

Slim Max button click pen



Needed:

Mandrel A, drill 8 mm, bushing 109A

Preparing the blanks

1. Cut the blanks 1/4" longer than each brass tube so you can square off the blanks after the tubes have been glued in.
2. Drill lengthwise through each blank using a 8 mm drill bit.
3. Scuff the brass tubes with sand paper to clean off 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. 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 one of the tubes in glue and insert it into the blank with a twisting motion until it is equidistant between both ends of the blank. Repeat with the other tube.
6. Set aside until the glue has had time to reach its maximum strength.
7. When the glue has cured, use a hobby knife to remove the plugs from the ends.

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8. Using a barrel trimmer of the proper size, square off the ends of the blanks until you can see bright brass tube. STOP at this point. This can also be done with the proper jig and a disk sander. *Improper tube length is another common cause of pen failure.*

Turning the blanks



1. Assemble the bushings and barrels onto the mandrel referring to the image above.
2. Tighten the tailstock before tightening the blanks on the mandrel. Then tighten the nut that holds the blanks. Do not over tighten or you may bend your mandrel, which will cause your pens to come out oval.
3. Turn the blanks to the desired contour, making sure that the area next to the bushing is turned to the size of the adjacent bushing.
4. Sand to 400 or 500 grit. For a smooth finish, continue sanding with Micro Mesh through to 12,000 grit.

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

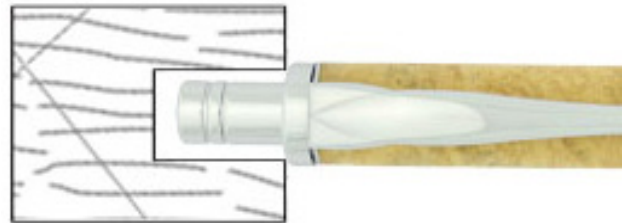
Assembling the pen

1. Slide the clip onto the finial and press this assembly into one end of the upper barrel.
2. Fully extend the 3 piece click mechanism. Insert the plastic click mechanism, small threaded end first, into the other end of the same barrel. Push it up with the black plastic end of the ink refill until the threaded portion of the click mechanism is in the top finial.
3. Drop the click mechanism spring into the finial over the threaded mechanism then screw on the button.
4. Using a press block over the button, press the center band, long insert first, into the other end of the same tube.
5. Press the nib bushing, recessed end first,

into the nib end of the lower barrel.

6. Press the center band end of the lower barrel onto the center band. Make sure to use the press block over the button.
7. Insert the ink refill with spring black plastic end first into the bottom end of the pen. Be sure the refill is completely seated in the click mechanism at the top of the pen.
8. Screw the nib on over the refill.

Press block



*** 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.**

