



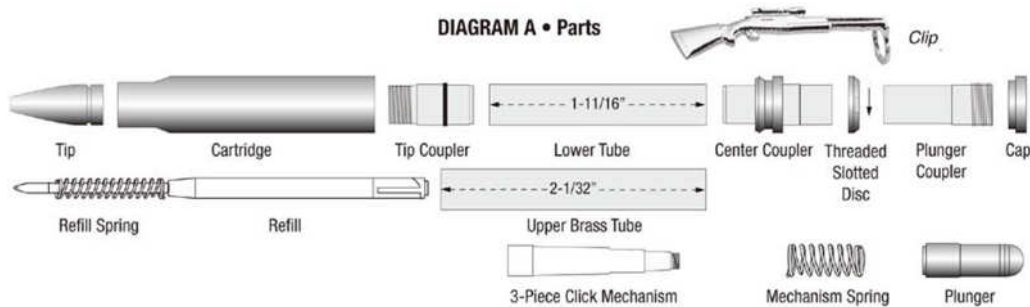
### Assembly instruction for Click Bullet Pen Kit

#### Required Accessories

- 7mm Pen Mandrel Kit
- 5/16" Colt Drill Bit
- PCBKIT Bushing Kit Click Bullet Pen
- PBTk04 Pen Blank Trimming Tool Kit
- Pen Mandrel Support
- 2 Part Epoxy Glue or Instacure Glue (Cyanoacrylate)



PCBKIT Bushing Kit



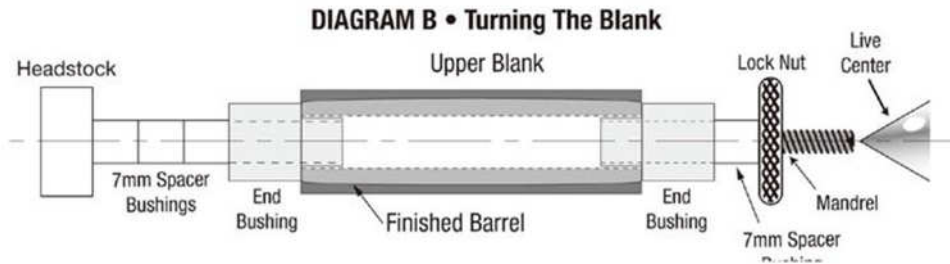
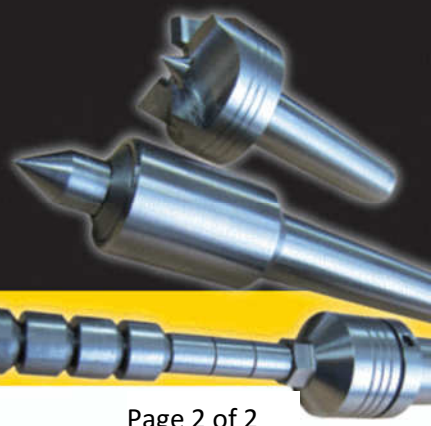
#### Preparing the Blank

- Cut 5/8" square blank to the size of the Upper Brass Tube. Add 1/16" to each end for squaring off.
- Drill a 5/16" hole through the centre of the blank.
- Apply glue to the tube and insert it into the blank with a twisting motion to spread the glue evenly.
- Centre the tube within the blank and allow to dry.
- Use a barrel trimmer to square the ends of the blank to the brass tube

#### Turning the Blank

- Place spacer bushings on the mandrel. Place one end bushing on, followed by the prepared blank.
- Assemble the second end bushing. Follow with additional spacer bushings as needed.
- Thread the lock nut hand tight onto the mandrel. Do not overtighten, it could damage the mandrel. For best results use the Pen Mandrel Support.
- Bring tailstock snug to the mandrel and lock it into place. Tighten the lock nut for turning.
- Using sharp tools, turn the blank down and sand it to the size of the end bushings.
- Finish the blank with your choice of polish.

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### Assembly

#### Line up the pen parts according to DIAGRAM C.

- Insert the clip assembly into the barrel, press in.
- Insert the 3-piece mechanism, threaded end in first, into the opposite end of the barrel.
- Press the cartridge assembly into the opposite end of the barrel.
- Unscrew the tip off of the front end of the cartridge assembly.
- Insert the refill spring over the refill end.
- Insert the refill, black end in first into the opening at the tip, screw the tip back on.
- Drop the plunger spring into the opening at the clip end, follow with the plunger, and screw in.
- The pen is ready to operate by clicking on the plunger to extract or retract the refill tip

**DIAGRAM C • Assembly**

