

# Bolt Action Click Pencil Kit

## Kit Features:

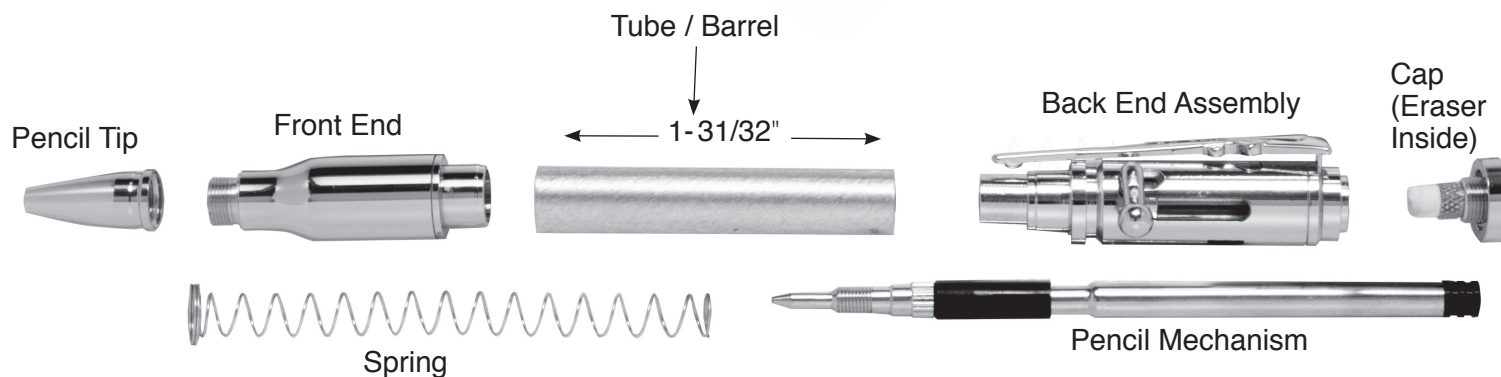
- Provides a companion pencil option for Bolt Action pens.
- Easy to turn with straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses durable .7mm lead
- Eraser included in cap - Replacement 10 pack PK-PCLE10
- Overall length: 5 <sup>3</sup>/<sub>8</sub>"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(2/ pc): #PKCP3000BU
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size: 5/8" X 2 1/4"

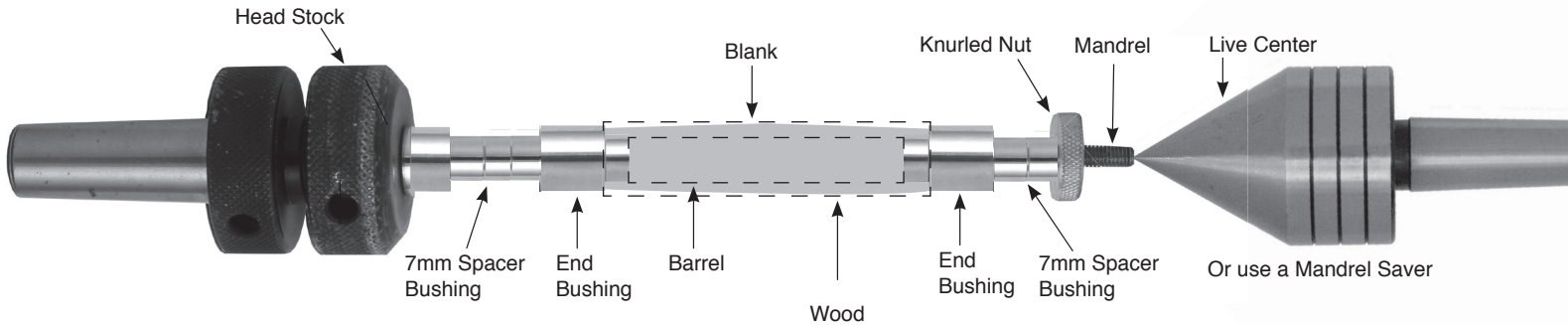


*DIAGRAM A / PARTS LAYOUT*



## Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
  - Drill 3/8" holes lengthwise through the blank.
  - Spread glue over the tube, insert 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 blank. Use a 3/8" barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (Do not trim beyond the length of the tube since this may interfere with 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.

**Pencil Assembly**

- Layout Finished parts according to diagram "A"
- Press the back end assembly into either end of the barrel.
- Slide the spring, narrow end in first through the opening at the opposite end of the barrel.
- Press the tip assembly into the opening at the barrel. (**Note: DO NOT Remove the pencil tip to press Front End. Press over the tip.**)
- Unscrew the tip and thread it onto the front of the pencil mechanism.
- Slide the mechanism (attached to tip) into the front opening; screw the tip onto the front end.
- To advance the lead, just click on the bolt once or twice. The bolt can be left in the small hook in the channel to allow for easy lead advancement while writing.
- To retract the lead, press the bolt down and push the lead back into the tip, then allow the bolt to retract fully.
- To reload with new lead, remove the mechanism and pull the black plug. Load with a maximum of five .7mm lead sticks.
- To use the eraser, unscrew and remove the upper cap to reach the eraser. Replace eraser with item # PK-PCLE10

**Diagram D****Bushings #PKCP3000BU**