

william wood-write

Elegant Sierra Click pen instructions



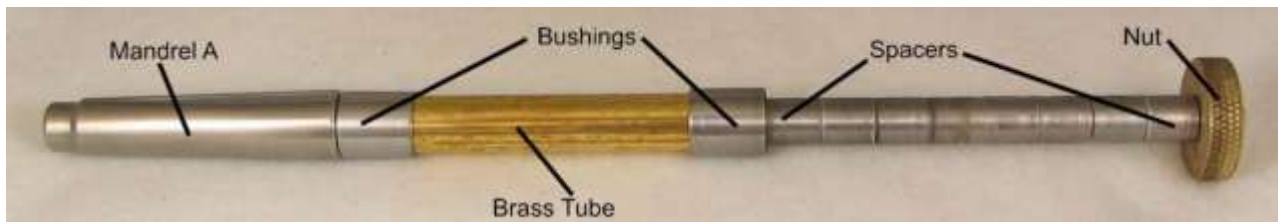
Needed:

Mandrel A; bushing 20A; drill 27/64;

Preparing the blank

1. Only one blank (half of a standard length pen blank) is required for this pen. Cut the blank slightly longer than the brass tube so you'll be able to square the ends off once the tubes have been glued in.
2. Drill the blank through the center, lengthwise, with a 27/64" bit.
3. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tubes with a material of your choice – we recommend base plate wax – to keep the glue from getting into the tube. Just push the ends of the tubes into a thin section of the material to form a plug. This is important: glue in the tubes is a common cause of kit failure.
5. Prepare your glue. We recommend two part epoxy glue – use a fast drying type, one hour or less. Be sure to mix it thoroughly. Wax or baking paper or even a Post-it notepad all make excellent mixing surfaces. You can also use thick flexible CA glue, but you have to work quickly to get the tube all the way into the blank before the glue dries.
6. Roll the tube in the glue.
7. Insert the tube with a twisting motion until it is almost entirely inside the blank. Use a dowel or small stick to push it until the tube is equidistant between both ends of the blank.
8. When the glue has cured, use a hobby knife to remove the plugs from the ends.
9. Using a barrel trimmer of the proper size, square off the ends of the blank until you can see bright brass tube. STOP at this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another common cause of pen failure.*

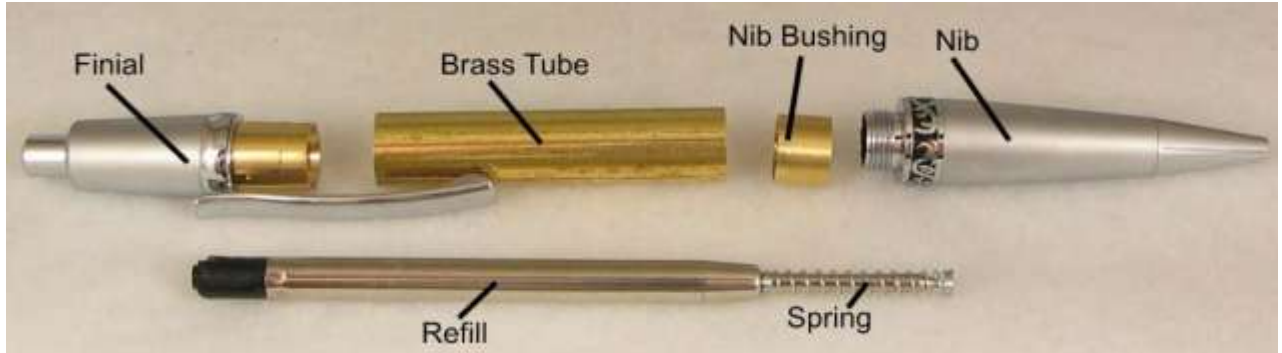
Turning the blanks



1. Assemble the blank on the mandrel using the 20A bushings and following the diagram above.
2. As there is only one blank to place on the mandrel, you will have to place spacers on the mandrel in order to tighten the tube for turning. You can drill a 7 mm hole in a piece of wood for a spacer. 7 mm bushings also make excellent spacers.
3. Lightly tighten the mandrel and secure. Do not over-tighten the brass nut – this can cause the mandrel to bend, which means your pen will come out oval.

4. Turn the pen blank to the desired shape using the bushings as a sizing guide.
5. After turning, sand the surface in progressive steps until you get to 400 or 500 grit.
6. For a smooth finish, continue sanding with Micro Mesh from 1,500 to 12,000 grit and apply a finish of your choice.
7. Remove the blank from the mandrel.

Assembling the pen



1. Press the finial/button click assembly into one end of your finished blank.
2. Press the nib bushing, the threaded brass insert, into the other end of the blank.
3. Insert the Parker-style refill into the nib assembly. Make sure the small spring is in place on the tip of the refill.
4. Screw the nib and refill assembly into the nib bushing.