

After printing, the lower part needs to be drilled out using a #44 drill bit (.086") and the top using a #19 (.166"). You can use the closest size drill bit that you have as long as it is larger than those listed above. Use PLA filament and be careful when drilling so as not let the drill bit contact your hand as it exits the other end of the part! Obtain the required spring from a Pilot G2 Retractable Premium Gel Ink Roller Ball Pen, Ultra Fine Point.

You want gel pens that look like this:



You should be able to find them on Amazon sold in large quantities for a very cheap price.