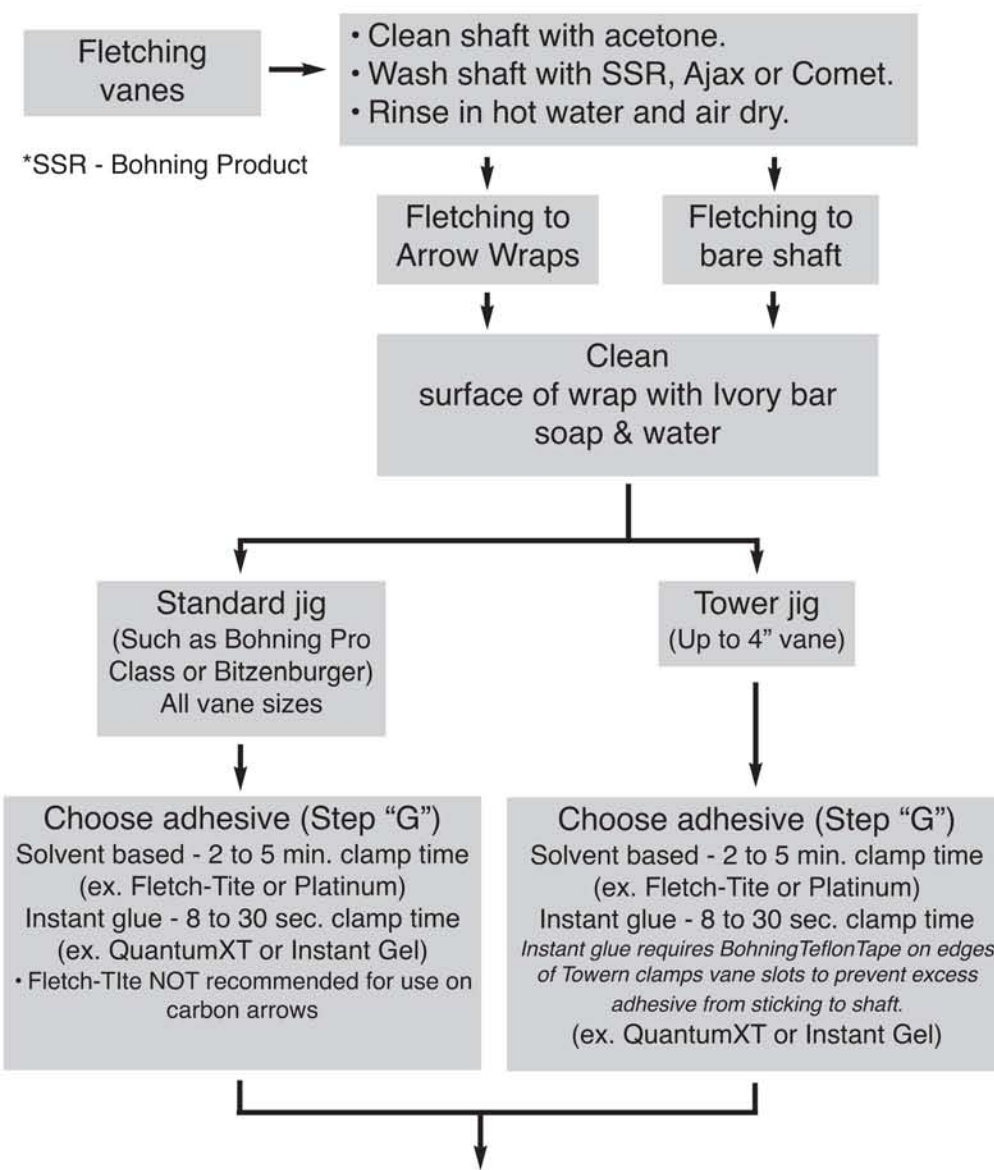


Use Flow Chart below for a quick reference fletching guide. If more detailed information is needed, refer to steps under Arrow Fletching.



Fletch according to jig instructions.
Any questions not covered, please call Bohning at 231-229-4247

Bohning Arrow Fletching guide

FLETCHING YOUR ARROWS WITH the BOHNING Pro-Class Jig

I. Arrow Shaft Preparation

- A. Cut shaft to size and install inserts.
- B. If re-fletch, remove old glue with acetone.
- C. Wipe shaft until all residue is removed. Both re-fletch or new shaft.
- D. Scrub shaft with hot water and abrasive cleaner such as Bohning SSR, Ajax®, Comet®, etc. Scrub with scotch-brite® pad.
- E. Rinse under HOT running water. Rinse well.

II. Arrow Fletching With Bitzenburger™ Style Jigs

- A. Nock should be installed on shaft prior to placing shaft in fletching jig. Ensure inside and edge of clamp has no adhesive residue on it.
- B. Select vane and place in clamp. Use indicating lines to select distance of vane from nock.
- C. Prior to applying any glue, place clamp in jig and sight down shaft to ensure vane base has full contact with shaft. If not, adjust clamp to ensure vane is centered on shaft.
- D. Adjust clamp for off-set or helical by adjusting magnet on jig. Make sure the base remains in full contact with the shaft.
- E. Remove clamp and apply an even bead of glue to vane base.
- F. Replace clamp in jig. Press slight downward on clamp against shaft for 10-15 seconds to ensure vane base is in solid contact with shaft.
- G. If solvent glue, let stand 2-5 minutes and release clamp by squeezing open and pulling away from magnet.
- H. Rotate index knob on jig and repeat until all 3 vanes are fletched on shaft.
- I. Dot both ends of each vane with glue to help guard against vanes pulling off shaft when shot through a target. Let dry 4-8 hours before shooting.

