridge on the upper or lower sections of the pen. Place the cartridges in both positions to see how it will look.
2. Press the nib (writing tip) into the slim (neck) of the cartridge you chose for the lower section. If needed, medium CA glue helps hold the pieces in place.
3. Press the transmission – brass colored end first – into the other end of the lower section. **DO NOT GLUE.** Press the transmission in partially stopping before the indent line on the transmission body. Screw in the ink refill. Twist the transmission and check how much the refill extends beyond the nib (writing tip). Remove the refill and press the transmission in **small increments** - rechecking the ink refill frequently until you have reached the position where the refill extends beyond the nib (writing tip) as the transmission is twisted.

4. The upper bullet cartridge can be mounted with the neck (narrow part of the cartridge) facing either direction. To help decide which you like, position the upper cartridge with the cartridge neck toward the pen center, and then try it with the neck facing away from the center.
5. Press the finial and clip into the cartridge end you chose as the top. If needed, medium CA works well to hold these parts in place.
6. Push the upper and lower completed sections together and check for a smooth twist operation.

SINGLE 30-06 BULLET CARTRIDGE INSTRUCTIONS

Follow these instructions if your kit has one 30-06 bullet cartridge and a brass tube for you to make your own barrel section. You can place the bullet cartridge on the upper or lower section of your pen and make the other barrel section from material of your choice. You will need a section of material slightly longer than the brass tube and about 5/8" square or larger; a lathe with turning tools; 7mm drill; glue (CA or epoxy works); some manner to drill a hole in your material such as a drill press; slim 7mm bushing; bullet bushing for 30 cal. bullet pen (available to order); sandpaper and finish of your choice.

1. Cut your wood, acrylic or other material of your choice about 1/8" longer than the brass tube.
2. Drill a 7mm hole through the center of the material.
3. Scuff the brass tube with 150 grit or so sandpaper.
4. Glue the tube with CA, epoxy or suitable glue into the barrel material. Allow to dry as recommended.
5. Sand or use an end mill to square the end and remove the barrel material down to the tube. Clean any glue remnant out of the tube.
6. Mount a Slim 7mm bushing on your lathe mandrel, the barrel material and a 30 cal. pen bushing.
7. Turn to desired shape leaving a fraction for sanding.
8. Sand as appropriate for your barrel material.
9. Finish as desired.
10. Press the finial and clip into the upper barrel section you chose. You can press these parts into either end to achieve the look you prefer. Glue helps hold the part in place.
11. Press the nib (writing tip) into the narrow end of the barrel you chose for the lower section of the pen. Glue helps hold the part in place.
12. After pressing the nib into the lower barrel, press the transmission – brass colored end first - into the wide end of the lower barrel. Press in slightly, screw in the ink refill and twist the transmission to extend the refill. If the refill does not extend the desired amount, remove it and press the transmission in slightly more. Continue this process of pressing and checking until the refill extends the desired amount.
13. Push the upper and lower sections together and check for a smooth twist operation.