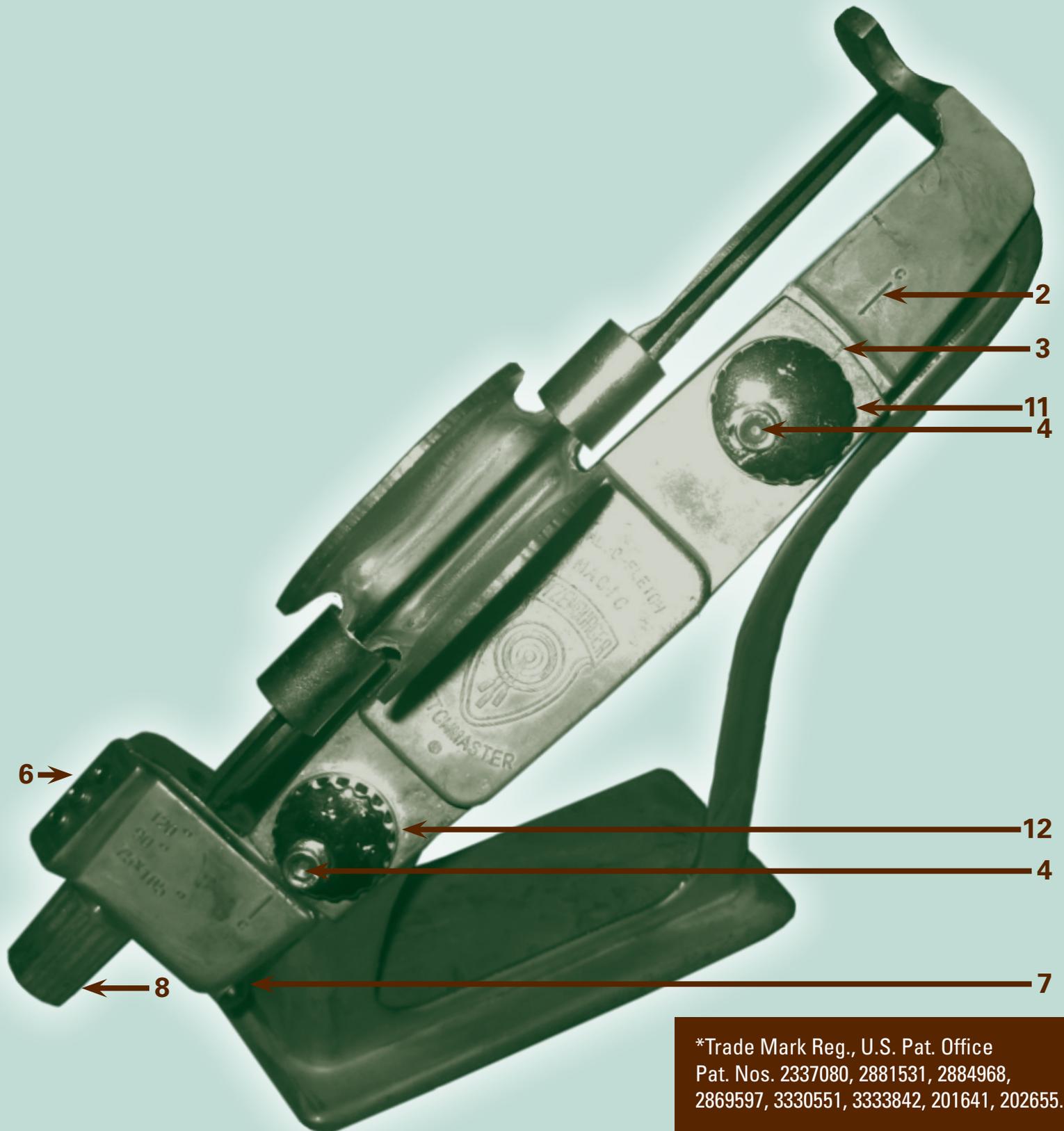


# BITZENBURGER DIAL-O-FLETCH OPERATING INSTRUCTIONS



\*Trade Mark Reg., U.S. Pat. Office  
Pat. Nos. 2337080, 2881531, 2884968,  
2869597, 3330551, 3333842, 201641, 202655.

You have purchased the worlds' finest fletching tool. More arrows are fletched on the **BITZENBURGER Fletching Tool** than any other.

The basic principle of the famous **BITZENBURGER Fletching Tool** is the powerful permanent magnet which allows for continuous uniform placement of all vanes and feathers. All of the many patented functional features work in unison with this magnet.

The magnet is the most expensive and important part of this tool. Great care should be taken to protect it. A metal keeper or the clamp should be kept across the face of the magnet at all times.

## INSTRUCTIONS FOR USE

Remove metal keeper from magnet.

**NOTE:** Helical clamps have no adjustment and only fit on the shaft in one particular setting. (see fig. 13 & 14 on back page).