Note: Feathers have a natural curve to them right wing or left wing curve. You must use only right wing clamps to fletch right wing feathers and left wing clamps with left wing feathers. You cannot mix left and right wing feathers on the same shaft. The Bohning Pro Class jig is available with left and right wing helical clamps or a straight clamp.

FLETCHING WITH THE BOHNING TOWER JIG

I. Shaft Preparation - Follow steps outlined above

II. Arrow Fletching

- A. Adhesive Bohning Fletch-Tite Platinum Adhesive is recommended. If using a fast set adhesive, you must first place Teflon Tape on the inside edges of the slots on the vane clamps to prevent them from adhering to the shaft.
- B. Move the lever on the Tower base all the way to the right.
- C. Load a vane in each of the three clamps, making certain the vanes are fully seated in slots and the leading edge of the vane points toward the top of shaft.

- D. Apply thin bead of adhesive to each vane base, starting at top, moving toward Tower.
- E. Place arrow shaft on post in center of Tower.
- F. Manually tilt the clamps up into position against the shaft.
- G. Place appropriate ring over clamps (Red for carbon and small diameter shafts, Black for Aluminum and larger diameter shafts.)
- H. Slide slightly down the shaft, making sure it is in the up position, keeping the notch aligned with one of the indicator lines on the ends of the clamps.
- I. Push lever on base of Tower to left, moving clamps into position against shaft.
- J. Slide ring slightly further down clamps, locking them in place against shaft.
- K. Wait 2-5 minutes, remove the ring and slide lever at base of Tower to right, releasing clamps.
- L. Manually pull the clamps away from the shaft and remove the shaft.
- M. Dot the ends of each vane with adhesive.

APPLYING BOHNING ARROW WRAPS

I. Shaft Preparation

- A. Remove any old adhesive with acetone or lacquer thinner.

II. Applying Wraps:

- A. Remove wrap from backing
 - 1. Place wrap on a flat surface that is slightly raised from table, such as a computer mouse pad.
 - 2. With the adhesive side up, align the shaft along the long edge of the wrap and roll the shaft over the wrap with a steady motion and pressure.
 - 3. It is best to remove any oils from the surface of the wrap with Ivory Bar soap before fletching.
 - 4. Fletch according to the instructions for the particular jig you are using.

III. Removing Arrow Wraps:

- A. Option 1
 - 1. Soak in hot tap water for approximately 5 minutes. Peel wrap off shaft.
 - 2. Clean & prep shaft
- B. Option 2
 - 1. Heat wrap with hair dryer until soft enough to peel off.
 - 2. Clean & prep shaft
- C. Option 3
 - 1. Scrape wrap off using a Bohning Stripper Tool.
 - 2. Clean & prep shaft.

Potential causes of adhesion failures

Adhesive:

- old adhesive
- using wrong kind of adhesive for shaft type
- too little adhesive on vane base
- not enough pressure on vane

Shafts:

- not removing oil, dust or chemical compounds from shafts prior to fletching.

Vanes

- best when used within 2 years of the date of manufacture
- DO NOT CLEAN VANE BASE** – they are treated with primer to promote adhesion

- Use of silicone based aerosols, oils or chemicals in shop.
- Adhesive that has been repeatedly thinned.
- Clamps with adhesive build-up.
- Improperly set-up jigs.
- Eating while fletching, allowing oil to contaminate shaft surface.

Common Fletching Errors:

1. Did not properly prep the shaft (see Shafts)
2. Too little adhesive
3. Not enough downward pressure on the clamp
4. Residue (oil from skin or lotion) left on shaft or wrap
5. Vane base not in full contact with arrow shaft (jig not properly set-up)
6. Adhesive build up on clamp edge or interior, which impedes downward pressure (to avoid this use Bohning Teflon Tape for easy removal of excess adhesive)
7. Not enough clamp time
8. Didn't allow for complete cure (we recommend 24 hours).

Tips:

1. If vanes come off and the glue has adhered to the base of the vane, you should try cleaning your arrow shaft again in the manner described.
2. If the vanes come off and the glue has adhered to the shaft, you should check the dates on the vanes and ensure you are using enough downward pressure.
3. If the vanes come off the wrap and the wrap is intact with no tears, you should make sure you are cleaning any residue off of the wrap prior to fletching.
4. If the wrap comes off of the arrow shaft, you should prep it as described above.

THERE IS NO NEED TO CLEAN VANE BASES BEFORE FLETCHING.

The base of every Bohning vane is chemically treated to promote excellent adhesion. All Bohning vanes have the best adhesion when used within 2 years from the date of manufacture.

Bohning vanes are compatible with most commonly available adhesives.

*Never use alcohol to clean any shaft. If in doubt wipe cleaner on mirror.

If film results, do not use to clean shafts.