

Native Pens

Bolt Action Bullet Pen Instructions

Required:

¼" Mandrel

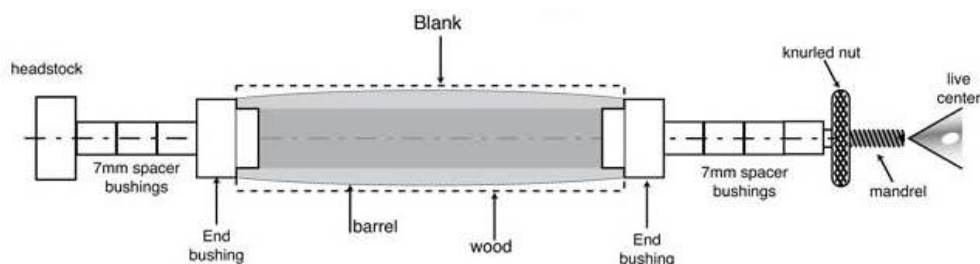
9.5mm Drill Bit

Pen Mill

Bolt Action Bullet Bushings

Turning the Pen Barrel.

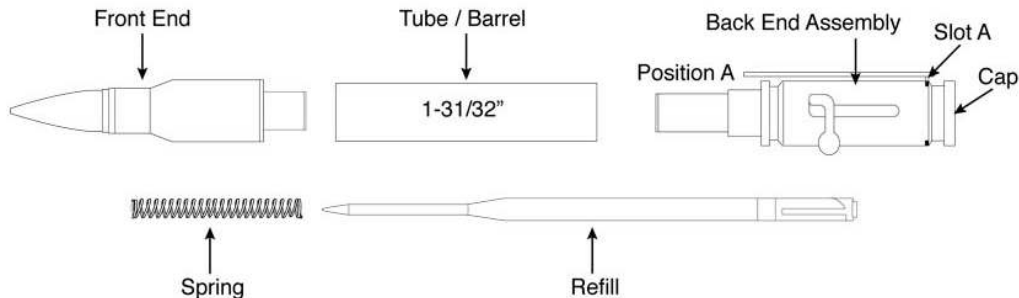
1. Cut a pen blank slightly longer than the brass tube. Recommended blank size is 20mm x 20mm x 54mm.
2. Drill the blank through the centre, lengthwise, with a Ø9.5mm bit.
3. Sand the surface of the brass tube. This can be done by hand or mounted in the bushes on the lathe. This will clean off any oxidation and roughen the surface for a better glue bond.
4. Bond the tube into the timber blank. This can be done with CA or two-part epoxy glue. Insert the tube with a twisting motion then push it in until slightly under flush. About equal distance in from each end of the timber blank.
5. Allow glue to cure as required by glue manufacturer.
6. Clean all the dried glue from inside the brass tube. This can be done with a appropriate size drill bit by hand. Not cleaning out all the glue from the tube is the most common cause of pen failure.
7. Using a pen mill, face off the ends of the blanks until you can just see the bright brass end of the tube. STOP facing at this point. Another method to square the ends is sanding on a disc sander against a square fence or using a jig to hold the tube square to the disc.
8. Another method of squaring the ends of the blank is to turn the blank until it is just round. Then using a mitre gauge to maintain the blank perpendicular to the sanding disc, just touch the ends to the disc. Once the blank is square and you can see the ends of the tube brighten you can return the blank to the mandrel and finish the turning until the desired shape is reached.
9. Finish the pen to your specifications. Remove the barrel from the mandrel and it is ready for assembly.



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Assembly of the pen.



1. Move the Bolt Action to Position A as shown above, then check to see than the Bolt is tightly in place (To tighten see Note I below).
2. Press the Front End into on end of the Barrel.
3. Press the Back End Assembly into the other Barrel end.
4. Unscrew the Tip and slide the Refill into the opening at the Front End.
5. Insert the Spring over the Refill and replace the Tip.
6. Lock and Unlock the bolt to extend or retract the Refill.
7. You pen is finished.

Note I.

Changing and Tightening the Bolt.

To loosen or tighten the bolt, Lossen for tighten the set-screw as shown in the figure below. Take a long Phillips screw drive with a small head; insert it into the Back End Assembly as shown. Rotate the screw as necessary to loosen or tighten the bolt.

