



Assembling the Prokraft Bare Pen Kit

**Drill size for tube = 10.7mm (Sie DRL)
Bushing Set = SieBSH**

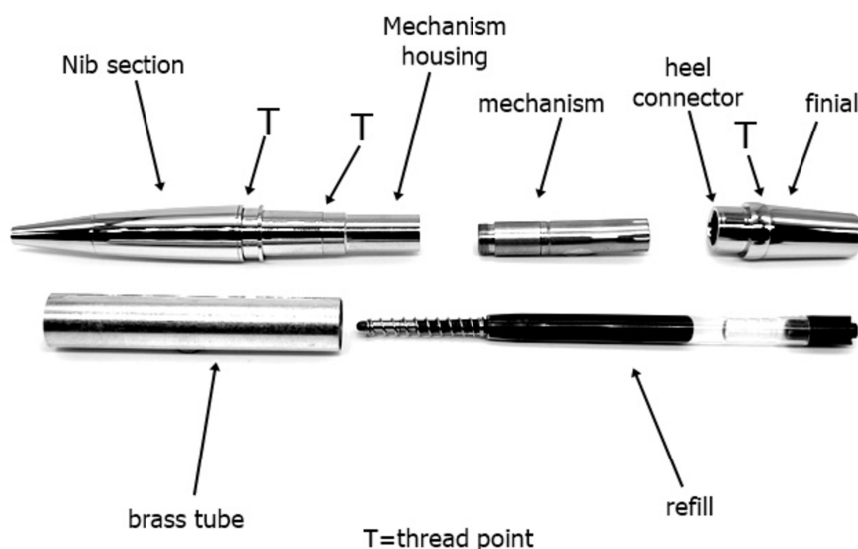
Please read this guide fully before starting

What is a bare pen kit?

The Prokraft bare kit is based on a Serea/Siera kit but it does not have a detail ring and it does not have a pocket clip. Those 2 items are available separately and enable you to personalise the final look of your finished pen.

You will require a blank at least 56mm long drilled out to 10.7mm. Once the brass tube has been glued into the drilled blank it can be turned using a bushing set either on a mandrel or between centres as you prefer.

Once you have finished your blank the pen kit can be assembled as follows:



1] The tube will push fit on the heel connector only – it fits loose on the nib section because this is the point the pen twists to operate the mechanism

2] If you are fitting a pocket clip (available separately) it can be used in 2 positions

a] fitted between the heel connector and the finished blank – this is a permanent fixed position.

b] the finial section unscrews from the heel connector and a pocket clip can be positioned between these 2 parts. This moves the clip back approx 5mm and allows you to change the clip at any time in the future should you want to.

3] If you are using a detail ring (available separately) the nib section can be undone and one of your choice of rings can be added or changed at any time to the kit – the thread point is detailed on the above picture and the refill is also changed this way.

For Final Assembly:

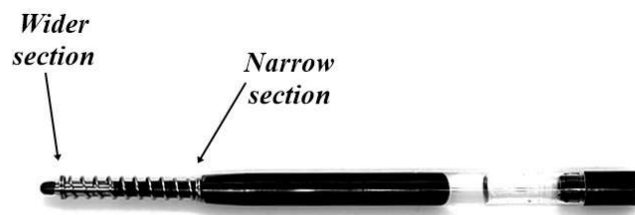
4] take the nib section and insert the refill inside then screw on the mechanism

5] Once the blank and heel of the pen are fitted together this section slips over the mechanism with the blank pushing neatly up to the nib section.

Your pen is now finished and ready for use.

Important note about the refill & spring:

The refill spring is tapered and the narrower end must be pushed right up to the wide part of the refill body. This can be done by pushing and twisting the spring. The wider end of the spring should be just below the writing tip of the refill. Incorrect fitting can cause a stiff mechanism due to excess pressure. A Parker style refill can also be used in these kits.



Please note this kit is NOT compatible with a pencil converter.