

Rifle Cartridge Pocket Pen Kit

This is a very sleek pen that is easy to turn, and requires no tenons. The brass cartridge has been re-worked to accept the twist mechanism. All you do is turn the tip portion of the pen, polish the casing and then assemble as you would any 7mm Pen Kit.



KIT INCLUDES:

Genuine Spent .3006 Rifle Cartridge
Smooth locking twist mechanism
Mini- style refill - Black Ink
Mini Pen Tip



REQUIRED ACCESSORIES:

7mm Pen Mandrel
7mm Pen Bushing
Drill Bit – 7mm
2-part epoxy glue, Gorilla Glue or CA glue

PREPARING THE BLANK:

The blank needs to be 1/2" to 3/4" long.
(We prefer 1/2" as pictured below)



Drill a 7mm center hole through the blank and glue in the tube keeping one end flush with the tube. Make sure both ends of the blank are square before gluing.

TURNING THE BLANK:

Use a 7mm bushing for the tip end of the pen. Slightly taper the rear of the blank that will ride on the mouth of the bullet casing. This is not critical, but should be about the same diameter as the casing.

We find that leaving the tip diameter of the blank a little proud of the 7mm bushing makes for a better fit when you press in the tip.

POLISHING THE CARTRIDGE:

If using a buffing wheel you will not need these instructions. If you polish on the lathe you will need a way to keep the cartridge on the mandrel.

Use a shop made jig pictured below. It is just a 7mm pen tube with some material removed from one end. It will fit inside the opening in the casing and act as a bushing. Use the tail stock on your lathe to secure the primer end of the cartridge to the mandrel as you polish.

After polishing, to keep the shine, spray with lacquer for brass. This is designed especially for brass and will last a long time... <http://www.woodcraft.com/Product/2021214/25928/Behlen-Brass-Lacquer-13oz.aspx>



ASSEMBLY:

Press the tip into the finished end of the tube and then press the transmission into the other end. Depth should measure about 1-1/16" from the base of the brass tube to the refill end of the transmission. Install the refill and push the twist mechanism into the casing .



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