Marker Dimensions

Marker length: 0.400 in.
Marker diameter: 0.130 in.

Marker materials for Chrysalis I and II

Delrin rods.
Stainless steel pins: $\frac{1}{2}$ in. × $\frac{1}{16}$ in. MSC #67599605.

1. Turn a Delrin rod to a diameter of 0.130 in.

2. Saw off the excess piece on one end.
3. Saw off the excess piece on the other end.

4. Mount the marker in a collet chuck and face it on both ends.

5. Shorten the marker to a length of 0.400 in.
6. Center drill the marker.

7. Drill a $\frac{1}{4}$-in.-deep hole with a 0.059 in. drill bit.

8. Mount a $\frac{1}{2}$ in. $\times \frac{1}{16}$ in. stainless steel pin in the drill chuck and press fit it into the marker.
9. Mount the stainless steel pin in a collet chuck and round over the top end of the marker with a fine file. Sand the marker with wet/dry 600- and 1000-grit paper, and polish with a buffing wheel.

10. To seat the marker in a Delrin nut, drill a shallow flat-bottom hole with a \( \frac{1}{8} \) in. brad-point drill bit.

11. In the center of the hole, drill a \( \frac{1}{4} \)-in.-deep hole with a 0.059 in. drill bit. Sand and polish the top of the nut.
12. Mount the marker in a collet chuck and press fit it into the nut.