

## Fireman's Click Ballpoint Pen Kit

Product : #162554

2/15/201



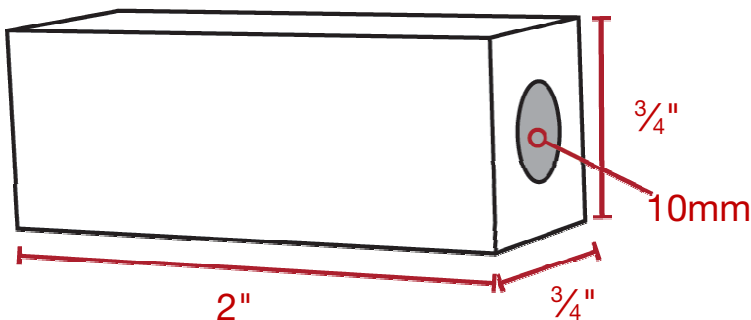
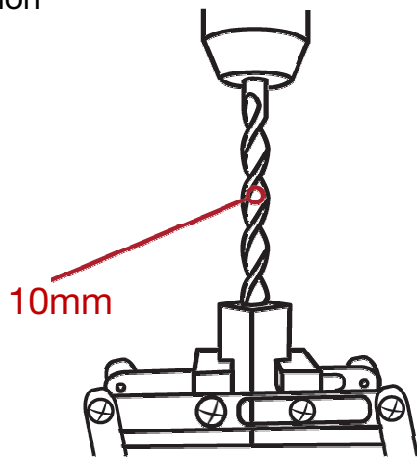
### From Setup To Sanding:

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

- 10mm Pen Maker's Bit
- 3/4" x 3/4" x 2" Pen Blank
- Pen Mandrel
- Lever Action/Fireman's Bushings (160834)
- 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.



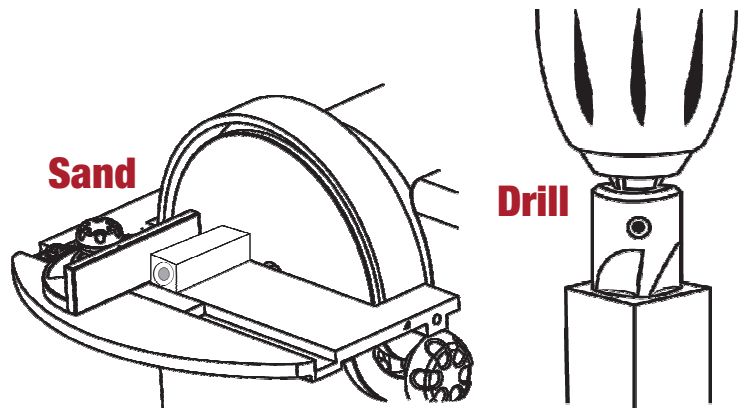
### Gluing Blanks to Tubes:

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 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.

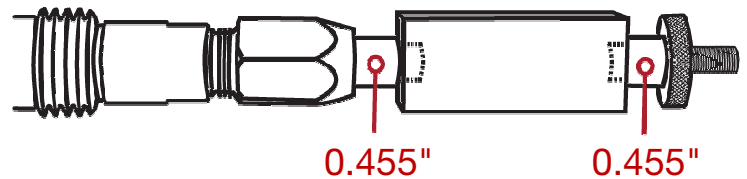
### Squaring the Blank to Length:

When squaring the blanks to length 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. **Note:**

**Due to the internal wall thickness of the brass tube it will be necessary to use a 3/8" pen mill pilot shaft.**



### Mandrel Preparation:



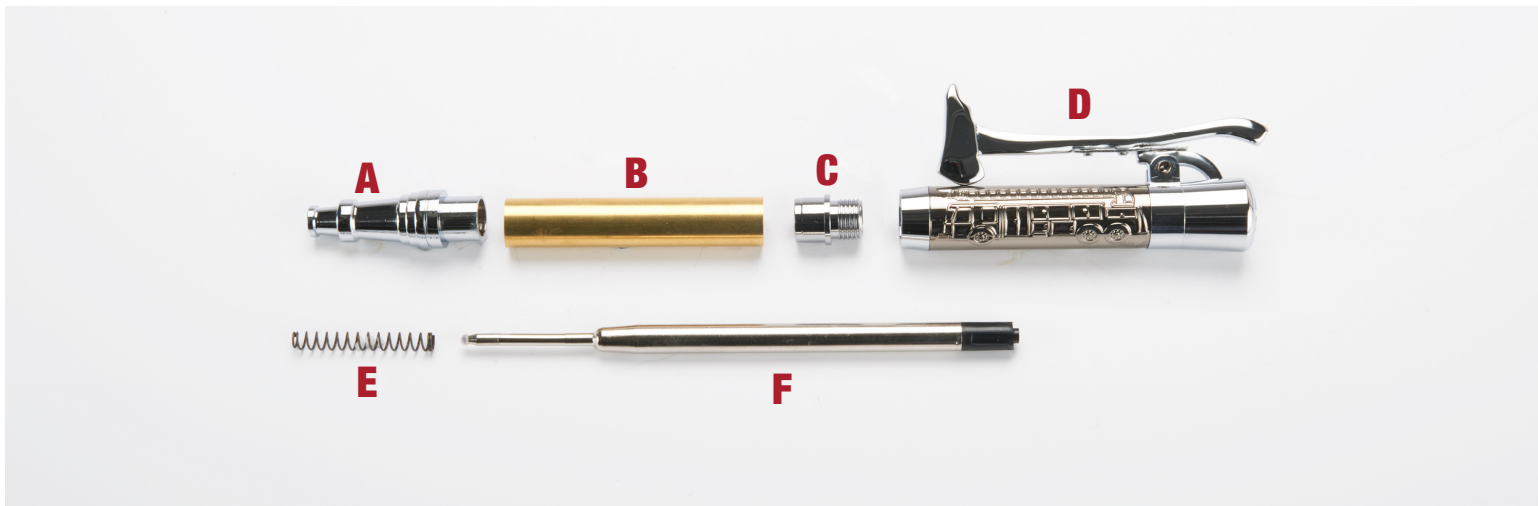
### Turning & Finishing the Blanks:

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.

## Fireman's Click Ballpoint Pen Kit

Product : #162554

2/15/201



### Assembly:

- Press Threaded Click Adapter (C) into one end of the Finished Blank Tube Assembly (B).
- Press the Nib (A) into the open end of the Finished Blank Tube Assembly (B).
- Slide Spring (E) small end first onto Ink Refill (F) and insert through the end of the Threaded Click Adapter (C) into the completed Blank Tube Assembly (A, B, C).
- Complete the assembly process by threading the Fireman's Click Assembly (D) onto the end of the Threaded Click Adapter (C).

To advance the ink refill lift up on the fireman's axe, to retract the ink refill lift up on the fireman's axe again.