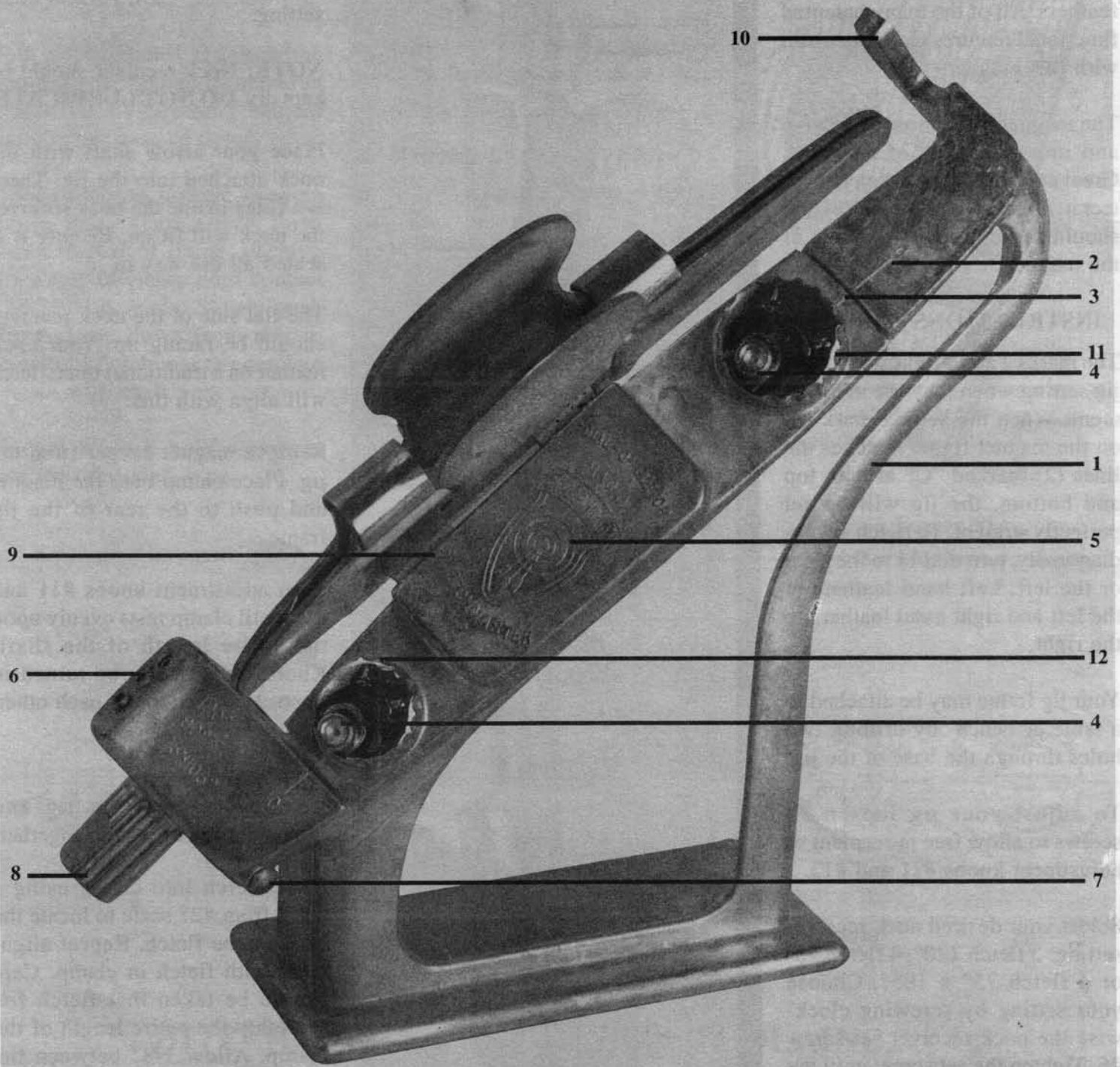


# BITZENBURGER DIAL-O-FLETCH

## 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 a 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.

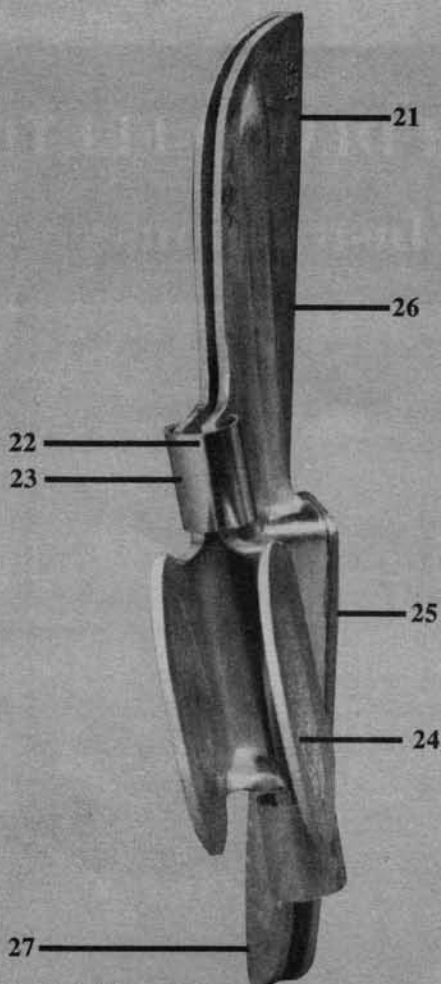
### INSTRUCTIONS FOR USE

The marks 2 and 3 indicate straight jig setting when they are in alignment. When the setting mark (3) on the magnet frame matches the lines (2) marked "C" at both top and bottom, the jig will be set perfectly straight. To fletch arrows diagonally, turn dial 11 to the right or the left. Left hand feathers to the left and right hand feathers to the right.

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° x 105°. Choose your setting by screwing clockwise the nock receiver set 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 much tension has been applied the nock receiver #8 will not turn. If



Left Wing Clamp



Right Wing Clamp

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° x 105° setting.

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

Place your arrow shaft with the nock attached into the jig. There is a ridge inside the nock receiver the nock will fit on. Be sure it is seated all the way in.

The flat side of the nock receiver should be facing up. Your cock feather on a traditional three fletch will align with this.

Remove magnet keeper from the jig. Place clamp onto the magnet and push to the rear of the jig frame.

Turn adjustment knobs #11 and #12 until clamp rests evenly upon the entire length of the shaft. Knobs will usually be turned in opposite directions of each other.

Snug up screws #4.

Remove clamp from jig and squeeze grips on clamp together.

Place fletch into clamp using a mark from #27 scale to locate the back of the fletch. Repeat alignment with fletch in clamp. Care should be taken that fletch fits smoothly the entire length of the clamp. Allow 1/8" between the base of the vane or feather and the base of the clamp.

Your **BITZENBURGER** is now aligned to the shaft diameter you

have chosen. If your shaft size changes you may have to realign the jig to match the new shaft size.

### FLETCHING YOUR ARROWS

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

With your cleaned fletch in the clamp at your desired location run a thin line of fletching cement along entire base of fletch.

Place clamp on magnet keeping fletch away from shaft. Push clamp to rear of frame, pushing down rear of clamp until contact with shaft is made. Slowly push entire clamp down from rear to front until fletch makes complete contact with shaft.

Magnet #9 will hold clamp in position until glue dries.

After drying, squeeze clamp grips together and carefully remove clamp from jig.

Turn nock receiver #8 counter-clockwise to next index setting stop.

Repeat steps 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. Very popular for over-draw shooters. Specify R, L or S.

#### •SECRET•

For the ultimate clearance. This nock receiver fletches 4 fletch 60° x 120°. May be used with any clamp.

