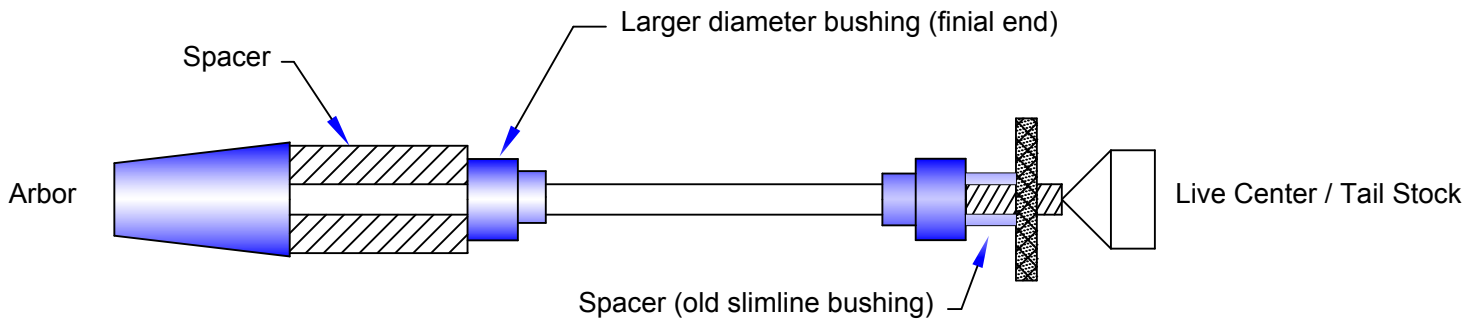


Instructions for the Sierra Vista Circuit Board Pen



Pen mandrel required: 'A' (standard 7mm mandrel) Bushings: 70A (smaller diameter bushing: nib end)

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 (refer to the attached Circuit Board Instruction Sheet for turning instructions). Sand the blank to the desired grit and polish like any acrylic pen blank. Sharp tools are an absolute necessity. 99% of all blank failures are a result of dull or improperly sharpened tools. We do not replace damaged and/or destroyed circuit board pen blanks nor do we have spares. Caution is urged when working with these blanks.
4. Assembly:
 - A. Press fit the CAP / CLIP assembly into one end of the brass tube / pen blank.
 - B. Insert the REFILL into the NIB ASSEMBLY making sure that the SPRING is in place.
 - C. Screw the TWIST MECHANISM over the REFILL and into the NIB ASSEMBLY.
 - D. Slide the BLANK / FINIAL / CLIP ASSEMBLY over the TWIST MECHANISM. This is a single twist pen.