Straight clamps are used to fletch straight; or offset by turning adjustment knobs (#11, #12) in opposite directions.

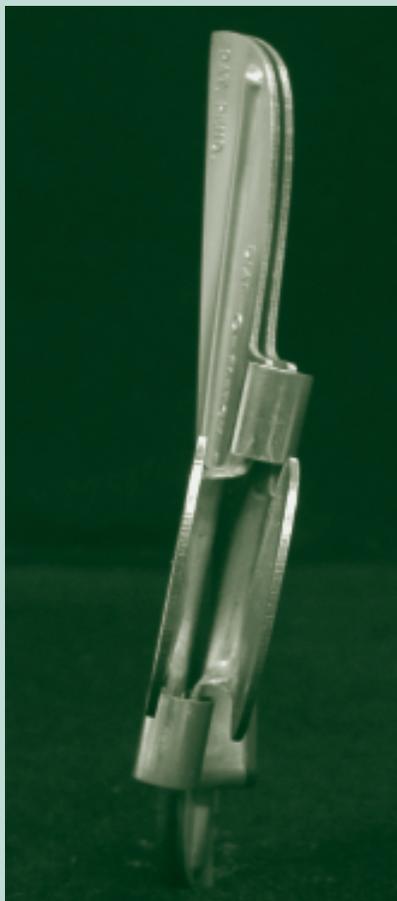
Your jig frame may be attached to a table or bench by drilling two holes through the base of the jig.

To adjust your jig loosen #4 screws to allow free movement of adjustment knobs #11 and #12.

Select your desired nock receiver setting: 3 fletch 120°, 4 fletch 90° or 4 fletch 75°x105°. Choose your setting by screwing clockwise the nock receiver set



**LEFT WING CLAMP**



**RIGHT WING CLAMP**

screw #6. Tighten the set screw until the top of it becomes flush with the jig frame. Make certain the other two screws are backed off. If too little pressure has been applied the roller bearings will not drop into the nock receiver index settings. Proper tension will result with #8 nock receiver turning smoothly with positive stops at each fletch location. If using a TM nock receiver, select the 120° setting. When using a secret nock receiver select the 75°x105° setting.

**NOTE:** nock receiver should be kept dry. **DO NOT LUBRICATE.**

Place your arrow shaft with nock attached, into the jig. There is a "V" notch inside the nock receiver the nock will fit on. Be sure it is seated all the way in, and stays centered at all times.

The flat side of the nock receiver should be facing up to start.

To adjust your jig loosen #4 dial screws to allow free movement of the magnet. Place clamp onto the magnet while pushing clamp to rear of jig making contact with frame. Now turn adjustment knobs #11 and #12 until clamp rests evenly upon shaft. Then tighten #4 screws.

Remove clamp from jig and squeeze open to insert fletch, using scale on clamp to locate back of fletch.

Allow 1/8" between the base of fletch and the base of the clamp.

Once again place clamp onto magnet to check alignment with your fletch in clamp. (a slight adjustment may be necessary). Care should be taken so that the fletch fits smoothly, the entire length of the clamp.

**NOTE:** If your shaft diameter changes you may have to realign the jig for your new shaft size.

## FLETCHING YOUR ARROW

It is important the shafting and fletching materials you use are clean and oil free.

With the fletch in the clamp run a thin line of fletching glue along entire base of fletch.

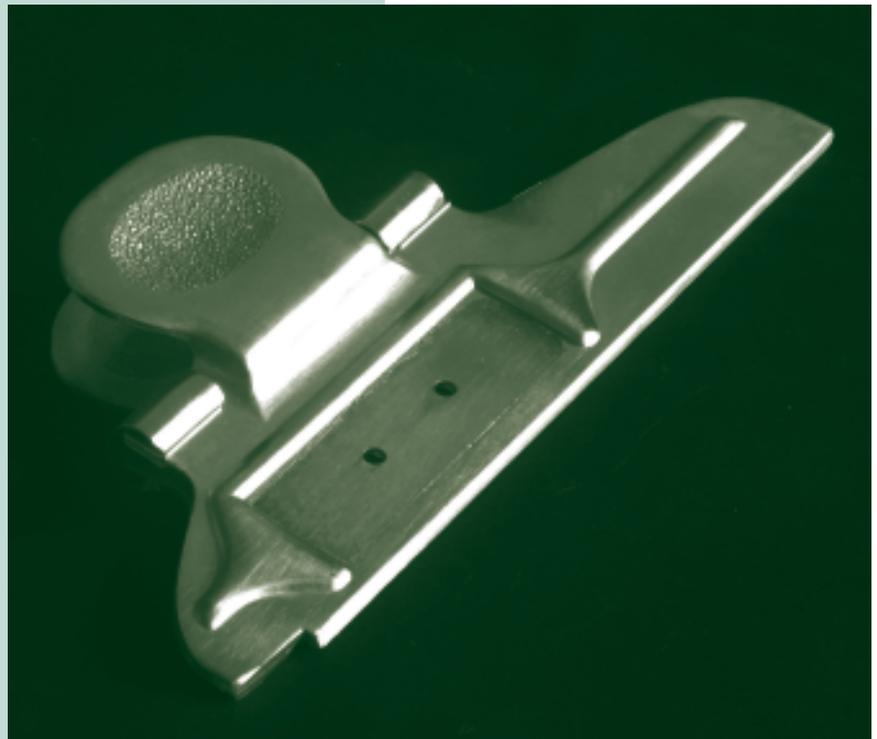
Place clamp on magnet keeping fletch away from shaft. Push clamp to rear making contact with frame. Push down rear of clamp until contact with shaft is made, then slowly push entire clamp down from rear to front until fletch makes complete contact with shaft, being careful as to not push clamp down on shaft to hard, allowing arrow to stay centered in "V" notch in nock receiver.