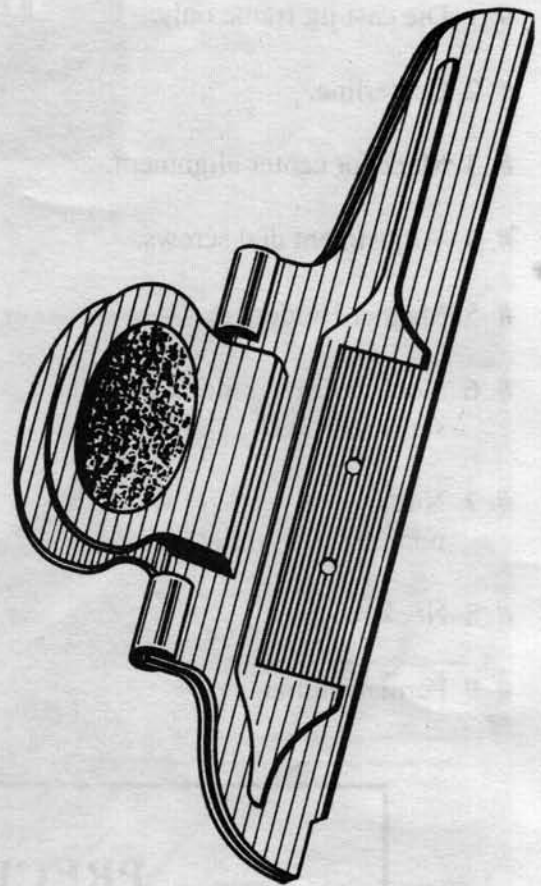
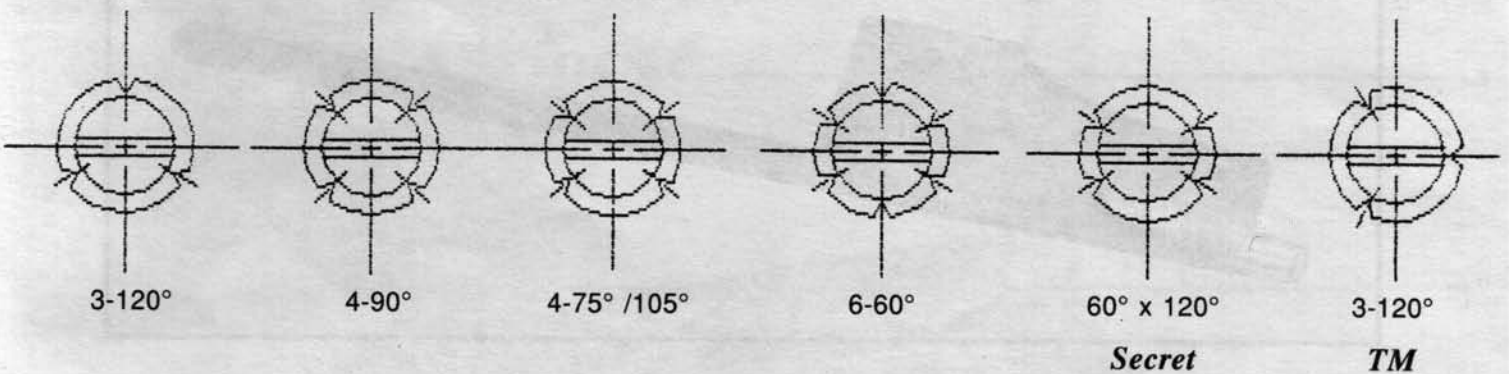


Figure #1



## BITZENBURGER MACHINE & TOOL, INC.

13060 Lawson Road  
Grand Ledge, MI 48837  
(517) 627-8433



## COMPONENTS OF BITZENBURGER JIG

- # 1 Die cast jig frame only.
- # 2 Centerline.
- # 3 Mark for center alignment.
- # 4 Adjustment dial screws.
- # 5 Magnet Holder.
- # 6 Nock receiver index setting screws.
- # 7 Nock receiver screw, holds nock receiver in jig.
- # 8 Nock receiver.
- # 9 Permanent magnet.

#10 Shaft Cradle - Accepts any size shaft.

#11 Top adjustment dial.

#12 Bottom adjustment dial.

## COMPONENTS OF BITZENBURGER CLAMP

LEFT CLAMP requires left wing feathers or any vane. It has a steel plate glued on.

RIGHT CLAMP requires right wing feathers or any vane. It has a steel plate glued on.

STRAIGHT CLAMP can be used with both right or left wing feathers or any vane. It has a steel plate casted into the clamp (plate has two holes in it). See Figure #1.

#21 Designates direction of helical clamp.

#22 Clamp spring.

#23 Clamp ball bearings.

#24 Form fitting thumb and finger textured grip.

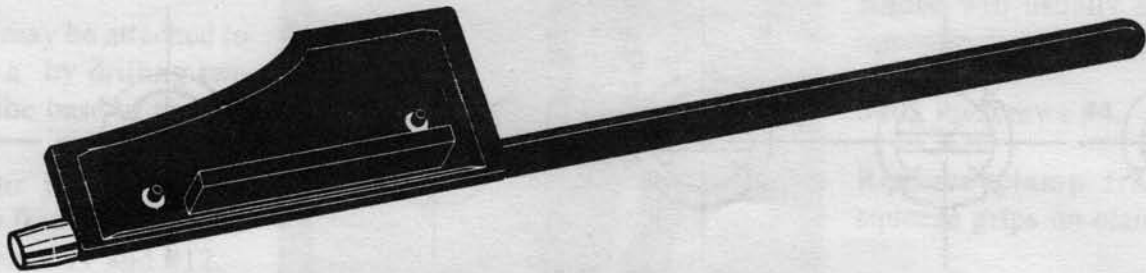
#25 Steel plate-glued on helical clamps, casted into straight clamp.

#26 Base of clamp tapered to prevent build-up of glue.

#27 Graduated scale provides exact spacing from nock.

## PRECISION JIG SETTING GAUGE

Now available, the jig setting gauge will set all your fletching tools to absolute precision uniformity. This tool will set each jig for exact consistency while saving time by eliminating individual jig set up. A must for the multiple jig owner.



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