

Everyday Classic Click Pen Kit

Kit Features:

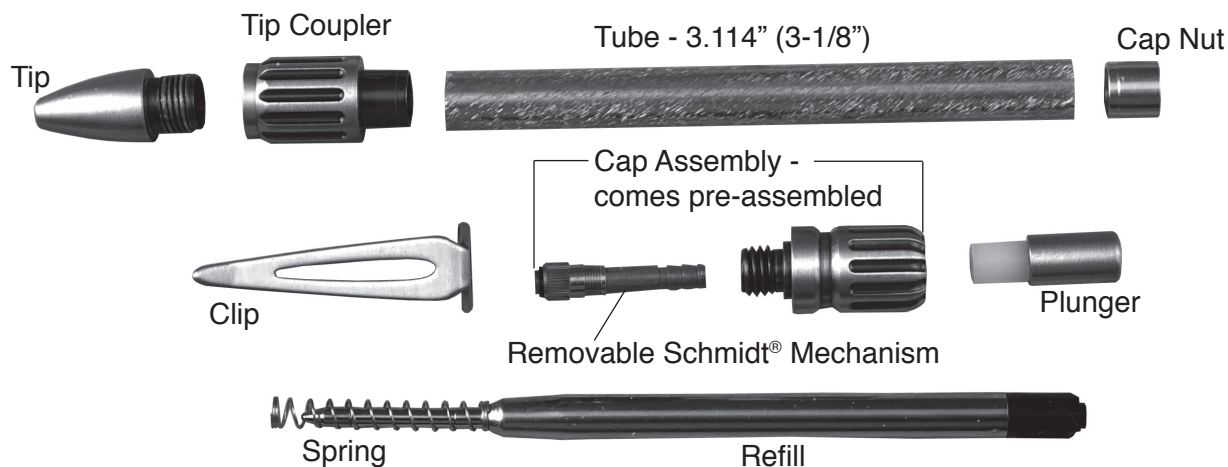
- Classic Fluted Design
- Reliable Schmidt® Metal Click Mechanism easy to remove and replace
- Easy to Turn with a Straight Tube
- Thin styling only requires a 5/8" blank
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-5/16"
- Uses Parker Style Refill: #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 8MM #PK-8MMSG for Plastic, #PKPARK-8MM for wood
- Bushing Set (2 pc): #PKSPCL3BU
- Barrel Trimming set: #PKTRIM8 or 8MM sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 3-3/16" L

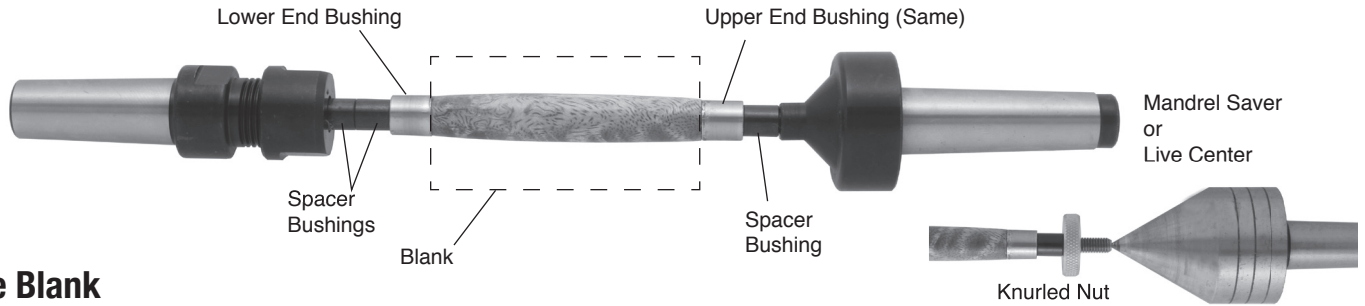


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 8MM hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use an 8MM barrel trimmer, or a pen blank squaring jig with an 8MM sleeve on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with the operation of the mechanism and assembly. Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANKS**Turning the Blank**

- Mount the bushings and blanks according to diagram B.
 - Thread on the knurled nut and hand tighten to hold all components in place.
 - Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
 - Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel).
 - Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
 - Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
 - Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.
- Refer to polish instructions.

Assembly

- Press Tip Coupler into either end of Barrel.
- Press Cap Nut into opposite end. Note that Cap Nut has a recess on one side. This side must go in first.
- Push Plunger into Opening at the top of the cap onto the barbed stem of Click Mechanism.
- To make sure Plunger is fully seated, place bottom of mechanism against a hard surface and push plunger down until it no longer moves (this can be done carefully in pen press if needed). Action may feel slightly rough if plunger is not fully seated.
- Thread Cap Assembly through the Clip into Cap Nut.
- Insert Refill through Tip Coupler and slide Spring over Refill shaft
- Thread tip over Refill and Spring.
- To change Refill, unscrew tip and replace. Be sure not to lose the spring when replacing refill.

Diagram C / Bushings #PKSPCL3BU