

Sierra Click pen



Needed:

Mandrel A; bushing 20A; drill 27/64

Preparing the blank

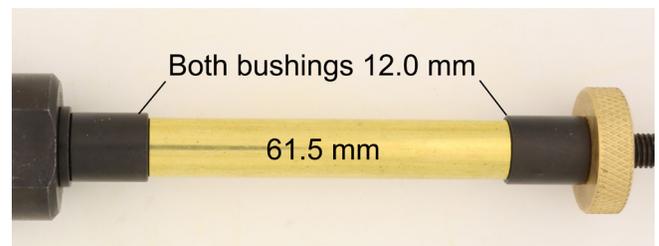
1. Cut the blank 1/4" longer than the brass tube so you'll be able to square the ends off once the tube has been glued in.
2. Drill the blank through the center, lengthwise, with a 27/64" bit.
3. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the 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 and insert the tube into the blank with a twisting motion until it is equidistant between both ends of the blank.
6. When the glue has cured, use a hobby knife to remove the plugs from the ends.
7. Using a barrel trimmer of the proper size or the proper jig and a disk sander, square

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off the ends of the blank until you can see bright brass tube. STOP at this point. *Not having the proper tube length is another common cause of pen failure.*

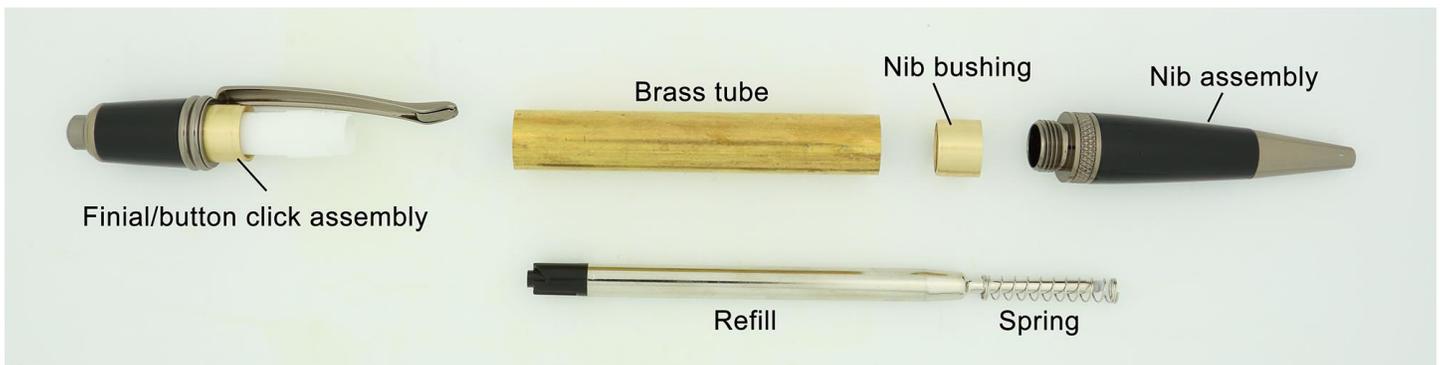
Turning the blank



1. Assemble the blank on the mandrel using the 20A 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 bushing (the threaded brass insert) into one end of your finished blank. Be sure to press the small, ridged end of the bushing into the tube first, as shown in the layout above.
2. Press the finial/button click assembly into the other end of your finished blank. It is important to use a block of wood or other material with a hole drilled to allow the button on the click assembly to pass through. This will allow the pressing force to be placed on the finial and NOT on the button. Pressing on the button itself will damage the button click mechanism.
3. Insert the refill into the nib assembly. Make sure the small spring is in place on the tip of the refill. Screw the nib and refill assembly into the nib bushing.



To make a press block:

Drill a 5/16" hole to a depth of 3/8" into a scrap piece of wood. Place the finial/button click assembly into the press block and press into the brass tube. This will keep the click assembly from being damaged.