

3006 & 3006N PEN KIT INSTRUCTION SHEET

This is a very sleek pen that is easy to turn, requires no tenons and is a snap since the lower barrel/cartridge has been pre-assembled. All you do is turn and assemble the upper barrel and push it onto the twist mechanism.

KIT FEATURES

- Genuine Spent 3006 Rifle Cartridge
- Smooth locking twist mechanism
- Cross™ style refills - PEN-R5
- Overall length: 5-3/8"

REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 1 Slimline Bushing & the Euro Sizing Sleeve
- Drill bit – 7mm
- 7mm Barrel Trimmer
- 2-part epoxy glue, Gorilla Glue or CA glue

PREPARING THE BLANK:

- Prepare a blank of at least 5/8" square stock. Cut to the length of the brass tube (add 1/16" for trimming)
- Drill a 7mm center hole through the blank.
- Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Center the tube inside the blank. NOTE: Sand the tube with 220 grit abrasive for better adhesion of the glue.
- Square the ends of the blank using a 7mm barrel trimmer. Trim the blank down flush with the brass tube. **DO NOT OVERTRIM OR YOUR PEN WILL NOT FUNCTION PROPERLY**

TURNING THE BLANK:

- Mount 7mm spacer bushings on the mandrel, Install the Euro Sizing Sleeve. (Assemble the sizing sleeve by inserting the narrow end of the smaller piece into the larger end of the outside bushing. Line up the narrow inner bushing with the narrow end of the outer bushing. Install the set screw and just barely tighten. Forcefully tightening the set screw is not necessary and will only damage the bushing threads or strip out the socket of the screw.) Insert the Sizing sleeve so that the thickest piece of the bushing will be against your blank. (The bushing will match the diameter of the back end of the rifle shell). Install your blank and follow with a slimline bushing 7mm bushing. Mount spacer

bushings to fill the space to the threads on the mandrel. Screw on the lock-nut hand tight. Bring the tailstock in snug to the mandrel and tighten the lock-nut for turning. Do not over tighten the lock nut, it may damage the mandrel or will cause your blank to be egg shaped. Turn the blank down close to the bushings; leave about the thickness of a fingernail above the bushings. Follow with abrasives until the barrel diameters are smooth to the feel with the bushings. For the best finish results, use Micro-Mesh and sand to the 12,000 grit. Finish with your choice of polish.



ASSEMBLY:

- Insert the cap into the clip and press this assembly into the small end of the Tube/ Barrel.
- Push the wide end of the tube/barrel onto the back of the cartridge assembly.
- Operate the pen by twisting the upper and lower barrel in opposite directions to extend and retract the refill.
- The refill can be replaced by unscrewing it from the mechanism like a regular slimline pen.

**For questions regarding this kit,
Please contact
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