



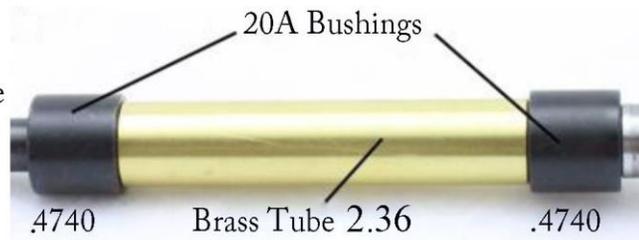
**KIT REQUIREMENTS-** Mandrel Shaft A, 27/64 Drill Bit, 20A Bushings

### **Preparing Your Blanks**

1. Only one blank is required for the Sierra Super Button Click Pen Kit, cut your blank about a 1/4" longer then the brass tube.
2. Using a Colt 27/64 bit drill lengthwise through the center of your blank.
3. Scuff up your brass tube with sandpaper.
4. Using the 2 part epoxy, System Three, mix equal parts of resin and hardener. Plug the end of the brass tube using base plate wax so glue does not get inside your pen tube. Roll the brass tube in the epoxy mix and insert it into the blank twisting it as you go in and out. Flip over the blank and do the same to the other side, remove the tube and look inside to make sure that the inside of the tube is “wet” with glue. Using an insertion tool pick up the brass tube and once again insert it into the blank twisting it as you go.
5. Set your blank aside to dry, the 5 min epoxy should be ready in about 30 minutes.
6. After your glue has dried, square the ends. We recommend either using a **sharp** Pen Mill or a disc sander with a squaring jig. Sand the blank until you **JUST** see the bright brass tube, **do not remove too much or when you assembly the pen your refill will not fully retract!**

### **Turning your Blanks**

Assemble the blank on your mandrel as shown. Both bushings are the same O.D.



1. Tighten your blank setup down on your mandrel. This will depend on your setup.
2. Turn the blank down to the desired shape. Do not turn your blank completely flush with the bushings. You will still need to sand and finish in the next few steps.
3. After turning, sand the surface of your blank in progressive steps, for wood- 150, 180,220, 360,400,600 and 800. Then use the Abralon pads and apply a finish of your choice. For acrylics, wet sand, using the Acrylic Sanding Pads PFK-1.
4. Remove your blank in preparation for assembly.

### **Assembling the pen**

1. Press threaded insert into one end of finished barrel.
2. Press Click Assembly into other end of finished barrel.
3. Slide spring into refill and insert into finished barrel.
4. Thread on nib.

