

# Slick Pro Gel Pen Kits Assembly Instructions

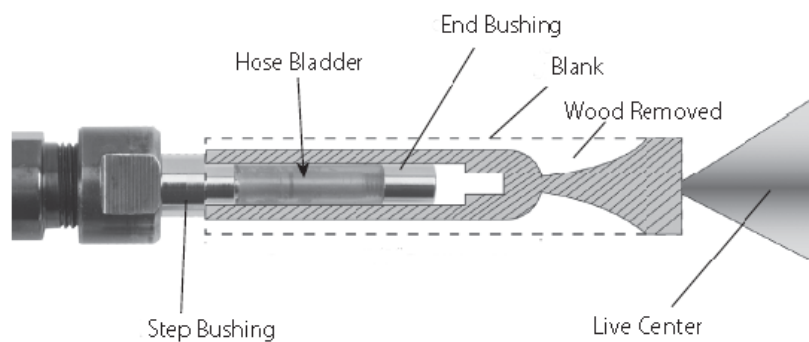
## Required Accessories:

- Big Grabber pen mandrel system
- 10MM Drill Bit
- 2-piece Bushing Set
- Pen Blank
- Sandpaper/Finish
- Glue (Thick CA or Epoxy)

## Preparing the Blank:

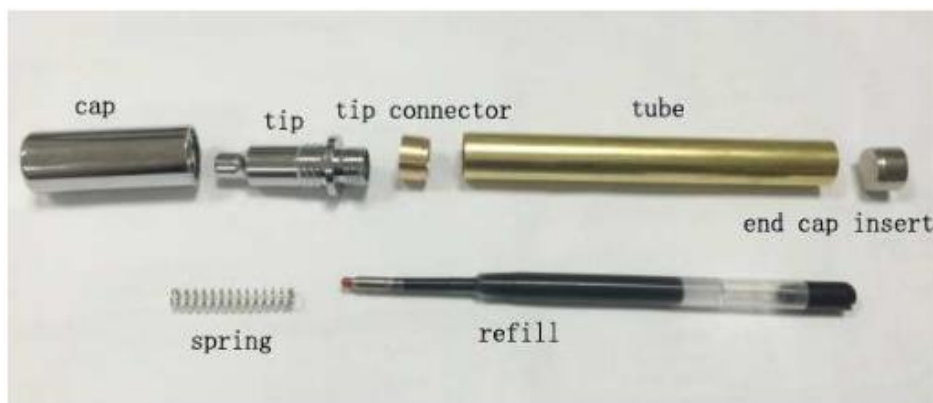
- Cut each blank 1/2" longer than the tube. The extra material is what provides the ability to leave the solid or closed-end on the barrel when turned.
- Before we drill the blank, we need to measure the length of the tube to be used and transfer this measurement to the drill bit by wrapping it with masking tape. The masking tape acts as a visual reference on how deep to drill the blank.
- Drill a 10mm hole through the blank
- Press the end cap insert to the tube first and the glue the tube into the hole, let dry.
- Use a sander (the hole is too short for a trimmer shaft) sand the end square.

## Turning the Barrel



- Insert the step bushing, the bladder and screw the end bushing over the mandrel shaft.
- Slide the blank over, to bottom. Expand bladder with lock nuts.
- Attach the mandrel into the taper of the lathe. Bring the tailstock over so the live centre support the blank. Lock set up in place, ready for turning.
- Turn the blank down to the bushing at the front, shape the end round as shown. Part off then sand off the end and finish the barrel manually.

## Assembly



- Press the tip connector, recessed end first into the opening at the barrel.
- Insert the spring into the recess in the bottom of the refill. Drop the refill into the opening at the barrel.
- Screw the tip to the connector. Screw the cap to the tip.