

Wall Street II Schmidt Click Pen Kit

Product: #180418, #180419, #180420, #180459 2/11/2022



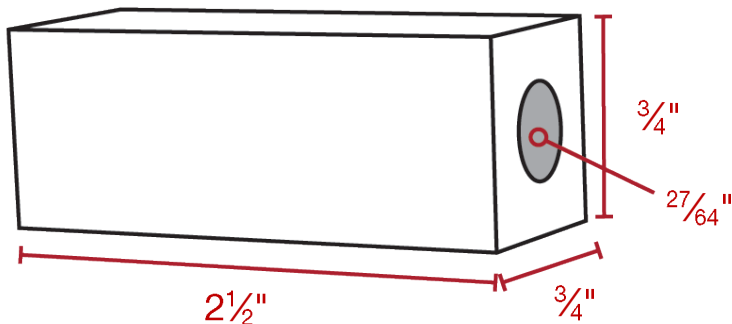
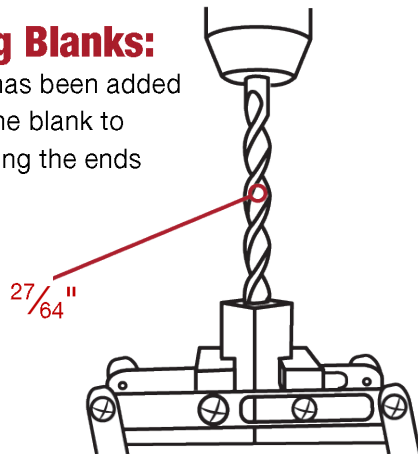
From Setup To Sanding:

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

- $\frac{27}{64}$ " Pen Maker's Bit
- $\frac{3}{4}$ " x $\frac{3}{4}$ " x $2\frac{1}{2}$ " Pen Blank
- Pen Mandrel
- Wall Street II Bushings (146597)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/MicroMesh
- Pen Mill Pilot Shaft $\frac{27}{64}$ "
- 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.

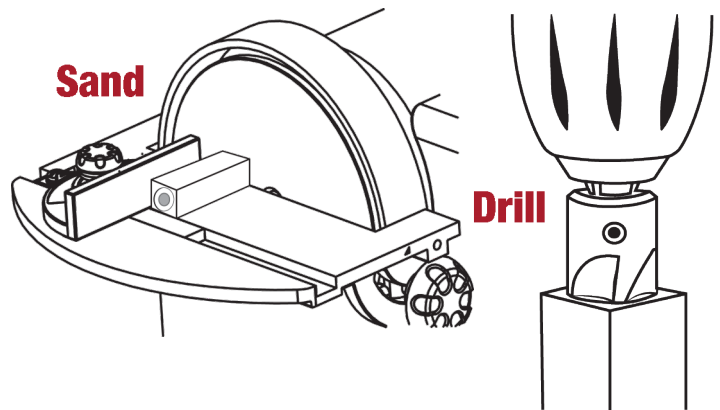


Gluing Blanks to Tubes:

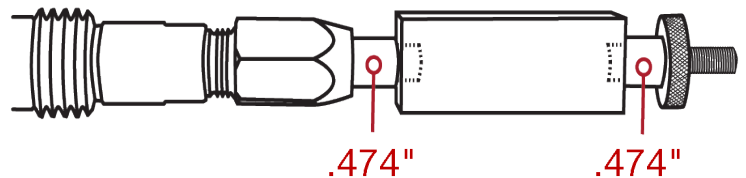
Rough the entire surface of the tube using 180 grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube into the inside of the blank make sure to rotate the tube as you insert it into the blank. This will help ensure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



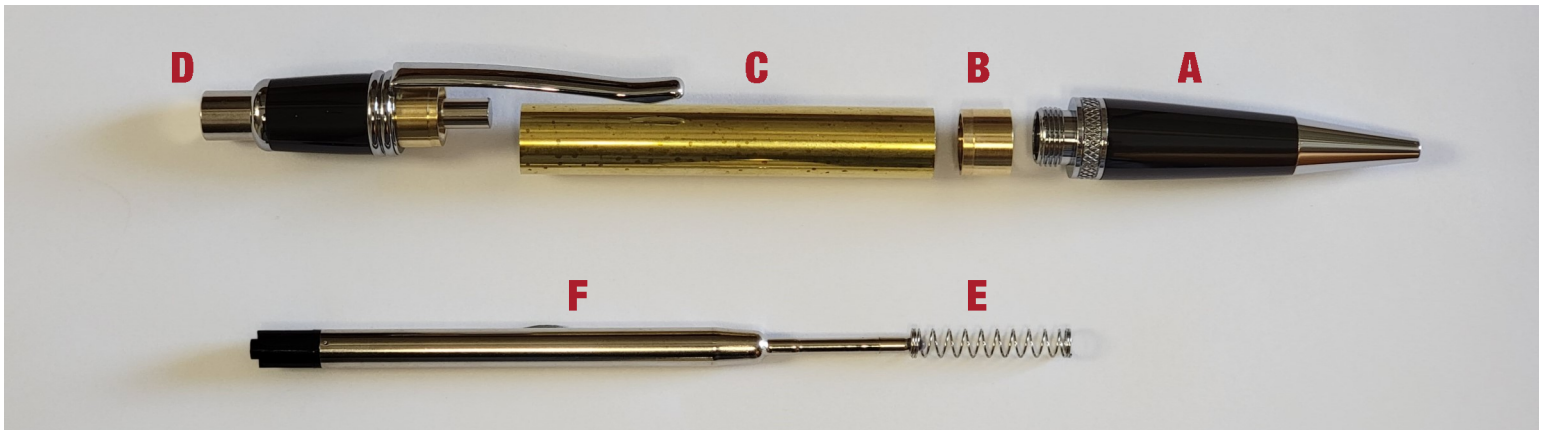
Turning & Finishing the Blanks:

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.

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2/11/202



Assembly:

- Press Threaded Insert (B) stepped end first into one end of Finished Blank (C).
- Next press Click Assembly (D) into other end of Finished Blank (C).
- Install Spring (E) onto Ink Refill (F) and insert into open end of Finished Blank (C).
- Finish assembly by threading Nib (A) into Threaded Insert (B).