

SLIMLINE PRO EDC PEN KIT

Kit Features:

- Modernized, curved Profile.
- Reliable, metal click mechanism
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-7/16"

Required Accessories:

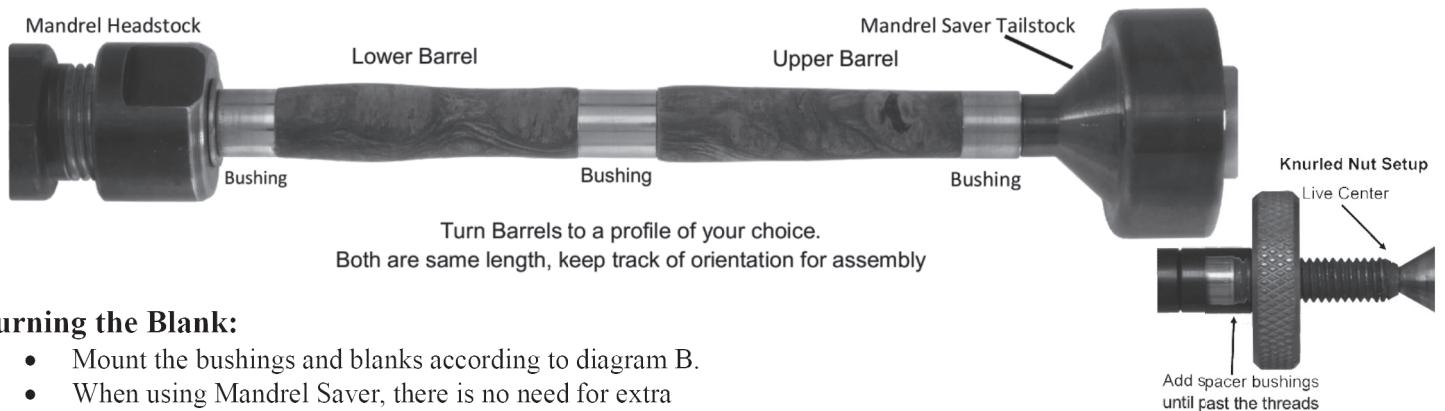
- 7mm Pen Mandrel
- Drill Bit: #PKPARK-8MM for Wood, #PK-8MMSG for Plastic
- Bushing Set(3pc): #PK-PENXXBU
- Barrel Trimming: #PKTRIM8 or 8mm sleeve from PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 4"L



Preparing the Blank:

- Cut blanks to the length of the tubes, adding 1/16" for squaring off.
- Both tubes are the same size. Mark ends to make sure to match them to each other on the lathe.
- 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.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten quill adjustment until blank and bushings are secure.
- If not using Mandrel Saver, add spacer bushings until some of the threads are covered and thread on the knurled nut, hand tightening against bushings to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple and locking the Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage mandrel shaft.
- 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 sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

Diagram C / Bushing #PKPENXXBU

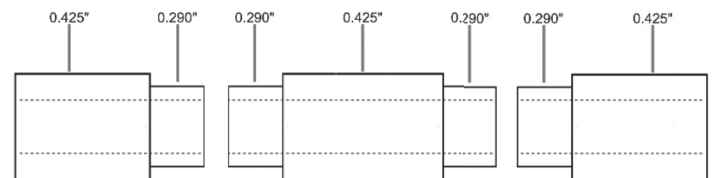
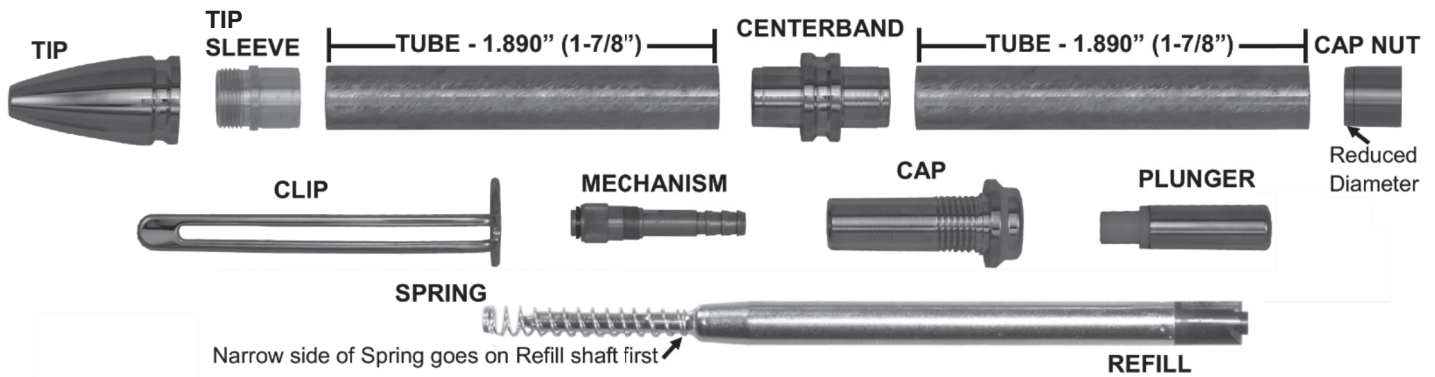


Diagram D / Parts Layout



Assembly:

- Screw Tip onto Tip Sleeve to prevent crushing the threads and press into open end of either Barrel. **WARNING! Never press directly onto the threads of the tip sleeve!**
- Press Centerband into opposite, open end of the same Barrel.
- Press second Barrel onto to remaining side of Centerband.
- Press Cap nut, reduced diameter first, into Upper end of second Barrel. There will be a slight line where the reduced diameter was machined. Failure to press in the right orientation will prevent Cap installation.
- Thread the Mechanism, barbed end first, into the bottom (smaller) end of the Cap.
- Place bottom of the mechanism on a hard surface, push the plunger into the top opening of the Cap until it is firmly locked onto the mechanism barbs.
- Slide Cap through the Clip and thread into the Cap Nut.
- Slide Spring onto Refill. The narrow side of the Spring should go on first and will grip the shaft of the refill.
- Unthread the Tip, insert Refill, and thread Tip back on.
- To extend and retract Refill, push down on the plunger.
- To Change Refill, unthread Tip. Remember to switch Spring onto the new Refill.