Magnet will hold clamp in position until glue dries.

After drying, squeeze clamp open and carefully remove clamp from jig.

Turn nock receive #8 counter clockwise to next index setting until arrow is fletched.

Finish arrow with a spot of glue on the front and rear of each fletch.



## OPTIONAL NOCK RECEIVERS

### MODELS TM

Fletches 3 fletch 120° with cock feather down or up. Specify R., L., or S.

### SECRET

For ultimate clearance. Fletches 4 fletch 60°x120° for use with any clamp.

### CROSSBOW

Accepts 22/64 diameter shaft with most end caps. Indexed at 120° for 3 fletch.

### STRAIGHT CLAMP

Can be used with both right and left wing feathers or any vane. Steel plate is casted into the clamp. No additional plate is glued on.

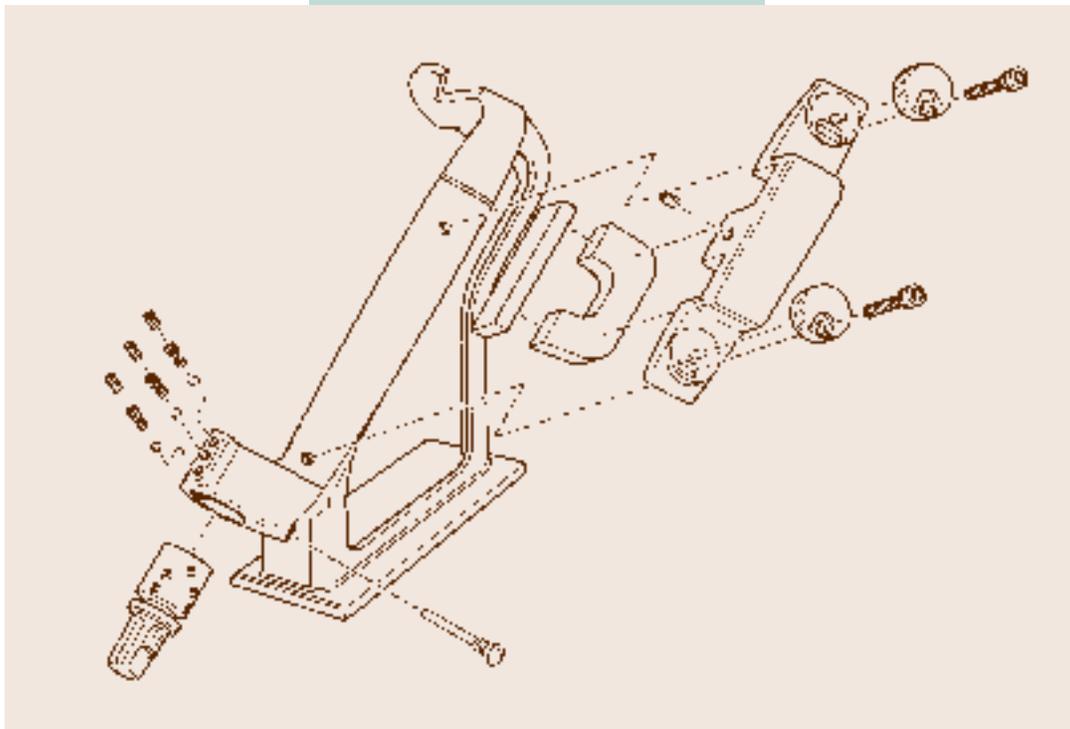
### STRAIGHT CLAMP



**RIGHT JIG & CLAMP Fig. 13**



**Fig. 14 LEFT JIG & CLAMP**



**EXPLODED VIEW**

# BITZENBURGER DIAL-O-FLETCH

**TROUBLES? QUESTIONS? Please call 888-724-5697**

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