

Script Click Ballpoint Pen Kits

Product #: 161785, 161786, 161787

6/21/2016



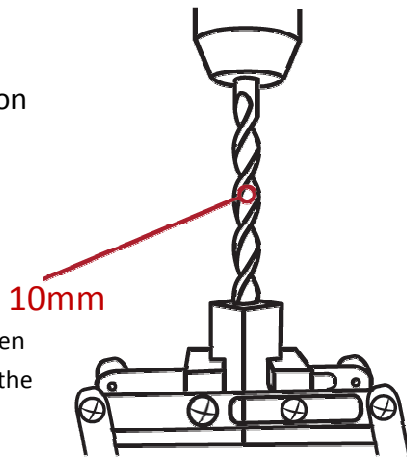
From Setup To Sanding:

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

- 10mm Pen Maker's Bit
- 1 - $3/4$ " x $3/4$ " x 2" Cap Blank
- 1 - $3/4$ " x $3/4$ " x $2\frac{1}{2}$ " Body Blank
- Pen Mandrel
- Script Bushings (161789)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/MicroMesh
- 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.

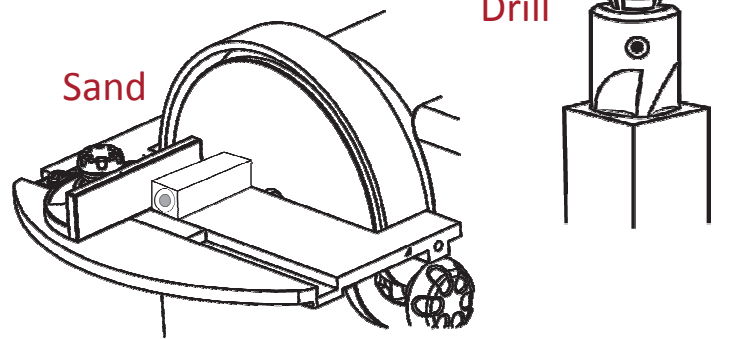


Gluing Blanks to Tubes:

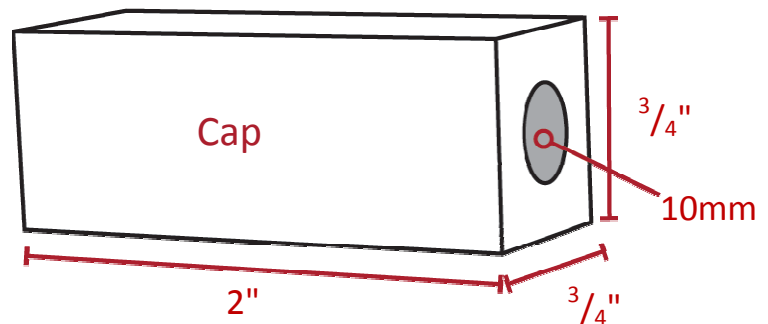
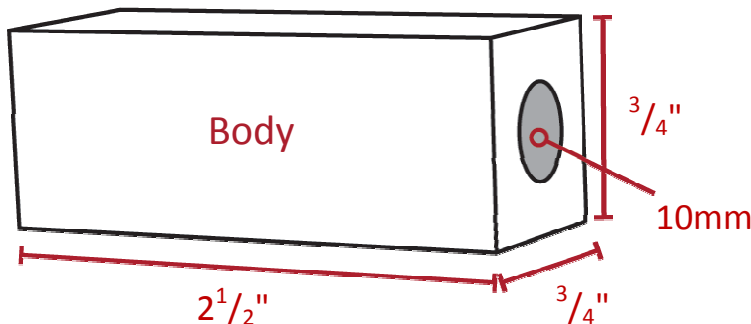
Rough the entire surface of the tube using 180 grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube into the inside of the blank make sure to rotate the tube as you insert it into the blank. This will help ensure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

Squaring the Blank to Length:

