

Eagle Click Pen Kits Assembly Instructions

Required Accessories:

- 7mm pen mandrel
- 2 pcs Bushing Set
- 10.2mm Drill Bit
- Universal Barrel Trimmer 10mm shaft
- Live Tailstock Center
- 2 part epoxy glue or instacure glue
- Minimum Blank size: 3/4" x 3/4" x 2-5/32"

Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 10.2mm hole lengthwise through 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 in the blank.
- When the glue dries, square the end of each blank. Use a Barrel trimmer with 10mm shaft or a universal pen blank squaring jig with a power disc sander.
- Take the wood down to the brass tube. Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly.
- Use the barrel trimmer shaft to clean the inside of the tube.



Turning the Blanks:

- Mount the bushings and blanks on the mandrel according to the Diagram above.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.)
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.

Diagram A



Pen Assembly

NOTE: Line up the components according to the above picture.

- Press the clip assembly into either end of the barrel.
- Slide the click mechanism into the end of clip assembly.
- Press tip assembly into the opposite end of the barrel.
- Insert the Refill with the spring into the open end of the threaded tip adapter.

Note: Make sure the refill goes through the tube end to show the click mechanism.

- Thread the tip onto the threaded tip adapter.
- Thread the Click spring and the click button onto the end of the Click assembly.

Note: Do not over tighten the assembly onto the Click Mechanism.

- To advance the refill press the end of the click mechanism, to retract the refill press the end of the click mechanism again.
- The pen is now ready to use. Just click the button to extend or retract the refill