



- **CXL PRO™**
- **MAXIMA BLUE STREAK®**
- **LINEJAMMER®**
- **X-JAMMER-27 PRO™**
- **SPEED DEMON™**
- **X-BUSTER™**

**LARGE & STANDARD  
DIAMETER TARGET ARROW**

**SHAFTS**

[carbonexpressarrows.com](http://carbonexpressarrows.com)

# ARROW ASSEMBLY

## INSTALLING PRESS FIT NOCKS

Firmly press the press fit nock into the shaft by applying pressure to the nock valley base only. Do not put direct pressure on the nock tabs - direct pressure on the nock tabs may cause the nock to deform, crack or break. Once seated flush against the shaft, the nock can be turned for precise tuning. Press fit nocks do not have to be glued to the shaft.

## INSTALLING CARBON EXPRESS® GLUE-IN TARGET POINTS

Using a swab and denatured alcohol (available at most hardware stores), clean the inside of the shaft and the outside of the shank portion of the component. Apply a generous amount of glue\* to the shank of the component. Push the component into the shaft while simultaneously turning in order to evenly spread the adhesive until firmly seated.

\*Note: Use only an adhesive made for attaching components to carbon shafts. We recommend CX™ Express Bond or a slow setting epoxy for the best long term results.

**\*CX™ Express Bond (Model M1037)** with maximum adhesive strength should be used when installing carbon arrow components like points for the best long term results. **DO NOT USE A QUICK SETTING EPOXY.** Quick setting epoxy can become brittle during the hardening process and may not create a sufficient bond between the arrow shaft and component.

## DETERMINING YOUR CORRECT ARROW LENGTH

Using the bow and release system that you normally use (mechanical or fingers), draw the bow back to your anchor point. Have someone mark the shaft where it comes into contact with the front of the riser. Measure the length of the shaft from where the nock contacts the string (nock valley) to the spot marked. This distance is your standard arrow length. We recommend you cut one shaft and install the front end hardware of your choice to make sure the shaft is the correct length before cutting the other shafts.

## PROCEDURES FOR CUTTING CARBON ARROWS

- 1) Always use a high-speed cut-off tool (above 5,000 rpm) with an abrasive wheel when cutting carbon shafts. Using tube cutters or hand saws will damage the carbon fibers.
- 2) Always cut carbon shafts with nocks in place.

**WARNING: Always use the appropriate respiratory protection (NIOSH Approved Dusk mask), and eye protection (safety glasses) when cutting arrow shafts.**

## PREPARING CARBON SHAFTS FOR FLETCHING

- 1) Using a clean white paper towel, wipe the shaft where the fletching will be applied with denatured alcohol. Continue to lightly wipe the shaft with alcohol until all carbon dust and residue is removed.
- 2) Wipe the base of the vanes with denatured alcohol also. Some vane producers use a mold-release agent in the manufacturing process that must be removed for solid adhesion between the shaft and vane.
- 3) Do not touch the portion of the shaft to be fletched, or the base of the vane, or allow them to come into contact with any surface once they have been cleaned.

## FLETCHING CARBON SHAFTS

- 1) We recommend carbon shafts be fletched with CX™ Express Bond or super glue gel designed for carbon arrows.
- 2) Carbon shafts can be fletched with standard fletching jigs and clamps. For optimum performance and flight stability, we recommend bowhunters fletch their shafts using a helical clamp or a straight clamp with the jig offset at least 2 degrees.

## RE-FLETCHING CARBON SHAFTS

**(WARNING: Never soak carbon shafts in any harsh chemical, including acetone.)** MEK can be used on carbon shafts without damage to the finish if it is rubbed on the shaft with a clean rag.

- 1) Use a dull knife to remove old fletching and glue. Be very careful to only remove fletching and glue - do not remove any carbon fibers.
- 2) Repeat steps 1-3 detailed under Preparing Carbon Shafts for Fletching.

