

Bolt Tec-Pen Kit Instructions

**Steve's
Woodcraft**

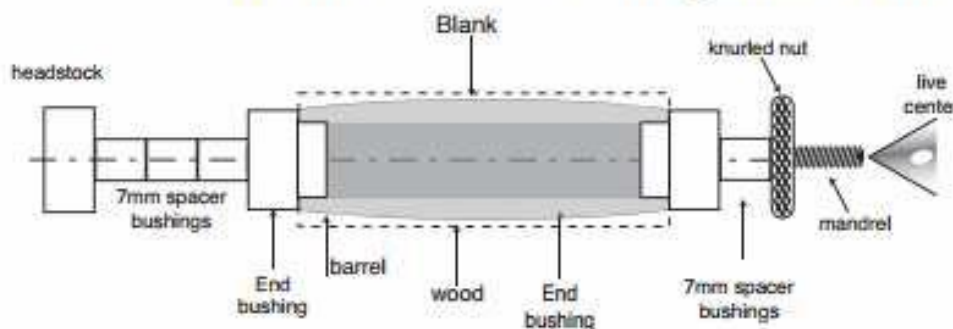
Required Accessories

- 7mm Pen Mandrel
- 2-piece Bushing set
- 8mm" drill bit
- Glue
- Pen blank



Preparing the Blank

1. Cut the blank to the length of the tube and add 2mm for squaring off.
2. Drill an 8mm hole lengthwise through the blank.
3. Glue the tube into the blank. Coat the outside of the tube with glue and insert the tube into the blank with a twisting motion to spread the glue until flush. Allow it to dry.
4. Square the ends of the blank to the tube.



Turning the Blank

1. Slide 7mm spacer bushings onto the mandrel shaft, followed by an end bushing. Slide on the blank followed by the other bushing. Add additional spacer bushings as necessary to reach the mandrel threads.
2. Thread on the locknut hand tight. Bring the tailstock in snug to the mandrel, lock in place. Tighten the lock nut for turning. DO NOT over tighten the locknut - it could damage the mandrel.
3. Turn the barrels close to the bushing diameter with sharp tools; sand the barrels to match the bushing diameter.
4. Finish the wood with your choice of polish.

Assembly

1. Layout Finished parts according to picture below.
 2. Press the tip and connector into either end of the barrel.
 3. Press the back-end assembly into the opposite end of the barrel.
 4. Unscrew the tip and insert the refill into the opening.
 5. Insert the spring over the refill, switch the bolt into the upper position and the replace the tip.
 6. Screw on the stylus cap or plain end cap.
- NOTE: Please do not press the front end of this kit with the tip removed. If you do so the parts will not assemble properly.

