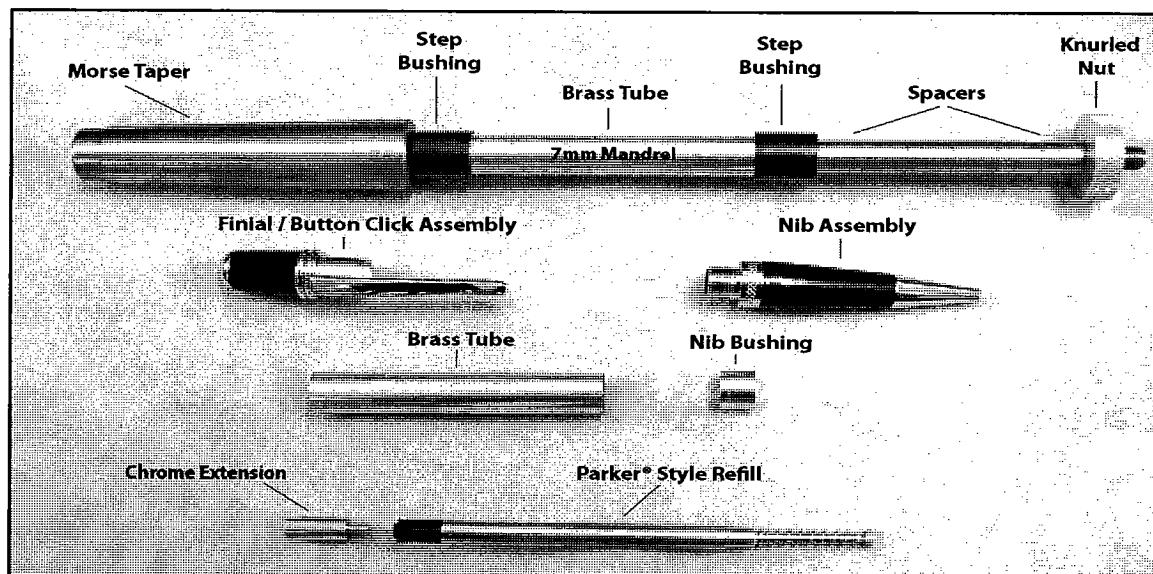


**Figure 1  
Mandrel Setup**

**Figure 2  
Pen Parts**



**Materials:**

- 1) Button Click Sierra Pen  
**1465 or 1466**
- 2) Pen Blank  
Recommended Size  
3/4 x 3/4 x 5"
- 3) 27/64" drill bit **0152**
- 4) Maxi-cure Extra-thick  
CA **0184** or epoxy **0189**
- 5) 5/8" barrel facing tool  
**0331** with pilot **0333** or  
**0335**.
- 6) 7mm mandrel and  
bushing set **0303**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP™ combo  
**0109** or HUT Crystal  
Coat™ **0104**

**Blank Preparation:**

- 1) Cut blank approximately  
1/4" longer than its respec-  
tive tube.
- 2) Drill blank with a 27/64"  
drill bit.
- 3) Glue tube into blank.
- 4) When glue is cured,  
square ends with barrel fac-  
ing tool.

**Turning:**

- 1) **See Figure 1** (Mandrel  
Setup). Turn on a 7mm  
mandrel with bushing set  
**0303**. Use spacers to fill  
out mandrel. (*Spacers are  
not included in kit*).
- 2) Turn blank down to  
bushings.
- 3) Sand and finish with  
HUT PPP combo. Finish  
with a two-step process;  
first apply PPP Satin  
Gloss™, then PPP High  
Gloss™ for a perfect pen  
polish or use HUT Crystal  
Coat™.

**Assembly:**

- 1) **See Figure 2** (Pen  
Parts). Press the Nib  
Bushing into the Nib end of  
the Barrel.
- 2) Using a bushing over the  
Button Clicker (this will pro-  
tect the button clicker while  
pressing it into the blank),  
press the Finial /Button  
Click Assembly into the  
other end of the Barrel.
- 3) Insert the Stud end of  
the Chrome Extension into  
the black portion of the  
Parker® style refill.
- 4) Insert the writing end of  
the refill into the Nib  
Assembly.
- 5) Screw the Nib Assembly  
into the Nib Bushing.

NOTE: An extra Chrome  
Extension is included in the  
kit.

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