

Preparation

- 1/ Only 1 blank is required for this pen. Cut this blank slightly longer than the brass tube.
- 2/ Drill the blank through the centre with the 27/64" drill bit.
- 3/ Scuff the brass tube with sandpaper to remove any oxidation so the glue will bond better.
- 4/ Insert the glued tube with a twisting motion into the drilled blank. Leave overnight for the glue to bond with the tube and timber .
- 5/ Using your Pen mill trim the ends of the blank so they are square with the tube. BE CERTAIN that all dried glue is removed from inside the tubes, failure to do so may affect the assembly of the pen.

Turning

- 6/ Place the blank on the mandrel with the Sierra bushes in each end, use spacers or the adjustable mandrel to ensure a tight fit.
- 7/ Turn the blank to the top diameter of the bushes.
- 8/ Sand to the desired finish, these are a fine pen so deserve a fine finish, then apply your choice of finish such as friction polish or shellac.

Assembly

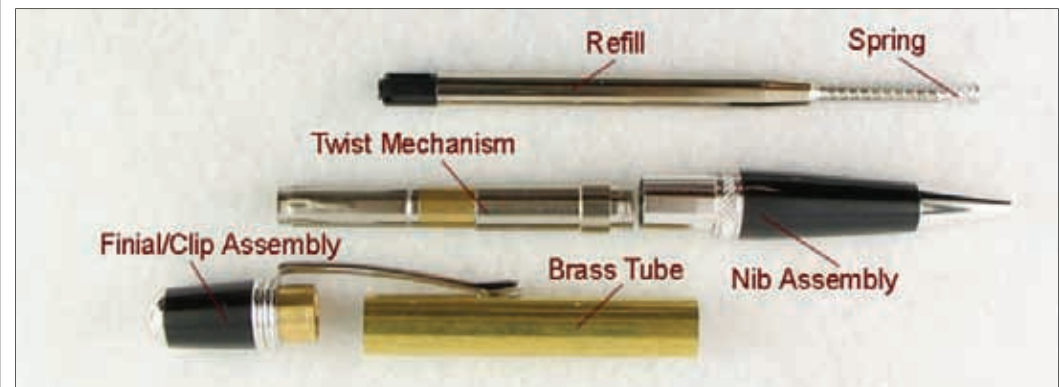
- 9/ Press the clip and cap assembly into the tube.
- 10/ Place the refill and spring into the nib assembly
- 11/ Screw the twist mechanism over the refill and into the tip.
- 12/ Slide the tube over the twist mechanism, Your pen is now finished

SIERRA PEN



REQUIRED ACCESSORIES:

- Pen Mandrel
- 2 Piece Bush Set
- 27/64" Drill Bit
- Delux Pen Blank Squaring Kit
- Cyanocrylate Glue
- Pen Drill Centring Vice
- Pen Assembly Press



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