

Maple Leaf Button Click pen



Needed:

Mandrel A; bushing 104A; drill 27/64

Preparing the blank

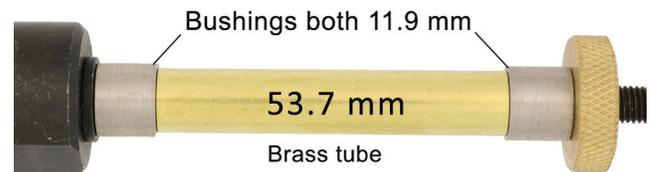
1. Only one blank (half of a standard length pen blank) is required for this pen. Cut the material blank 1/4" longer than the brass tube so you can square the ends off once the tube is glued in.
2. Drill the blank through the center, lengthwise, with a 27/64" bit.
3. Scuff the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate wax – to keep the glue from getting into the tube. Push the tube ends into a thin section of the material to form a plug. *This is important – glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in the glue then insert it into the blank using a twisting motion until the tube is equidistant between both ends of the blank.
6. Set aside until the glue has had time to reach its maximum strength.

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7. When the glue has cured, remove the plugs from the ends.
8. 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 major cause of kit failure.*

Turning the blank



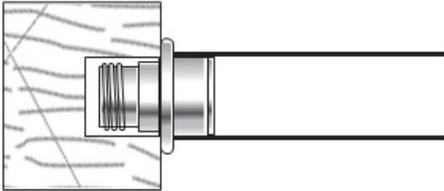
1. Assemble the blank on the mandrel using the 104A bushings and following the diagram above.
2. Lightly tighten the mandrel and secure. Do not over-tighten the brass nut – this can bend the mandrel which will result in an oval pen.
3. Turn the pen blank to the desired shape using the bushings as a sizing guide.
4. After turning, sand the surface in progressive steps until you get to 400 or 600 grit. For a smooth finish, continue

sanding with Micro Mesh from 1,500 to 12,000 grit.

5. Apply a finish of your choice and remove the blank from the mandrel.

Assembling the pen

1. Press the nib assembly into the bottom of the finished barrel.
2. **USING A PRESS BLOCK OVER THE BUTTON**, press the finial assembly with the clip into the top of the finished barrel. **DO NOT PRESS DIRECTLY ON THE BUTTON.**



* To protect the click mechanism from damage, make a press block by drilling a 5/16" hole through a 1/2" long scrap of blank. Place the press block over the button at the top of the pen so not to press directly onto the button.

3. Unscrew the nib assembly from the nib coupler and insert the ink refill, with the spring, into the barrel. Make sure the black plastic end of the refill seats all the way into the click mechanism at the top of the barrel.
4. Screw the nib coupler back onto the nib assembly, over the refill.

