

### Required Accessories

7mm Pen Mandrel  
8mm Drill Bit  
Cyanoacrylate Glue

Click Bullet Bushes {2 piece set}  
Delux Trimming Kit  
Mandrel Saver

### Preparing the Blank

Cut a 16mm square blank to the length of the longer tube, add 2mm for squaring of if need be. {the short tube does not require any turning}

Drill a 8mm hole through the centre of the blank.

Spread glue in the blank and over the tube.

When the glue dries square of both ends of the blank with your pen mill.

### Turning the blank

Place the bushes and prepared blank on the mandrel and take up the extra room with bushes and your mandrel saver.

Turn the blank down to size of the bushes being carefull not to touch the bushes.

Sand and finish with a suitable finish.

### Assembly

Line up the parts according to the top diagram

#### Click Coupler Assembly

Push the click coupler into the threaded coupler, now have a look at the recessed tube and you will see one end clear and the other end with an internal lip. Push the complete coupler into the tube from the open end, {you may have to use the refill to hold in position to help with the next part}. With the threaded part protruding through the tube place the large spring over the stem then screw the plunger part onto the shaft.

#### Pen Assembly

Press the tip coupler {this may be already screwed into the tip, unscrew} into the lower tube, there is a light indent about half way along the tip coupler, only push the tip coupler on this far no further. Slide this assembly, threaded end first through the rear of the cartridge to expose the threads.

Screw the tip onto the tip coupler. Hand tighten to the end.

Assemble the centre coupler next. The centre coupler has 2 distinct ends, one with a short step and the other end a longer step. The centre coupler get pushed onto the short step end and must only go on 3/16" or 4.5mm no further. Make sure the centre coupler is fitted the right way around. Now insert the short end into the lower tube till the fitting is flush with the bullet body, do not over press as you do not want the coupler to move.

#### Long tube assembly

Push the assembled click mechanism into one end of the turned and finished tube.

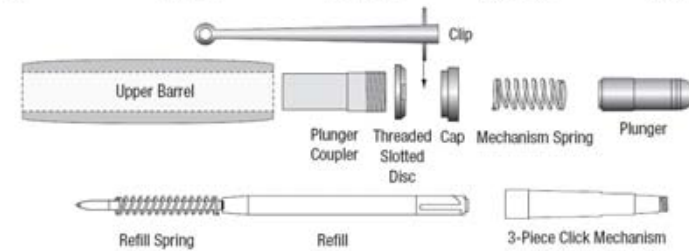
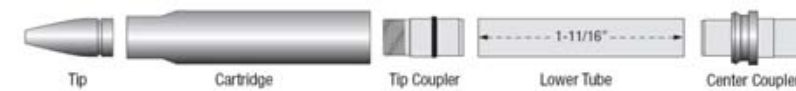
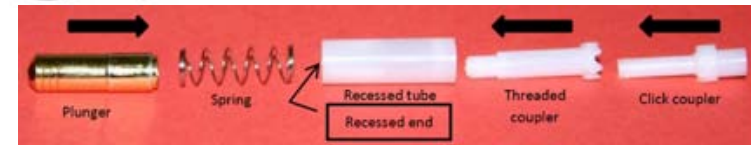
At the other end push in the plunger coupler up to the thread but no further.

Align the pen clip in the notch on the slotted disc and place over the exposed thread. Screw on the threaded cap.

Push the completed assembly onto the centre coupler and you should now have a complete pen.

Unscrew the Tip remove the wax seal and push the small spring over the refill and push the refill into the assembled pen and screw the tip back on, The pen is ready to use.

## BULLET STYLE CLICK PEN



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