

# Clip Bolt Action Pen Kit

## Kit Features:

- Convenient and sturdy Clip and Bolt Combo
- Knurled Button provides additional functionality
- Easy to Turn with Straight Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-3/8"
- USES REFILL: #PKPARK-R5

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: #PKEXEC-38 for Plastic or #PK-38BP for wood
- Bushing Set (2 pc): #PKCHPENBU
- Barrel Trimming set: #PKTRIM38 or #PKTRIMSET with sanding disc
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 2-7/16"L

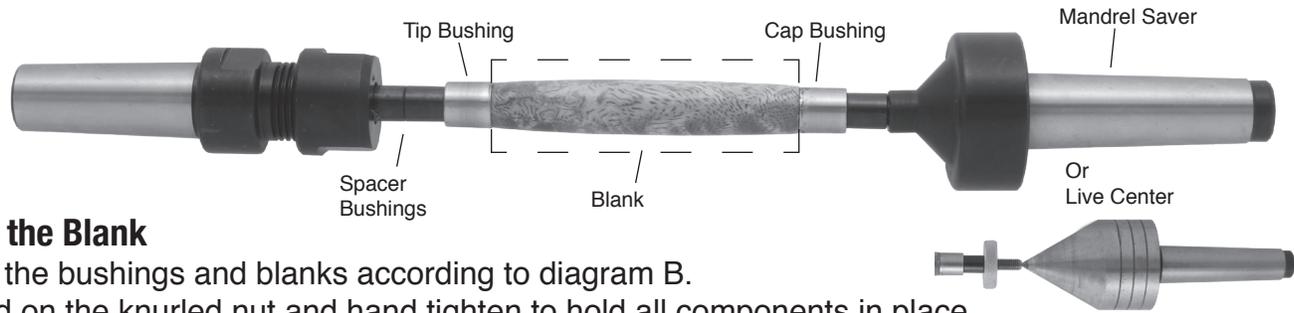


DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- 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 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, making sure the trimmed ends are 90° to the tube. Use a 3/8" barrel trimmer, or a pen blank squaring jig with 3/8" 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.
- 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.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- 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.

**Assembly**

- Lay out Parts according to Diagram A.
- Press Tip Coupler into open end of Barrel.
- Making sure clip is in the down locked towards tip position, press Back End Assembly into either end of Barrel.
- Drop Refill, back end first into opening and place Spring onto Refill shaft.
- Thread Tip into pen, over Refill.
- Refill can be advanced by sliding clip forward and pushing it into the side slot. To retract, slide Clip out of side slot.
- Refill can also be advanced by pushing down and twisting the top button. A quick twist in the opposite direction retracts the refill.
- If clip becomes loose, there is a set screw in the Back End Assembly can be accessed through the tip and tightened with a #0 Phillips Head screwdriver.
- To change the refill, unscrew tip. Be careful not to lose spring when transferring to new refill.

**Diagram C / Bushings #PKCHPENBU**