

Art Deco Click Ballpoint Pen

Kit Features

- Easy to Turn with Straight Tubes
- Minimal Parts—easy to assemble
- Available in multiple finishes
- Classic Style
- Reliable Schmidt™ Mechanism
- Overall Length: 5-1/16"

Required Accessories

- 7mm Pen Mandrel
- Drill Bit: #PK-38BP for Wood, #PKEXEC-38 for Plastic
- Bushing Set(2pc): #PKMAJSQBU
- Barrel Trimming: #PKTRIM38 or 3/8" sleeve from #PKTRIMSET with squaring jig on disc sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 2-5/16"L

Preparing the Blank:

- Prior to cutting and gluing, always verify tube length is correct (see parts diagram on back page)
- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 3/8" hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank while twisting 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 #PKTRIM38 or 3/8" barrel trimming sleeve with a pen blank squaring jig 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 assembly and the operation of the mechanism. Use a barrel trimmer to clean the inside of the tube.



DIAGRAM B / TURNING THE BLANK



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 and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To use Knurled Nut Setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- 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 Tailstock and hand tighten the quill adjustment with wheel 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 manufacturer's instructions.

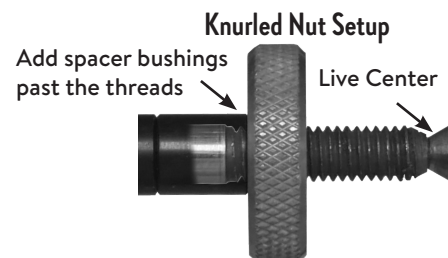


Diagram C / Bushing #PKMAJSQBU

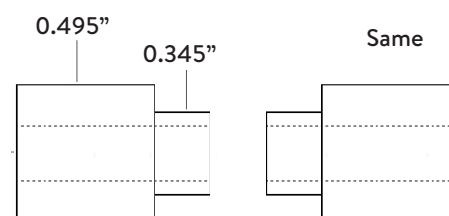
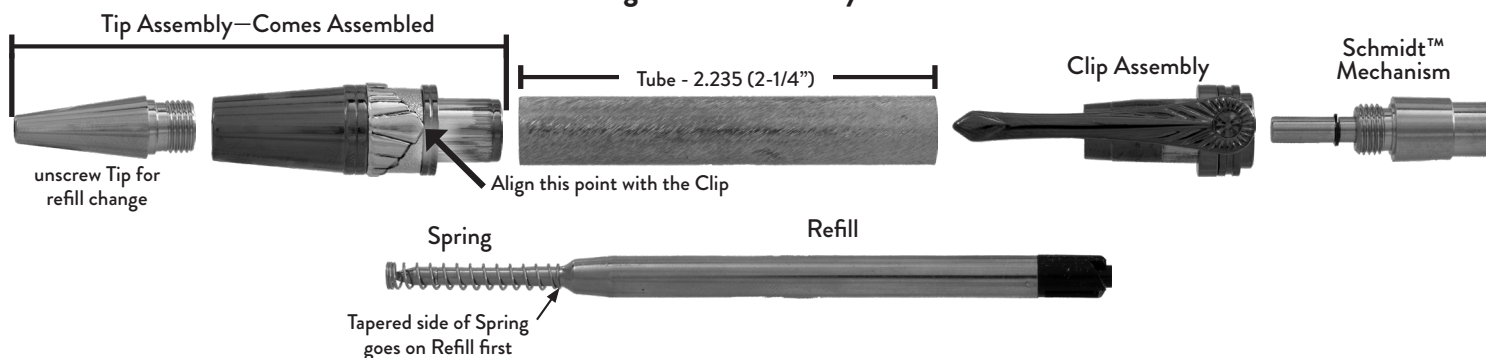


Diagram D / Parts Layout

**Assembly:**

Alignment Tip: The Art Deco looks best when the Clip aligns with the the central point on the Tip Assembly design. To help witht this alignment, before removing from the lathe, select a spot on the Barrel where you want the clip to be. Use clear adhesive tape and place it over that section of the Barrel. Then use the tool rest as a guide and draw a straight line with permanent marker from one end to the other. Use this line when pressing to line up the clip and Tip Assembly and then remove the tape.

- Press Clip Assembly into either end of the Barrel.
- Press Tip assembly into remaning open end of Barrel, aligning cetral point of design with the clip.
- Thread Mechanism into the opening in the top of the Clip Assembly.
- Place Spring, tapered end first, onto the Refill shaft.
- Unthread the Tip from the rest of the Assembly.
- Insert refill, back end first, into the opening in the Assembly.
- Thread Tip onto the Assembly over the Refill.
- To extend and retract the Refill, push on the the Mechanism Plunger.
- To change Refill, unthread the Tip from the Assembly. Remember to switch Spring to new Refill.

