

Instructions for 30 cal rifle cartridge assemblies

308 commercial and military

The base of the 308 has a diameter of 0.473 inches. The brass tube extends out from the base about 3/8 inches. It uses a cross refill and any 7 mm kit for the upper barrel. To make the upper barrel, start with a blank that is at least 2 ½ inches long if using a slimline kit. Drill a 7 mm hole through the blank and a 9/32, or larger, inch recessed hole at least 3/8 inch deep. The recessed hole is there to provide clearance for the brass tube extending out from the base. Glue the tube flush with the non-recessed end and trim the ends. Turn the blank so that the non-recessed end is the diameter of the clip/cap of the kit chosen and the recessed end should be turned to 0.473 inches. The edge of the base is rounded so this dimension does not need to be exact. Assemble the upper barrel as normal for the kit chosen.

30-06 commercial and military

The base of the 30-06 has a diameter of 0.470 inches. The brass tube is recessed in the base. It uses a cross refill and any 7 mm kit for the upper barrel. To make the upper barrel, start with a blank that is at least 2 1/8 inches long if using a slimline kit. Drill a 7 mm hole through the blank. Glue in the tube and trim the ends. Turn the blank so that one end is the diameter of the clip/cap of the kit chosen and the other end should be turned to 0.470 inches. The edge of the base is rounded so this dimension does not need to be exact. Assemble the upper barrel as normal for the kit chosen.

30-30

The base of the 30-30 has a diameter of 0.498 inches. The brass tube extends out from the base about 3/8 inches. It uses a cross refill and any 7 mm kit for the upper barrel. To make the upper barrel, start with a blank that is at least 2 ½ inches long if using a slimline kit. Drill a 7 mm hole through the blank and a 9/32, or larger, inch recessed hole at least 3/8 inch deep. The recessed hole is there to provide clearance for the brass tube extending out from the base. Glue the tube flush with the non-recessed end and trim the ends. Turn the blank so that the non-recessed end is the diameter of the clip/cap of the kit chosen and the recessed end should be turned to 0.498 inches. The edge of the base is rounded so this dimension does not need to be exact. Assemble the upper barrel as normal for the kit chosen.

300 WIN mag for cross refills

The base of the 300 WIN mag has a diameter of 0.531 inches. The brass tube is recessed in the base. It uses a cross refill and any 7 mm kit for the upper barrel. To make the upper barrel, start with a blank that is at least 2 1/8 inches long if using a slimline kit. Drill a 7 mm hole through the blank. Glue in the tube and trim the ends. Turn the blank so that one end is the diameter of the clip/cap of the kit chosen and the other end should be turned to 0.531 inches. The edge of the base is rounded so this dimension does not need to be exact. Assemble the upper barrel as normal for the kit chosen.

300 WIN mag for parker refills

The base of the 300 WIN mag has a diameter of 0.531 inches. The brass tube and transmission adapter are recessed in the base. It uses a parker refill and a cigar kit for completion. The diameter of the base is a perfect fit to match up with the center band on the upper barrel of a cigar kit. All that is needed is the refill, transmission and the upper barrel of a cigar kit