## DISCLAIMER

While Carbon Express is committed to bringing its customers the best arrows, the arrows are not designed to impact a metal, plastic, concrete or other hard surface. Firing any Carbon Express® arrow into such a hard surface will not only damage the arrow, prohibiting any other use, but may also cause serious injury or death. Shooting an arrow into a target encased in plastic or other hard surface, such as a decoy designed with such attributes, exposes the arrow to such conditions, may damage the arrow and/or cause serious injury or death. Such a target should not be used with any Carbon Express® arrow. Use of such arrows with a hard surface impact voids any warranty, express or implied.

## SAFETY WARNINGS FOR ARCHERS

The use of a bow and arrow requires considerable skill and should be treated with caution to avoid injury to persons and/or property. Bows and arrows should only be used by those who are properly trained in safety or under the supervision of a qualified instructor. Safety glasses should be worn while working with archery equipment. Read assembly instructions and all information included with arrows, hardware and adhesive packages.

**WARNING!** To avoid serious injury and learn about safe hunting techniques, users must read the instructions and watch the videos at [www.safearrow.com](http://www.safearrow.com) prior to shooting any arrow.

**CARBON EXPRESS® ARROWS SHOULD ALWAYS BE FLEXED IN A GRADUAL ARC AND VISUALLY INSPECTED FOR DELAMINATION, SPLITTING OR IMPACT CRUSH MARKS PRIOR TO SHOOTING. A DAMAGED SHAFT COULD FAIL COMPLETELY UPON RELEASE AND CAUSE INJURY TO YOURSELF OR OTHERS. NEVER SHOOT A CRACKED OR DAMAGED SHAFT.**

- After loading into the bow, do not point the arrow at yourself or others. It may discharge accidentally and cause serious injury to yourself or others.
- Do not shoot unless the target is visible and you are aware of what is behind the target area.
- Be conscious of shooting technique and sequence. Careless handling of bow and arrows and/or distractions can lead to serious injury to yourself and others.
- Always check all arrow components prior to shooting. Loose components can cause unbalanced arrow flight and partial dry firing of the bow.

The proper arrow size for a selected bow may differ from that of other bow brands or models due to design differences, the particular bow's set-up, arrow weight, etc. "Adjusted Bow Draw Weight" is a calculation that accounts for such differences, making arrow selection more reliable. To choose the proper arrow shaft size for your bow, use the Adjusted Bow Draw Weight chart to determine your correct draw weight, then use the Arrow Selection Chart to select your arrow shaft size. If your set-up falls between shafts sizes, choose the higher size (stiffer spine).

**WE RECOMMEND YOU SELECT THE LARGER SHAFT SIZE IF THE CHART INDICATES YOU ARE BETWEEN SIZES.**

**NOTE: Due to the equipment and accessory variations, other shaft sizes than the ones shown may be needed.**

Shaft straightness tolerances measured over a 28" span.

# BOW DRAW WEIGHT

## ADJUSTED WEIGHT CHART

Proper spine selection is the key to optimum arrow flight. With today's modern compounds, there are many variables that affect how an arrow reacts when it is thrust from the bow. The bow's cam, bow speed, arrow length and many other conditions affect performance during flight. Given the number of variables that require consideration, Carbon Express® STRONGLY recommends that you begin by using the company's adjusted bow draw weight chart to calculate a final pound number for your bow.

**WARNING. FOR COMPOUND BOW USE:** It is CRITICAL that you determine your proper adjusted bow draw weight before selecting arrow shafts. Selecting the wrong shaft could result in damage to the shaft and/or serious injury. To avoid serious injury and learn about safe hunting techniques, users must read the instructions and watch the videos at [www.safearrow.com](http://www.safearrow.com) prior to shooting any arrow.

