

## Wall Street II Click Pen Kit

Product: #148461, # 148462, #149178, #149243, 2/4/2019  
 #150307, #150309, #150546, #150864, #150865,  
 #165908



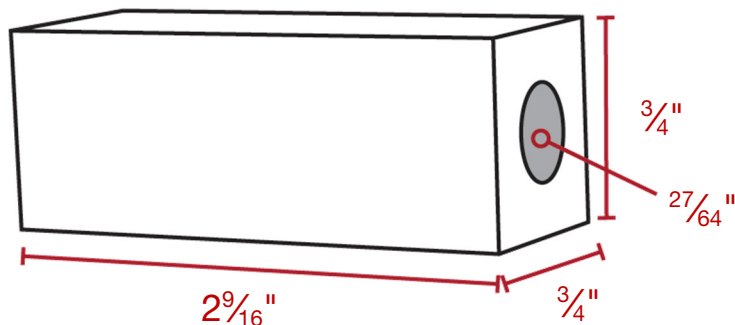
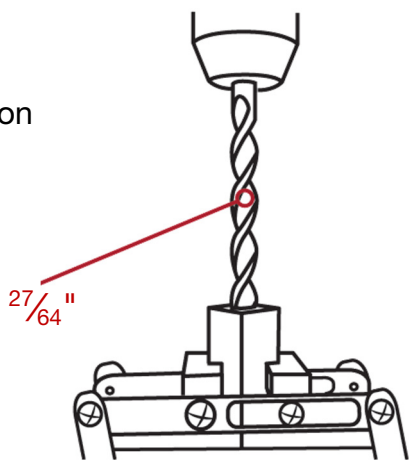
### From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- $27/64$ " Pen Maker's Bit
- $3/4$ " x  $3/4$ " x  $29/16$ " Pen Blank
- Pen Mandrel
- Wall Street II Bushings (146597)
- Thick CA or 5-Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- Barrel Trimmer
- Pen Press
- Eye & Ear Protection
- Dust Mask

### Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.

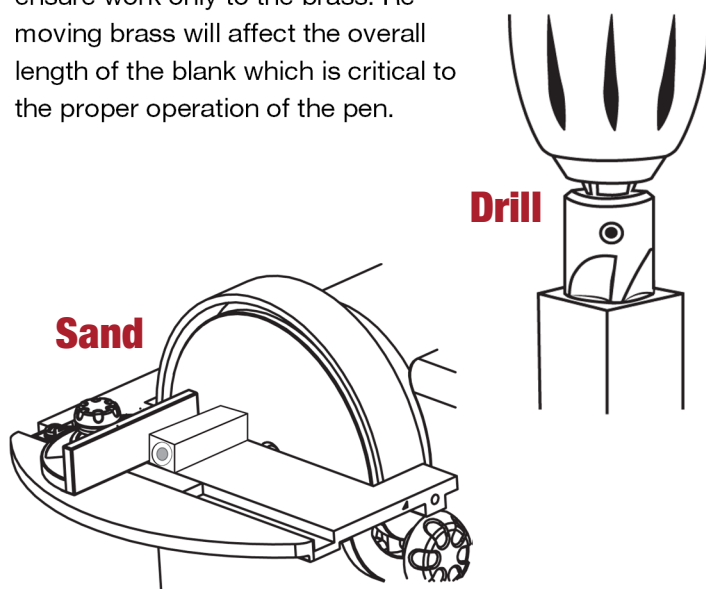


### Gluing Blanks to Tubes:

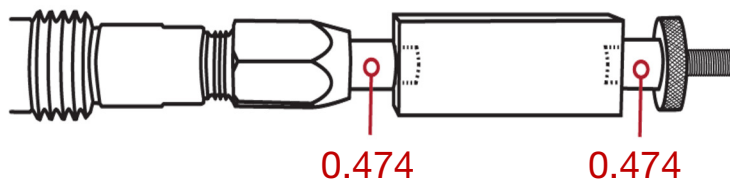
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5-Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.

### Squaring the Blank to Length:

When squaring the blanks to length ensure work only to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.



### Mandrel Preparation:

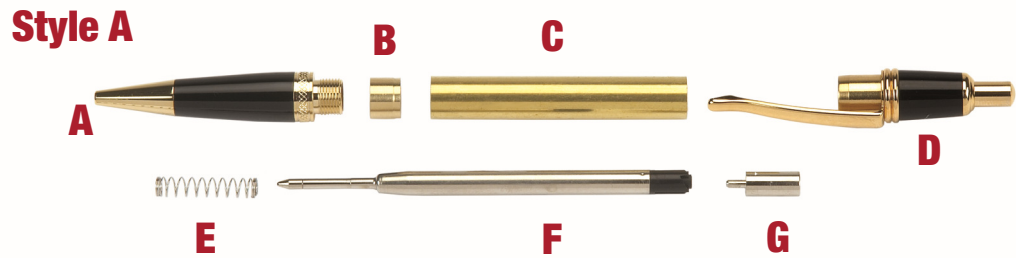


### Turning & Finishing the Blanks:

Turn the blank to your desired profile leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120-grit paper, and progress through the finer grits, finishing at 320-grit. Once finished with sanding apply a finish of your choice.

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### Assembly: Style A

- Press Threaded Nib Adapter (B) into one end of Body (C) until flush with the end of the tube.
- Next, using a sacrificial push-block with a 1/4" hole, 3/8" deep, press the Finial/Clip Assembly (D) into the opposite end of the tube. This will allow the pressing force to be placed on the Finial, not the Button.
- Slide Spring (E) over the Ink Refill (F). Using your hands press the Refill Adapter (G) into the hole in the center of the black upper end of the Ink Refill (F).
- Insert the Ink Refill Assembly (E, F, G) spring end first into Nib (A) and thread into the open end of the Body (C).

To advance the ink refill depress the button, to retract the ink refill, depress the button again.

### Assembly: Style B

- Press Threaded Nib Adapter (B) into one end of Body (C) until flush with the end of the tube.
- Next, using a sacrificial push-block with a 1/4" hole, 3/8" deep, press the Finial/Clip Assembly (D) into the opposite end of the tube. This will allow the pressing force to be placed on the Finial, not the Button.
- Slide Spring (E) over the Ink Refill (F), insert the Ink Refill Assembly (E, F) spring end first into Nib (A) and thread into the open end of the Body (C).

To advance the ink refill depress the button, to retract the ink refill, depress the button again.

### Style B

