

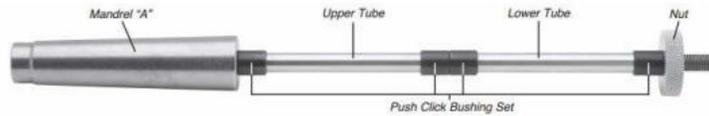
Push Click Pen Kits Assembly Instructions

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 11/32"
- Bushing set (4 pc)
- Barrel Trimming set
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank 5/8"x5/8"x4-1/2"

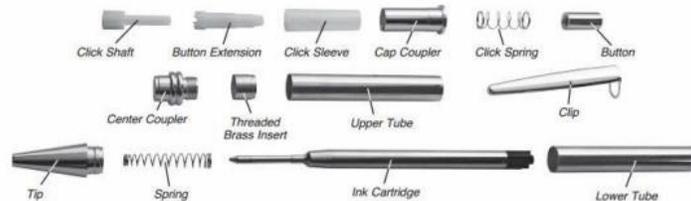
Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 11/32" center 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, use a universal squaring jig or a belt/disc sander to square the ends.
- Trim the wood down, flush to the brass tube.



Turning the Blanks

1. Assemble the blanks on the mandrel with the bushings placed as shown in the picture above. Keep the grain orientation of the blanks in line when mounting. Each bushing has a step that is designed to be inserted into the Brass Tubes for stability while turning, as the inner diameter of the tubes is larger than the mandrel. Note that all of the bushings are the same size.
2. Tighten the tailstock and then tighten the mandrel nut that holds the blanks. Do not over-tighten the tailstock or mandrel nut as this may cause the mandrel to flex, causing the blanks to go out of round.
3. Turn the blanks to the desired shape, making sure that the surfaces next to the bushings are turned to the same diameter as the bushings.
4. After turning, sand the surfaces in progressive steps of 220, 400, 600, and 1000 grit. If a higher finish is desired, micromesh sandpaper may be used.
5. Apply the finish of choice and polish.
6. Remove the blanks from the mandrel, keeping the blank orientation and grain patterns in line.



Assembly

1. Press the Tip into the end of the Lower Tube. Make sure you choose the appropriate end of the tube to preserve the pattern or grain match for your pen.
2. Press the Center Coupler into the open end of the Lower Tube, leaving the threaded end exposed.
3. Thread the Threaded Brass Insert onto the Center Coupler and then align the grain pattern of the Upper and Lower blanks. Using hand pressure, push the Upper Tube onto the Threaded Brass Insert until the Upper Tube is firmly seated and will not twist or fall out.
4. Gently unscrew the Upper Tube, making sure the Threaded Brass Insert does not shift. Fully press the Threaded Brass Insert into the Upper Tube.
5. Insert the Click Sleeve into the Cap Coupler. The end with the "ribs" is slightly smaller and will fit inside easily.
6. Insert the Click Shaft into the Button Extension until the gears mesh.
7. Insert the Button Extension assembly into the Click Sleeve, threaded end first.
8. Insert the Click Spring into the Cap Coupler, around the threaded end of the Button Extension.
9. Thread the Button onto the Button Extension assembly. Use the black end of the Ink Cartridge to push the Button Extension assembly toward the end of the Cap Coupler.
10. Make a pressing block by drilling a 1/4" diameter hole into a 3/4" thick piece of scrap wood.
11. Slide the Clip onto the Clicker assembly, then insert the Clicker assembly Button into the pressing block. Press the Clicker assembly into the far end of the Upper Tube, using the pressing block to prevent damage to the mechanism when pressing into place.
12. Slide the Spring onto the writing tip of the Ink Cartridge.
13. Insert the Ink Cartridge into the Lower Tube through the Center Coupler.
14. Thread the Upper Tube onto the Lower Tube and check the operation. If the operation is a little stiff, click the mechanism several times to break it in.