	Bow Draw Weight 59.9 lbs. or under	Bow Draw Weight 60 lbs. or over	Calculated Draw Weight
1. Measured Draw Peak Weight	-----	-----	= _____
2. Round Wheel	0	0	
Single Cam	+5	+7	
High-Energy Cam	+6	+8	= _____
3. 65% - 80% Let-Off	-4	-5	
50% Let-Off	0	0	= _____
4. Glue-In Target Points 60-79 grains	-9	-9	
Glue-In Target Points 80-99 grains	-7	-7	
Glue-In Target Points 100 grains	-6	-6	
Glue-In Target Points 110-120 grains	-5	-5	
Glue-In Target Points 145 grains	-4	-4	
Insert & 70-79 grains Screw-In Point	-9	-9	
Insert & 80-99 grains Screw-In Point	-8	-8	
Insert & 100 grains Screw-In Point	-7	-7	
Insert & 125 grains Screw-In Point	-6	-6	
Insert & 145 grains Screw-In Point	-5	-5	= _____
5. Arrow Length 25.9" or less	-2	-2	
Arrow Length 26" to 27.9"	+1	+1	
Arrow Length 28"	+2	+3	= _____
6. Finger Release	+3	+6	= _____
7. If the bow's speed rating exceeds:	AMO	IBO	
240 FPS	300 FPS	+2	+3
245 FPS	306 FPS	+3	+4
250 FPS	313 FPS	+4	+5
255 FPS	319 FPS	+7	+8
260 FPS	325 FPS	+9	+10
270 FPS	335 FPS	+11	+12
280 FPS	345 FPS	+13	+14
290 FPS	360 FPS	+15	+16
			= _____

Adjusted Bow Draw Weight =

# SHAFT SELECTION CHART

		ARROW LENGTH												
		23"	24"	25"	26"	27"	28"	29"	30"	31"	32"	33"		
COMPOUND BOW (ADJUSTED WEIGHT)						PT800	PT800 SD750	PT800 SD750						13-18 lbs.
	13-18 lbs.				PT800	PT800 SD750	PT800 SD750	PT800 SD750 XB700	SD650					19-24 lbs.
	19-24 lbs.			PT800	PT800 SD750	PT800 SD750	PT800 SD750 XB700	PT700 SD650 XB700	SD650 XB600					24-34 lbs.
	25-34 lbs.		PT800	PT800 SD750	PT800 SD750 XB700	CXL150 MAX150 PT800 SD750 XB700	CXL150 MAX150 PT700 SD650 XB700	CXL150 MAX150 LJ250 PT2040 SD650 XB600	CXL150 MAX150 LJ250 PT3050 SD550 XB600	CXL250 MAX250 LJ250 SD550 XB500	CXL250 MAX250 LJ250	CXL250 MAX250 LJ250		35-39 lbs.
	35-39 lbs.		PT800 SD750	CXL150 MAX150 PT800 SD750	CXL150 MAX150 SD750 XB700	CXL150 MAX150 PT700 SD650 XB700	CXL150 MAX150 LJ250 PT2040 SD650 XB600	CXL150 MAX150 LJ250 PT3050 SD650 XB600	CXL150 MAX150 LJ250 PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* SD550 XB500	CXL250 MAX250 LJ250 XJ* XB400	CXL250 MAX250 LJ250 XJ*		40-45 lbs.
	40-45 lbs.	PT800	CXL150 MAX150 PT800 SD750	CXL150 MAX150 PT800 SD750 XB700	CXL150 MAX150 PT700 SD650 XB700	CXL150 MAX150 LJ250 PT2040 SD650 XB600	CXL150 MAX150 LJ250 PT2040 SD550 XB600	CXL150 MAX150 LJ250 PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB500	CXL350 MAX350 LJ250 XJ* SD450 XB400	CXL350 MAX350 XJ*		46-51 lbs.
	46-51 lbs.	PT800	CXL150 MAX150 PT800 SD750	CXL150 MAX150 PT700 SD650 XB700	CXL150 MAX150 LJ250 PT2040 SD650 XB700	CXL150 MAX150 LJ250 PT2040 SD550 XB600	CXL250 MAX250 LJ250 XJ* PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB400	CXL350 MAX350 LJ250 XJ* XB400	CXL350 MAX350 XJ*		52-57 lbs.
	52-57 lbs.	PT800	CXL150 MAX150 PT700 SD650 XB700	CXL150 MAX150 LJ250 PT2040 SD650 XB700	CXL250 MAX250 LJ250 PT2040 SD550 XB600	CXL250 MAX250 LJ250 XJ* PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB400	CXL350 MAX350 XJ* XB400	CXL350 MAX350 XJ* XB350	CXL350 MAX350 XJ*		58-63 lbs.
	58-63 lbs.	PT700 XB700	CXL150 MAX150 PT700 SD650 XB700	CXL250 MAX250 LJ250 XJ* PT2040 SD550 XB600	CXL250 MAX250 LJ250 XJ* PT3050 SD550 XB500	CXL250 MAX250 LJ250 XJ* SD550 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB400	CXL350 MAX350 XJ* XB400	CXL350 MAX350 XJ* XB350	CXL350 MAX350 XJ* XB350	CXL350 MAX350 XJ*		64-69 lbs.
	64-69 lbs.			CXL250 MAX250 LJ250 XJ* SD550 XB600	CXL250 MAX250 LJ250 XJ* SD550 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB500	CXL350 MAX350 LJ250 XJ* SD450 XB400	CXL350 MAX350 XJ* XB400	CXL350 MAX350 XJ* XB350	CXL350 MAX350 XJ* XB350				70-75 lbs.
	70-75 lbs.			CXL250 MAX250 LJ250 XJ* SD550 XB500	CXL250 MAX250 LJ250 XJ* SD450 XB500	CXL350 MAX350 LJ250 XJ* SD450 XB400	CXL350 MAX350 XJ* XB400	CXL350 MAX350 XJ* XB350	CXL350 MAX350 XJ* XB350					

