

# Sierra Vista Circuit Board pen



## Needed:

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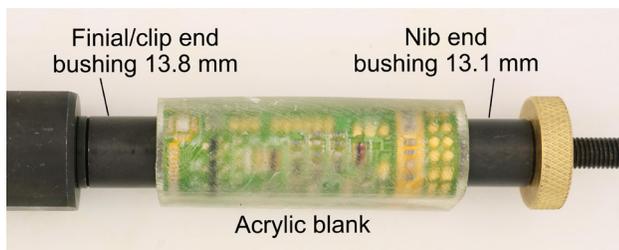
Mandrel A; bushing 50A

**Each kit comes with the blank you need to make the pen - it is pre-drilled with the tube inside. Be sure to use 50A bushings. Sierra 20A bushings will not work with this kit.**

**A special clear resin covers the circuit board, making it relatively easy to turn; this is what you turn down, sand and polish. These blanks are more difficult to turn when compared to wood or regular acrylic. Sharp tools and light cuts are absolutely necessary.**

## Turning the blank

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1. Carefully trim the edges of the blanks lengthwise using a belt or disc sander in order to reduce the stresses encountered when turning the blank.
2. Using a disc sander, very carefully trim the ends of the blank. DO NOT use a pen mill or barrel trimmer as this may damage the blank.

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3. Assemble the provided blank on the mandrel using the 50A bushings (see photo above). Select the larger bushing for the finial/clip end of the pen and the smaller one for the nib end.
4. Lightly tighten the mandrel and secure. Do not over-tighten the brass thumbnut – this can cause the mandrel to bend, causing your pen to come out oval.
5. Begin turning. Do not turn the material all the way to the bushings. Leave a small amount of material above the bushings for finishing (about 1.5 mm). If you turn the acrylic down to the bushings, you can easily ruin the blank by exposing the circuit board.
6. Finish these blanks as you would any acrylic blank. If an air bubble is exposed while turning, use a tiny drop of CA glue to fill it before you begin the sanding/polishing process. We recommend sanding to 600 grit using regular sandpaper. Then, use MicroMesh 1,500 through 12,000 grit. Finally, buff using Hut Ultra Gloss plastic polish.

## Assembling the pen

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1. Press the finial/clip assembly into the larger end of your finished blank.

2. Insert the refill into the nib assembly making sure that the spring is in place.
3. Screw the twist mechanism over the refill and into the nib assembly.
4. Slide the blank/finial/clip assembly over the twist mechanism.

