



Patriot Bullet Pen Kit with Patriot Clip - Assembly Instructions

A. Cutting Blanks:

Cut blanks length of the brass plus 1/8" extra on each side to allow for trimming. Starting with a solid blank free of checks or other defects will help ensure good results and enhance safety. Use caution when using smaller diameter stock.

B. Drilling:

Drill the blanks using a drill press and clamp or other device suitable for securing the blank in an upright position to ensure stability throughout the drilling process. Ensure the blank is a true 90 degrees to the drill press table. Drill a 25/64 hole through the center of each blank.

C. Glue the Blanks:

Lightly sand the exterior of each brass tube with fine sandpaper to ensure glue adhesion. Using a small cork or potato slice will help keep glue out of the inside of each tube during the process, which will improve the ease at which components fit together. Using a good quality wood glue, polyurethane glue or Cyanoacrylate glue, coat the inside of the blank and then the brass tube with your glue of choice.

Insert the tube fully into the blank, cork end first. Expel the cork and clean up any remaining excess glue. Wait the required wait time for the selected glue as determined by the manufacturer.

D. Dress the Ends:

Using a belt sander or barrel trimmer, true the ends to an accurate 90 degrees and remove any excess wood until the brass is just revealed. Removing too much brass may hinder future assembly.



E. Turning the Blanks:

Slide the bushing and the pen blanks onto the mandrel in the order required. The Patriot Bullet Pen only has one barrel and two bushings, so a block spacer or additional bushings will be required to fill in the gap so that the knurled knob on the mandrel will tighten on the single barrel assembly. A WoodPenPro Adjustable Mandrel will also work effectively for this application without the need of spacers.

After aligning the bushings and blanks, thread the lock nut and hand tighten. The turning unit should now be secure on the mandrel. Slide the tail stock over and set in place next to the mandrel, ensuring there is enough pressure to secure the mandrel (do not over tighten or the mandrel and live center could be damaged). Turn the blank down to the approximate diameter of the bushings and then sand to the desired finished diameter.

F. Sanding:

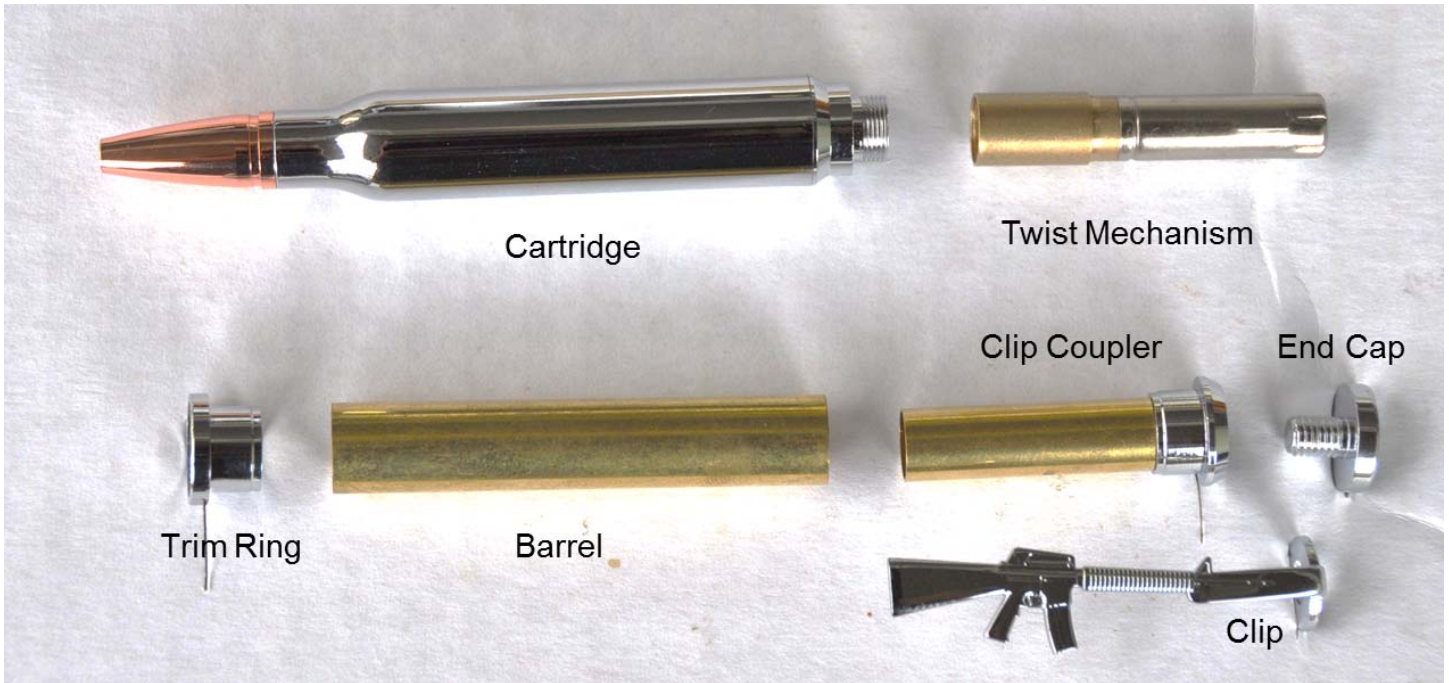
Once the pen is turned to approximately 1/16" of the final diameter (more if wood is brittle or hard to turn), switch to sand paper and sand to the diameter of the bushings. Start with course 150 to 220 grit and work consecutively to finer diameter sandpaper, 400 to 600 grit or finer.

G. Finishing:

Finish with your desired wax or friction polish. If using a polyurethane finish, ensure not to weld the bushings to the blanks.

H. Assembly:

Use a clamp or vice with wooden jaws to prevent damage to the pen components. Excess pressure on the components could cause damage, so ensure all tubes are free of glue or any burs. A pen press is especially useful for pen assembly.



1. The Patriot Bullet Pen body and transmission coupler are already assembled, so insert the spring and refill in the pen body then screw on the twist mechanism.
2. Press the pen clip coupler onto one end of the finished barrel and secure clip in place with the end cap.
3. Press the Trim Ring onto the opposite side of the barrel.
4. Slide the assembled halves together, then press together by hand until fully seated.

Congratulations, you have just completed the Patriot Bullet Pen!

If you have any problems, feel free to contact me at your convenience.