



Sierra Super Button Click Ballpoint



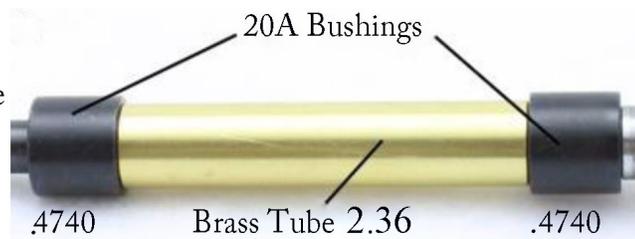
KIT REQUIREMENTS- Mandrel Shaft A, 27/64 Drill Bit, 20A Bushings

Prepping Your Blanks

1. Only one blank is required for the Sierra Super Button Click Pen Kit, cut your blank about a 1/4" longer than the brass tube.
2. Using the 27/64 bit drill lengthwise through the center of your blank.
3. Scuff up your brass tube with sandpaper.
4. Using Stick Fast 2 part epoxy, mix according to instructions, apply epoxy inside the blank using a toothpick or q-tip then apply a small amount on the brass tube. Give your brass tube a twist as you insert it into the blank, this will allow the glue to fill in around the tube.
5. Clean out any excess glue with a q-tip. The remainder can be cleaned out after the glue has dried. Set your blank aside to dry, a 5 min epoxy should take about an hour.
6. After your glue has dried, square the ends. We recommend the Ultra Shear Pen Mill or you can use a disc sander, just until you see the bright brass tube, **do not remove too much.**

Turning your Blanks

Assemble the blank on your mandrel as shown. Both bushings are the same O.D.



1. Tighten your blank setup down on your mandrel. This will depend on your setup.
2. Turn the blank down to the desired shape. Do not turn your blank completely flush with the bushings. You will still need to sand and finish in the next few steps.
3. After turning, sand the surface of your blank in progressive steps, for wood- 180,220, 360,400,600 and 800. For acrylics, wet sand, 180,220,360,400,60,800, then use micro mesh from 1500 grit to 12000 grit.
4. Apply the finish of your choice and remove for assembly.

Assembling the pen

1. Press threaded insert into one end of finished barrel.
2. Press Click Assembly into other end of finished barrel.
3. Slide spring into refill and insert into finished barrel.
4. Thread on nib.

