

# Model #PKPARK-X Classic "Click" Ball Point Pen Kit

## Kit Features:

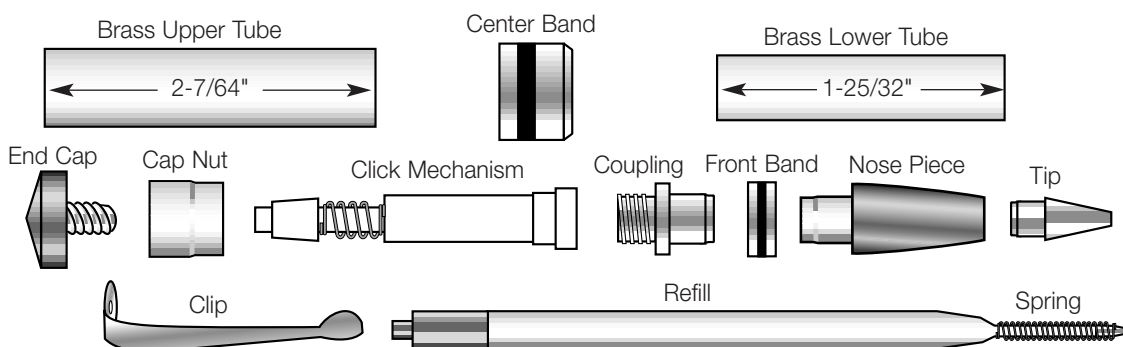
- Heavy 24 kt. gold plating with epoxy coating.
- Pen constructed to be similar in appearance to the classic "Parker" Pen design of the 1920's.
- Smooth operating "click" to extend or retract ball point.
- Uses Parker® type ball point refill.
- Overall length: 5 1/4".

## Required Accessories:

- 7mm long mandrel.
- Pen bushings set #PKPARK-BU2.
- 2 Drill Bits: #PKPARK-8mm and #PKPARK-11mm.
- 8mm Barrel Trimmer #PKTRIM8.
- 2 part epoxy glue or inst-cure (cyanoacrolate glue).
- Parting Tool

Note: Drawings not to scale

## Diagram A / Parts Layout



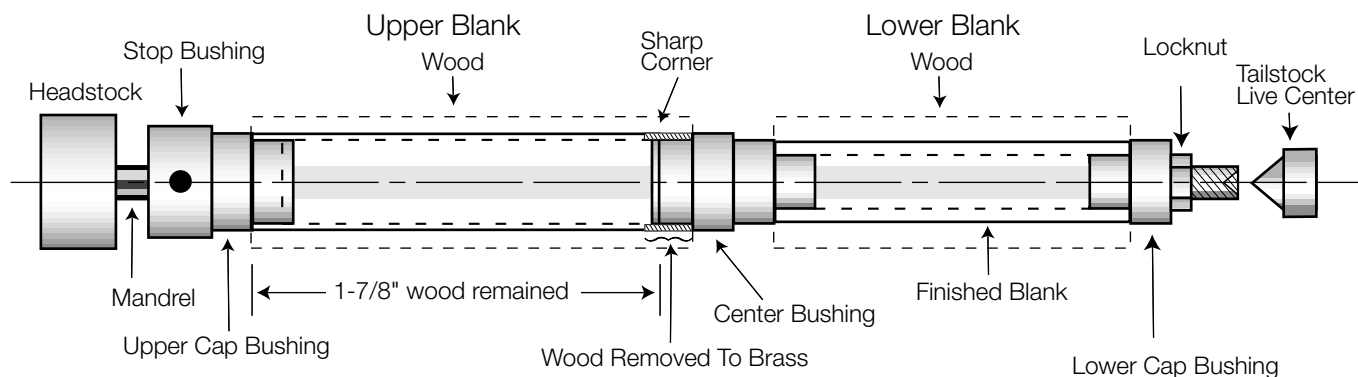
## Preparing the blanks:

- Cut 5/8" square blanks to the length of the brass tubes (add 1/16" for squaring off).
- Drill hole lengthwise through center of each blank. For upper blank use 11mm bit. For lower blank use 8mm bit.
- Spread glue over brass tubes. Insert each tube into proper blank with a twisting motion to spread the glue evenly

inside. Center each brass tube lengthwise in the wooden blank.

