

Cue Chalk Holder Pen Kit

Kit Features

- Conveniently for carrying chalk and permanently marking scores
- Compact pocket size
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 4-7/16" (Plus Holder)

Required Accessories

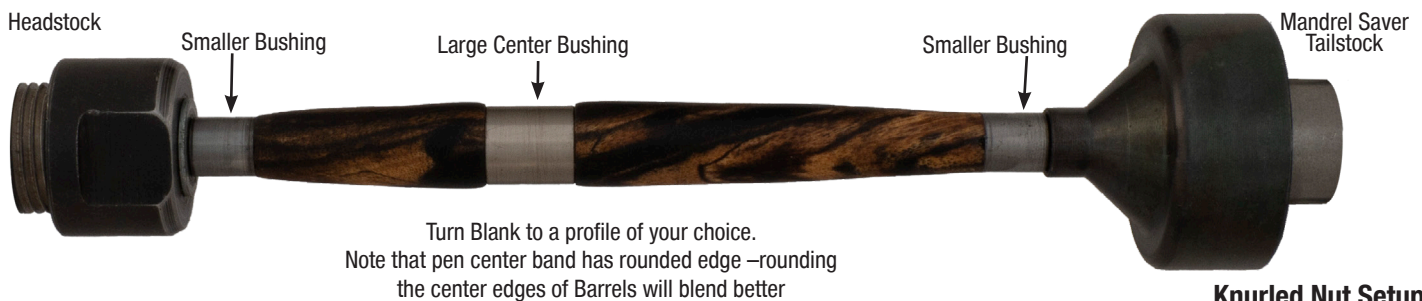
- 7mm Pen Mandrel
- Drill Bit: #PK-7MM for Wood, #PK-7MMSG for Plastic
- Bushing Set(3 pc): #PKCOLDBU
- Barrel Trimming: #PKTRIM7 or #PKSQUARE with Sanding Disc
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 4-1/4"L



Preparing the Blank:

- Cut blanks to the length of the tube, adding 1/16" to each for squaring off.
- Drill 7mm hole lengthwise through the blanks.
- 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 blanks, making sure the trimmed ends are 90° to the tube. Use a 7mm Barrel Trimmer or 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 Used 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 the manufacturer's polish instructions.

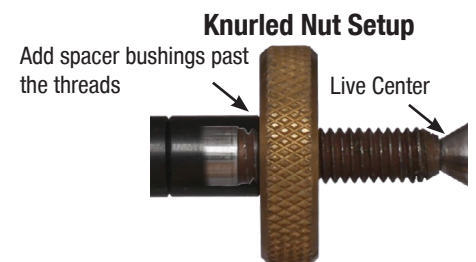


Diagram C / Bushing #PKCOLDBU

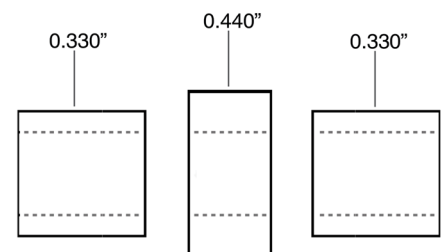
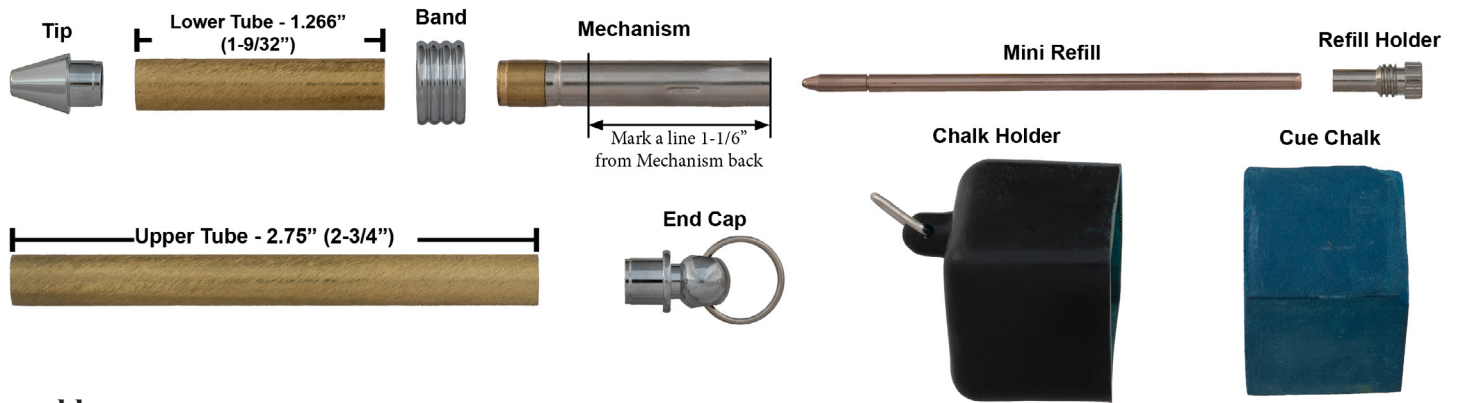


Diagram D / Parts Layout

**Assembly:**

- Press End Cap into smaller diameter end of the Upper Barrel.
- Attach Chalk Holder to the jump ring on the End Cap.
- Press Tip into smaller diameter end of Lower Barrel.
- Mark the Mechanism with a line 1-1/16" from the back of the Mechanism. This will be the depth mark for Pressing.
- Press the Mechanism, brass end first, into the larger, remaining opening in the Lower Barrel. Press past the crimp line to the depth mark made in the previous step.
- Make sure that Refill is fully pushed into the Refill Holder.
- Make sure the Mechanism is in the retracted position. The threads inside Mechanism should be all the way up to the opening in the back of the Mechanism. If it is not, twist back of Mechanism counter-clockwise until the threads reach the opening.
- Insert the Refill and Holder into the back of the Mechanism and thread fully into the Mechanism threads. Twist the back of the mechanism clockwise and make sure you are satisfied with refill extension. Mechanism can be carefully pressed further into the Lower Barrel for longer extension of the Refill if desired –be careful not to press too far or Refill may not fully retract.
- Slide the Band over the back of the Mechanism until it is fully against the Lower Barrel.
- Slide Upper Barrel over the back of the Mechanism until it is fully against the Band.
- To extend and retract Refill, twist pen barrels clockwise and counter-clockwise.
- To replace Refill, pull Upper Barrel off of Mechanism and unthread Refill Holder. Transfer Refill Holder to new Refill and re-install into Mechanism. Replace Upper Barrel over Mechanism.
- To replace Chalk push gently against bottom of Chalk Holder until Chalk is pushed enough out that it can be grabbed by hand and removed. Slide new Chalk fully into the Holder.