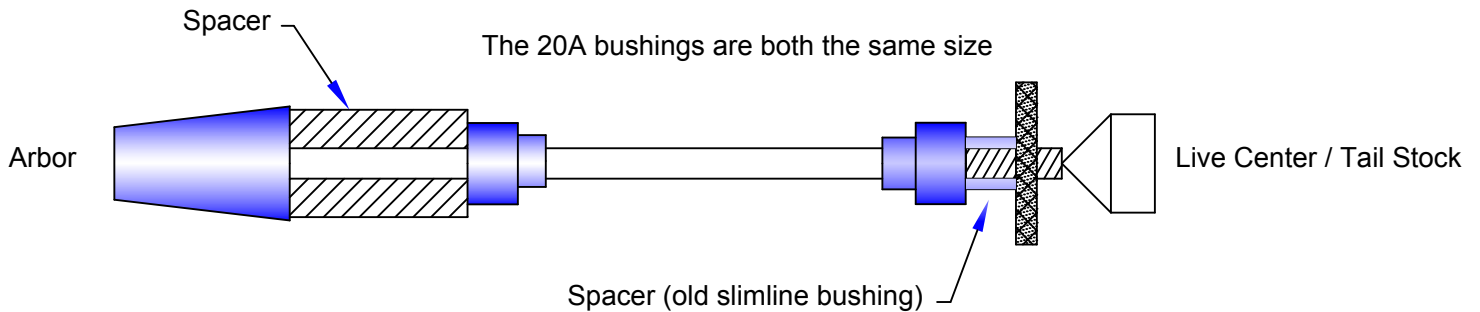


## Instructions for the Button Click Sierra Pencil



Bushing: 20A

Drill needed: 27/64"

Blank size: 3/4" x 3/4" x 1 7/8" long

1. We suggest that you use a spacer, drilled with a 1/4" hole, when using a standard length pen mandrel. Disregard this suggestion when using an adjustable length pen mandrel. Since the Sierra is a single-barrelled pen, the spacer fills the extra space not used on a standard mandrel. The spacer can be made from any solid material including wood.
2. With the mandrel installed in the lathe, mount the spacer, bushing, the pen blank, bushing, spacer and the threaded brass thumb nut on to the mandrel. Lightly tighten the brass thumb nut. Carefully slide the tail stock, with a 60° live center installed, up to the concave center of the mandrel shaft and secure. DO NOT over tighten or apply excessive force to the mandrel as damage may result! DO NOT over tighten the brass thumb nut as this can cause the mandrel to bend and, as a consequence, your pens may come out oval.
3. Turn the pen blank to the desired shape using the bushings as a guide. The Sierra pen blanks are generally turned 'bushing to bushing' (no taper). Sand the blank to the desired grit and then apply your choice of finish.
4. Assembly:
  - A. Press fit the CAP / CLIP assembly into one end of the brass tube / pen blank.
  - B. Insert the BRASS THREADED INSERT, shoulder end first, into the other end of the brass tube / pen blank. Ensure that the BRASS THREADED INSERT fits flush with the end of the brass tube.
  - C. Insert the PENCIL MECHANISM (button end first) into and through the CAP / CLIP Assembly. Then screw the NIB BODY into the BRASS THREADED INSERT.
  - D. Slide the NIB over the threaded end of the PENCIL MECHANISM and tighten.