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



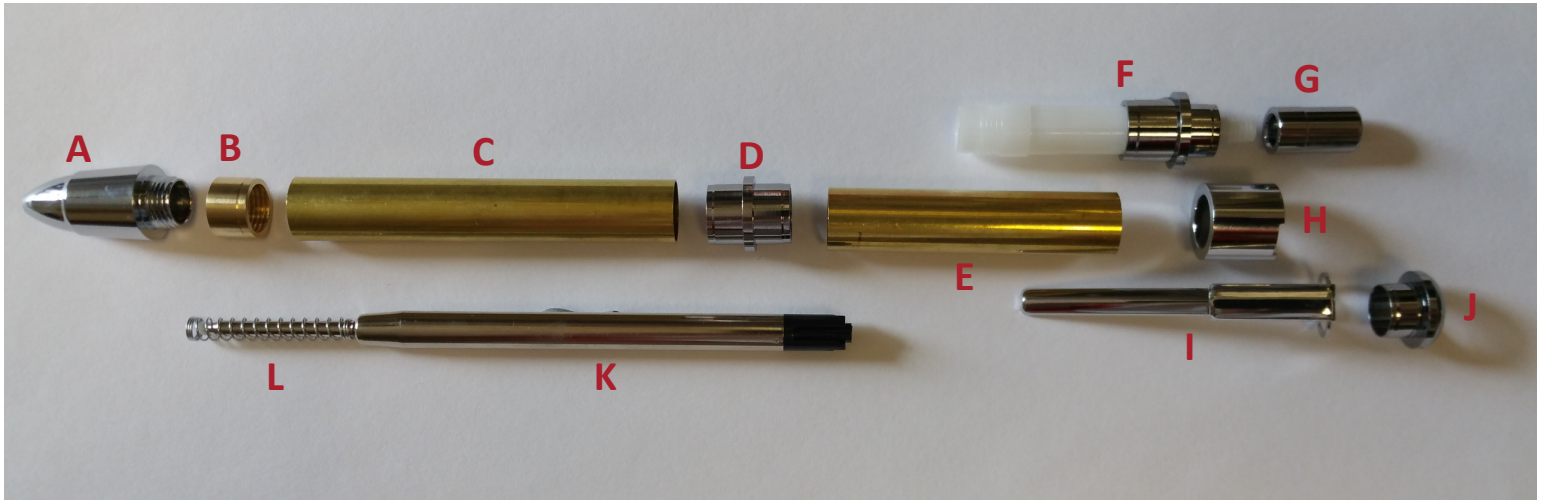
Mandrel Preparation:



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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 progressing through the finer grits finishing at 320 grit. Once finished with sanding apply a finish of your choice.

Pen Assembly:

Cap:

- ❑ Press Click Assembly (F) into one end of the Cap Blank (E). The use of a sacrificial press block will need to be used for this step. Using a scrap piece of wood, bore a $\frac{9}{32}$ " diameter hole $\frac{1}{4}$ " deep. Place the threaded end of the Click Mechanism (F) into the hole of the press block and press the two parts together.
- ❑ Next press the Clip Spacer (H) onto the end of the Click Mechanism, paying attention to the orientation of the notch that will later receive the clip as this is where the clip will be positioned.
- ❑ Slide the Clip (I) onto Finial (J) and press into the Clip Spacer (H). Ensure that the clip is seated in the notch. Set this portion aside for final assembly.

Body:

- ❑ Press Threaded Nib Bushing (B), tapered end first into one end of Body Blank (C).
- ❑ Next thread Nib (A) into the Threaded Nib Bushing previously installed.

- ❑ Press Center Coupler (D), either end, into the open end of the Body Blank (C).
- ❑ Press the assembled Cap and Body together.
- ❑ Next unscrew Nib (A) and insert Ink Refill (K) and Spring (L) black end first into the open end. Once inserted thread Nib (A) into the end of the pen assembly.
- ❑ Last, thread the Push Button (G) onto the Click Assembly and test the operation.