RECURVE BOW (BOW DRAW WEIGHT)

**LEGEND:**

CXL = CXL Pro™ MAX = Maxima Blue Streak® LJ = LineJammer® PRO XJ = X-Jammer-27 Pro™ PT = Predator™ SD = Speed Demon™ XB = X-Buster™

Note: For compound bows, you must first calculate your adjusted weight from the adjusted weight chart. Recurve bows use the weight on the right side from the draw weight of your bow at your draw length.

\*A heavier point may be required to achieve proper arrow flight.

# SPECIFICATION SHEET

ARROW DESCRIPTION	Grains per inch	Spine	Straightness	Diameter
MAXIMA BLUE STREAK® 300	8.3	0.347"	±0.0025"	0.295"
MAXIMA BLUE STREAK® 250	7.4	0.413"	±0.0025"	0.290"
MAXIMA BLUE STREAK® 150	6.5	0.508"	±0.0025"	0.284"
X-BUSTER™ 700	8.7	0.701"	±0.0025"	0.327"
X-BUSTER™ 600	9.0	0.584"	±0.0025"	0.329"
X-BUSTER™ 500	9.0	0.493"	±0.0025"	0.358"
X-BUSTER™ 400	9.5	0.396"	±0.0025"	0.360"
X-BUSTER™ 350	10.2	0.323"	±0.0025"	0.363"
CXL PRO™ 150	5.9	0.504"	±0.0025"	0.348"
CXL PRO™ 250	6.4	0.417"	±0.0025"	0.350"
CXL PRO™ 350	7.2	0.361"	±0.0025"	0.354"
X-JAMMER-27 PRO™	7.7	0.290"	±0.0025"	0.414"
LINEJAMMER® PRO	7.1	0.361"	±0.0025"	0.381"
SPEED DEMON™ 750	5.5	0.731"	±0.0025"	0.271"
SPEED DEMON™ 650	5.7	0.633"	±0.0025"	0.272"
SPEED DEMON™ 550	6.1	0.549"	±0.0025"	0.283"
SPEED DEMON™ 450	6.8	0.455"	±0.0025"	0.288"
SPEED DEMON™ 350	7.9	0.356"	±0.0025"	0.292"

For Technical Assistance on any Carbon Express® Arrow and Dealer Orders, call 1.810.733.6360

**carbonexpressarrows.com**

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**YOUTH ARROWS:** Intended for Ages 13 and Up!



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