Sierra Click Pen Kits Assembly Instructions
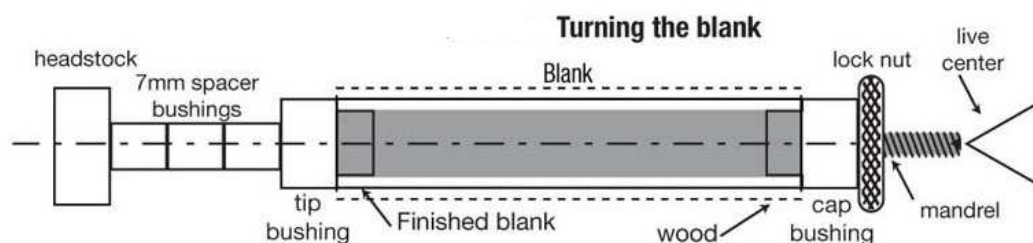
REQUIRED ACCESSORIES

7mm pen mandrel

2-pc bushing set RZ-BP40#-BU

27/64" drill bit RZ-DB27/64

Barrel trimming sleeve

Universal trimming kit

2-part epoxy glue or insta-cure glue(cyanoacrylate)

Preparing the Material Blanks

1. Only 1 material blank is required for this pen. Cut the material blank slightly longer than the brass tube.

2. Drill the blank through the center with a 27/64" drill bit.

3. Glue the tube in the blank , spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise inside the blank.

4. When the glue dries,square the ends of the blank using a 7mm barell trimmer with the adapter sleeve . Mount the sleeve over the shank. Trim the blank down flush with the brass tube.

TURNING THE BLANK

- Mount 7mm spacer bushing in the mandrel . Slide the bushing,wide end in first. Insert the blank. Follow with the other bushing, narrow end in first. Mount spacer bushing to fill the space to the threads on the mandrel . Screw on the lock nut hand tight. Do not overtighten the lock nut, it may damage the mandrel.

- Turn the blank down,close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings .

- Apply the finish of your choice and polish.

- Remove the blank from the mandrel.

Turning the blank

Click mechanism assembly

Step1

Step2

Step3

Diagram B

ASSEMBLY:
- NOTE: Line up finished parts according to diagram B
- Push the click mechanism(end A) into the chrome end of the top cap，put a drop of glue to hold the click housing in place.
- Press this finial clip assembly into the barrel
- Affix the refill spring over the refill tip. Insert the refill(black end first) into the barrel

- Thread on the tip assembly over the refill
- Drop the mechanism spring into the opening at the top cap
- Insert the click button and screw tight
- The pen operates by clicking on the button to extract or retract the refill