- When the glue dries, square ends of blanks. Use a 8mm barrel trimmer for lower blank and a belt/disc sander for the upper blank. Take the wood down flush to the brass tube at each end, making sure the wood ends are perpendicular to the tubes.

## Diagram B / Turning the Blanks



## Turning the blanks:

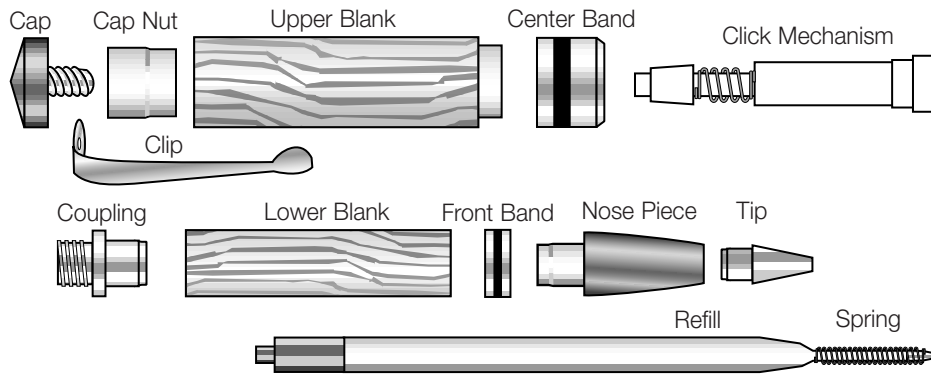
- First, place the stop bushing on the mandrel. Next, place the cap bushing onto the mandrel, then slide on the upper blank. Next, insert center bushing with the larger diameter next to the upper blank. Slide the lower blank onto the mandrel over the center bushing. Insert the tip bushing. Place locknut on next, hand tighten. Bring up the tailstock snug with the live center engaging the mandrel and live center. Do not overtighten tailstock, it could damage the mandrel. Tighten both the stop bushing and lock nut.
- Turn wood down flush with the bushings using lathe chisels and various grits of sandpaper (see note).

NOTE: Be sure to sand down the wood on the lower blank **flush with the bushing**. Otherwise, the lower blank may get jammed inside the upper tube when engaged.

Finished lower blank must fit inside upper blank. Test for clearance and fit before finishing.

- **Removing excess wood**- Mark 1-7/8" from the bushing on the upper blank (See diagram B). Use a parting tool to remove all the wood beyond the mark, down to the brass tube. Retain a sharp 90° corner at the end of the upper blank to assure a good fit for center band. When the wood is cut, finish blanks with varnish or wax as desired.

## Diagram C / Assembly



### Assembly:

- Line up finished parts according to diagram "C"
- To press parts, use a vise or a clamping instrument with wooden jaws. Press slowly with caution, keep the parts aligned to avoid cracking the wood or scratching the gold plating.

### Lower Blank

- Press tip into nose piece.
- Slide front band over nose piece, then press this assembly into lower blank.
- Press coupling into opposite side of lower blank leaving threaded portion exposed.
- Screw click mechanism flush over thread.

### Upper Blank

- Press cap nut, tapered end first into upper blank.
- Use a drop of glue on the exposed brass tenon, and slide center band (square end first) onto upper blank. Press together. Let dry. (Parts must be flush together with no gaps).
- Insert click mechanism inside upper blank until tip of click is visible through hole in cap nut.
- Insert cap screw into clip. Use drop of glue on the thread, and quickly screw into blank through cap nut (see note).

### Tips:

- Test the pen for free, smooth operation by sliding the lower blank into the upper blank. Push down to the maximum spring tension. It should slide smoothly in and out.
- To test click operation- Insert refill and spring into lower barrel. Push down to click. The refill point should extend or retract with each click.

NOTE: Do not allow the clip to spin around when tightening black cap to avoid scratches on wood.

To replace the refill, remove the upper barrel by turning it counter clockwise. Remove and replace the refill.

### Bushings (#PKPARK-BU2)

