

## .308 Rifle Cartridge Pen Kit Instructions

This is a very sleek pen that is easy to turn, and requires no tenons. The lower barrel/cartridge has the 7mm brass tube already inserted. All you do is turn the upper barrel and then assemble as you would any 7mm Pen Kit.



### KIT INCLUDES:

Genuine Spent .308 Rifle Cartridge  
Smooth locking twist mechanism  
Cross™ style refill - Black Ink  
Fancy Gold Fittings.



### REQUIRED ACCESSORIES:

7mm pen mandrel  
.308 Bushing Set (2-pc set)  
Drill bit – 7mm  
7mm Barrel Trimmer  
2-part epoxy glue, or CA glue

### PREPARING THE BLANK:

These instructions assume that you already know how to glue up a pen blank and are familiar with your lathe and the turning process. So from here we will continue with instructions that you will find more useful. Prepare and Drill the 7mm hole about 10mm longer than the tube.

### BUSHINGS

If you have purchased our bushing set you will find the Small bushing is designed for the clip end of the pen and the Large bushing will match the diameter of the primer end of the rifle shell. This will produce a “comfort” style cap. If you desire a more defined taper simply use a 7mm bushing for the clip end of the pen.

### POLISHING THE BULLET CASING

The casing is sent to you as a spent casing. It may have slight scratches and chambering marks, or residual adhesive on the casing used during the manufacturing process.

(They are made one at a time by hand) Polishing will remove scratches and adhesive, enhancing the casing before assembly. Mount the casing on your mandrel. Use a metal polish as the case is spinning to polish to your desired shine. Brasso will work, but metal polish designed for mag wheels will give a better shine much quicker.

### ASSEMBLY:

Press the copper tip into the rifle cartridge (small end). Press the twist mechanism into the rifle cartridge (primer end). *Don't press too far, or your pen refill will protrude past the tip when in the closed position.*

**NOTE:** When pressing in the transmission make sure it is perfectly straight and aligned. If it is cocked you may bend it or crush it. This is because the brass around the casing is so thick it does not expand. A little Vaseline will help.

The transmission depth should measure about 1-1/8” from the base of the bullet to the refill end of the transmission.



Assemble the clip end of the pen as usual and slide it over the twist mechanism to complete the kit.

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