

30 Caliber Bullet Express Pen
Instructions

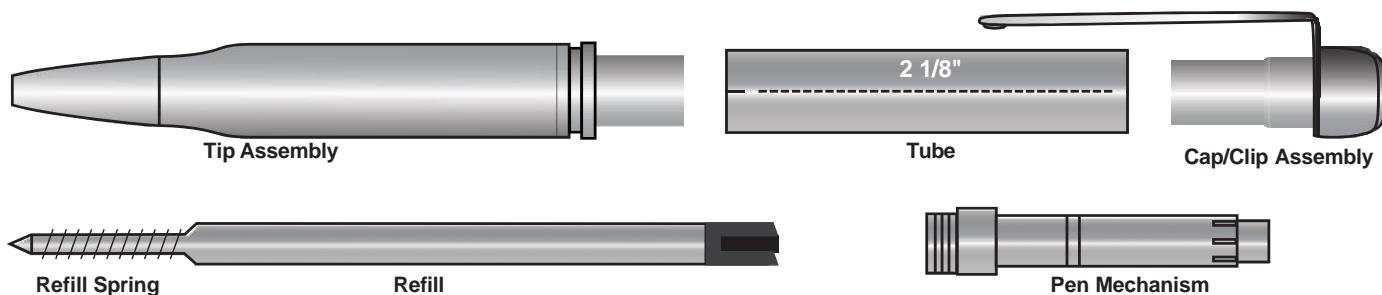
Kit Features

- Smooth twist mechanism
- Overall length: 5-1/2"
- Uses smooth-writing Parker™ style refill (See Below)
- WG50001 Standard Parker Style Refills / Black 5pk
- WG50004 Parker Style Gel Refills Black (5-pack)
- WG50005 Parker Style Gel Refills Blue (5-pack)
- WG50006 Parker Style Gel Refills Red (5-pack)
- WG50007 Parker Style Premium Roller Ball 5Pk

Required Accessories & Materials

- 7mm mandrel-pc. Express bushing set (**WG60029**)
- Drill bit – 3/8" (**AF00390** Or **WS22597**)
- 3/8" barrel trimmer or belt sander to square the ends of the blanks to the tubes (**W9100-344** Paired with **w9078**)
- Glue (We recommend the thick CA glue—**PA00030**)
- Sanding and finishing supplies
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Diagram A - Parts and Assembly



BLANK PREPARATION

The Express pen has a single tube measuring 2 1/8". **Cut** your blank approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. Use a medium drill speed to **drill** the blank. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blank, **sand** the exterior of the brass tube to roughen its surface and use CA **glue** to glue the tube inside the blank. Sand or barrel trim to **square** the ends of the blank.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. The Express pen's upper and lower bushings both have an outside diameter of .467" (see Diagram B).

Turn the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

ASSEMBLY

(Line up finished parts according to Diagram A) To avoid damage to components when assembling, use a pen press or a vise with covered jaws

1. Slide the spring onto the refill and place inside the tip assembly. Screw the pen mechanism into the tip assembly.
2. Press clip assembly into the upper end of the barrel.
3. Push pen barrel with clip/cap assembly onto completed lower assembly.
4. The pen is now ready to operate; twist clockwise to open.

Diagram B - Bushings

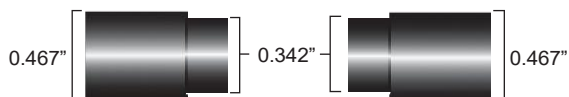


Diagram C - Turning the Pen

