

Fig. 1

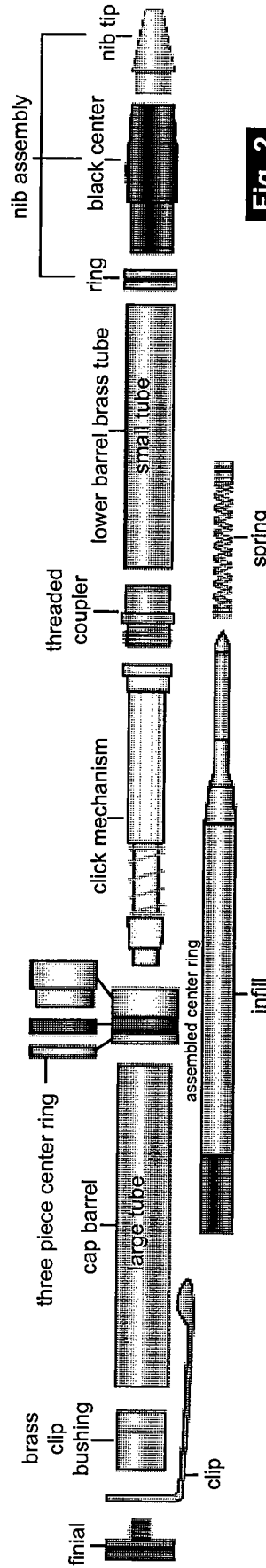
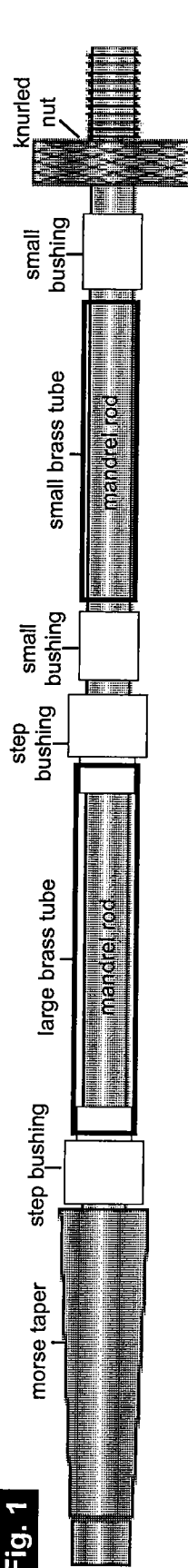


Fig. 2

Materials:

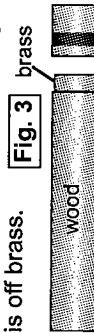
- 1) Ameroclassic Click Pen kit **526**
- 2) Pen blank, minimum size 5/8 x 5/8 x 5"
- 3) 21/64" drill bit **174** & 27/64" drill bit **152**
- 4) Maxi-cure Extra-thick CA **184**, epoxy **189**, or polyurethane **196**
- 5) 5/8" barrel facing tool **331** with pilots **334** & **335**
- 6) Ameroclassic mandrel and bushing set **325**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP combo **109**

Preparation:

- 1) Cut blank in two pieces, each approximately 1/4" longer than its respective tube.
- 2) Drill large (cap) blank with a 27/64" or 11 mm drill bit. Drill short (lower barrel) blank with a 21/64" drill bit.
- 3) Glue tubes into blanks.
- 4) When glue is cured, square ends with barrel facing tool. Note: No pilot is available for the large cap tube. A 335 rollerball pilot is acceptable.

Turning:

- 1) Turn on an Ameroclassic mandrel with bushing set **325**. Arrange bushings and tubes as shown. (Fig. 1)
- 2) Turn wood down to bushings. The lower barrel in particular must be turned flush with small bushings. Barrels should have straight, Ameroclassic profile.
- 3) Using a parting tool, remove 3/16" of material down to brass tube on the center ring end of cap. (Fig. 3) Make sure all glue is off brass.



- 4) Sand and finish with HUT PPP combo.

Assembly:

- 1) Lower barrel assembly: Push fit nib tip into black center. Slide ring onto black center. Push fit into one end of lower barrel tube. Press non-threaded end of threaded coupler into open end of lower barrel.
- 2) Place spring on infill and insert in lower barrel. Place click mechanism over infill and screw onto threaded coupler.
- 3) Cap assembly: Assemble three-piece center ring. Press center ring over exposed portion (Fig. 3) of brass tube on cap barrel, flat end first. Press brass clip bushing, stud end first, into clip end of cap barrel until flush with wood.
- 4) Place cap (without clip) over assembled lower barrel. Insert finial through hole in clip and screw into top of click mechanism. Line up grain if necessary. To avoid possible clip rotation, place a small drop of glue between pen cap and clip.



7-30-04