

# Duraclick Slim Pen Kit

## Kit Features:

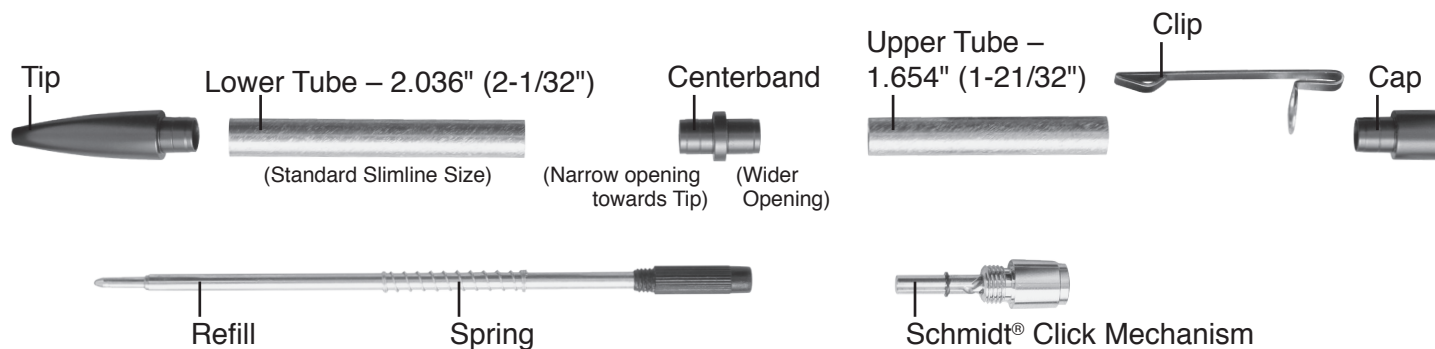
- Slim Profile
- Reliable Schmidt® Click Mechanism
- Easy to Turn With Straight 7mm Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-25/32"
- USES CROSS® REFILL: #PK-PEN-R5

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: # PK-7MMSG for Plastic, #PK-7MM for Wood
- Bushing Set(3 pc): PKDUSLIMBU
- Barrel Trimming set: #PKTRIM7 or #PKSQUARE and Disc Sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 3-15/16"L

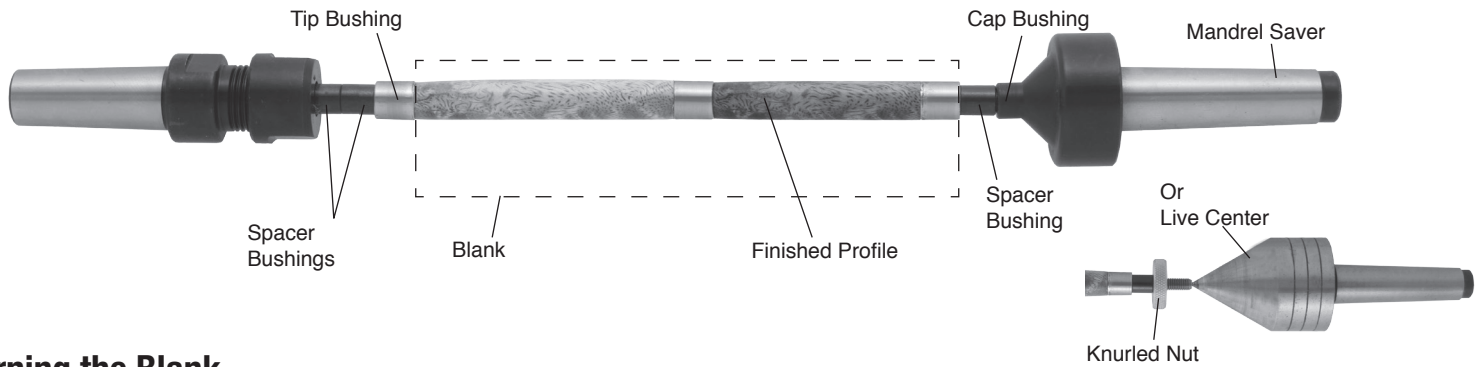


## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut blanks to the length of the tube, adding 1/16" to each blank for squaring off. Mark blank prior to cutting to help match grain when mounting on Mandrel.
- Drill 7mm holes 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 with 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. Remember to match ends so grain will match.
- 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.
- Tip: before pulling off Mandrel, place a piece of painter's tape on the center side of both Barrels so that they can be matched in the right direction when pressing parts — painter's tape will not leave residue when removed.

**Assembly**

- Press Tip into bottom end of Lower Barrel (longer)
- Press side of Centerband with narrow opening into opposite end of Lower Barrel.
- Match grain on Upper Barrel to Lower Barrel and press Upper Barrel onto side of Centerband with wide opening.
- Slide Clip onto Cap and Press Cap into Upper Barrel.
- Drop Refill with Spring into opening in Cap.
- Thread Mechanism into Cap, behind Refill.
- To extend and retract Refill press plunger on Mechanism.
- To change Refill, unscrew Mechanism from cap and replace old Refill. Take care not to lose spring when changing Refill.

**DIAGRAM C / BUSHINGS # PKDUSLIMBU**