

50 CAL. Flip Pen Kit

Kit Features:

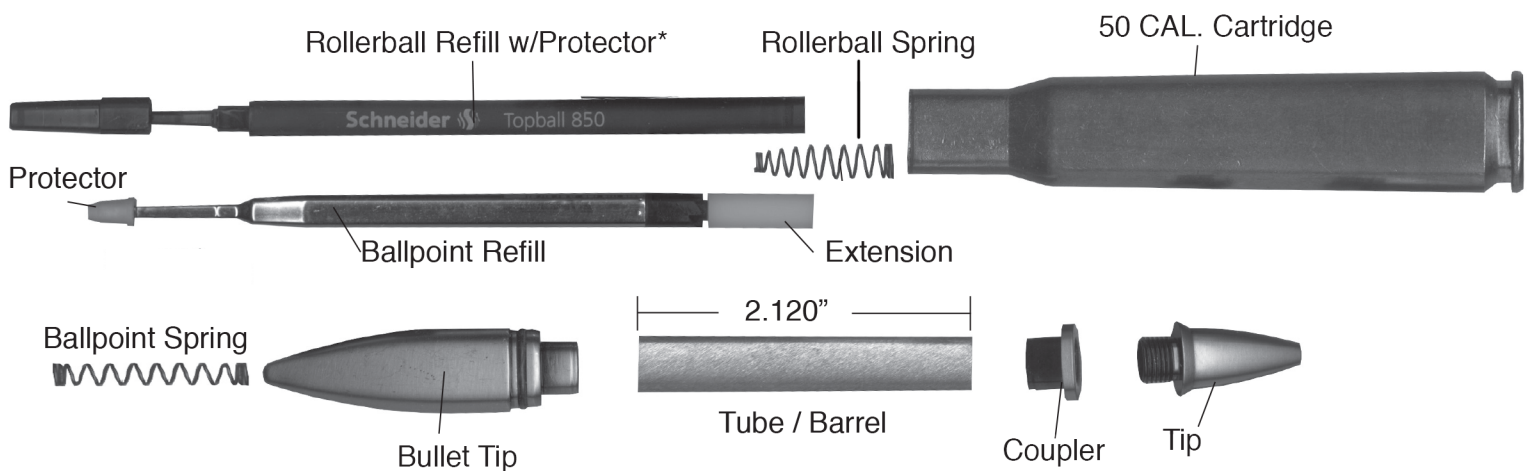
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in Rollerball & Ballpoint Styles
- Use Parker® Style Refill (with extension) or Rollerball Refill
- Overall Length: 5-1/2"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(2 pc): #PK50RBU
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" X 3"



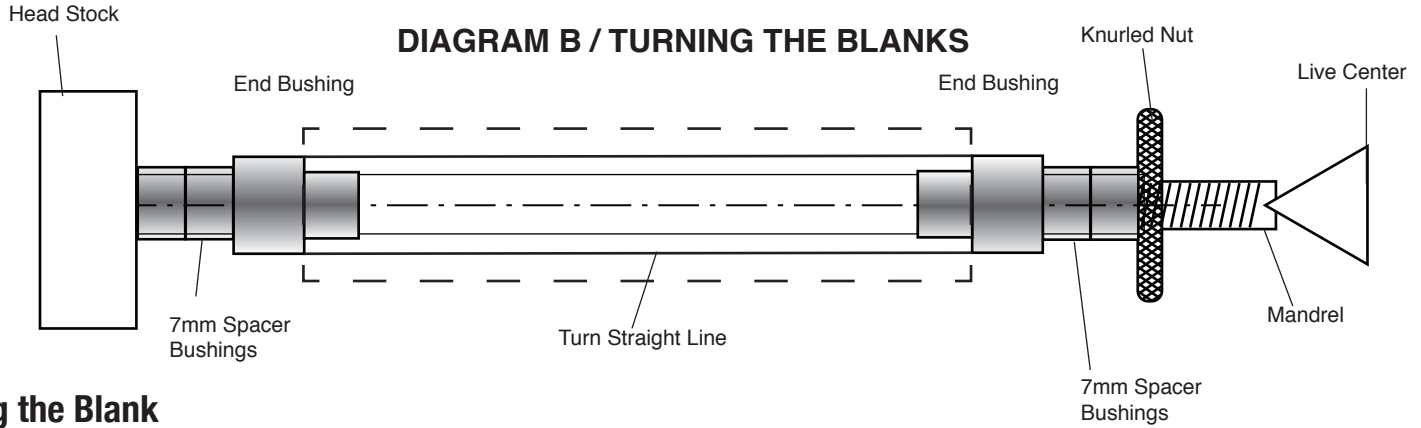
DIAGRAM A / PARTS LAYOUT



* Only one style included with pen kit

Preparing the Blank and Cartridge:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Fired cartridges require deburring and rounding.
- 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 the extension of the refill). Use a barrel trimmer to clean the inside of the tube.



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 so that the blank will insert into the inside of the 50 Cal. Shell.
- Insert the blank and make sure it slides in freely.
- 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

- Layout parts according to diagram A
- Press the coupler into either end of the barrel.
- Press the bullet tip into the opposite end of the barrel.

FOR ROLLERBALL:

- Remove the protector of the refill and drop in the spring then the refill into the opening at the coupler.

FOR BALLPOINT:

- Remove the protector of the refill, slide spring over front then drop into the opening at the coupler.
- Screw the tip into the coupler.
- When the pen is not in use, store inside the cartridge. The pen 'O' ring will seal and keep the pen secure.
- To use the pen, just pull out of the cartridge for writing.

Diagram C / Bushings #PK50RBU

