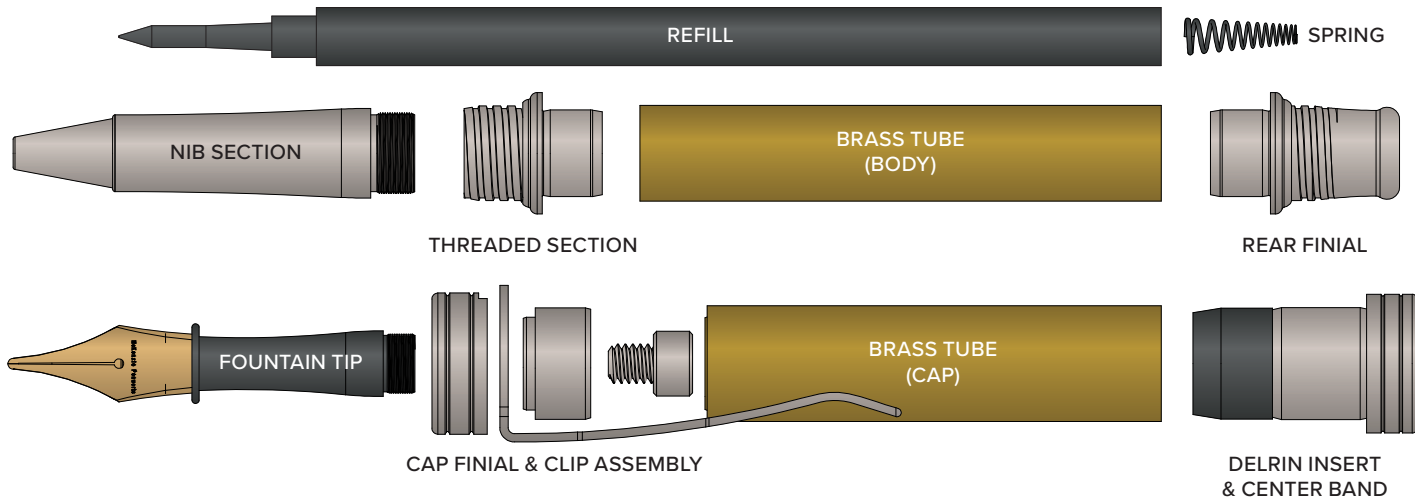


DESIRE PEN KIT - ASSEMBLY INSTRUCTIONS

- 1: Cut blank to proper lengths before drilling. This kit uses 10.5mm (body) and 12.5mm (cap) drill bits.
- 2: Glue in brass tubes. We recommend using epoxy for best results.
- 3: Carefully sand or trim blanks flush with brass tube. Do not trim too far into the brass.
- 4: Using a mandrel or centers, turn the blanks to the diameter of the bushings.
- 5: After finishing/polishing the turned blank, carefully press the rear finial into the body tube. Then press the threaded section into the other end of the body tube.
- 6: Prepare the cap finial/clip assembly by putting the clip between the cap finial and the press in section. Screw the pieces together. Use a dab of blue loctite (NOT RED!) to keep it tight over time.
- 7: Press the clip assembly into the cap.
- 8: Insert the threaded Delrin piece into the center band. Carefully press the center band into the bottom of the cap.



- 9: Drop the spring into the open end of the body, insert refill, and screw the section onto the body to complete the pen.

*Required Drill Bits: 10.5mm, 12.5mm

*Requires 5/32 hex key

*Bushing diameters: Large .588", Small .498"

