

DURACLICK SLIM MINI PEN

Kit Features

- Reliable Schmidt Mechanism
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 4 in.

Required Accessories

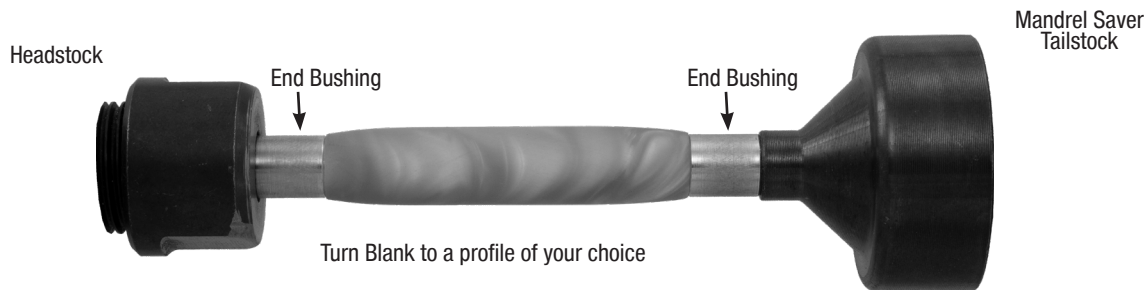
- 7mm Pen Mandrel
- Drill Bit: #PK-7MM for Wood, #PK-7MMSG for Plastic
- Bushing Set(3pc): #PKDUSLIMBU (Use two only)
- Barrel Trimming: #PKTRIM7 or squaring jig on disc sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 2-1/16"L

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 7mm 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 PK-TRIM7 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 will cause the refill to stick out so far it will not be able to retract. 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.

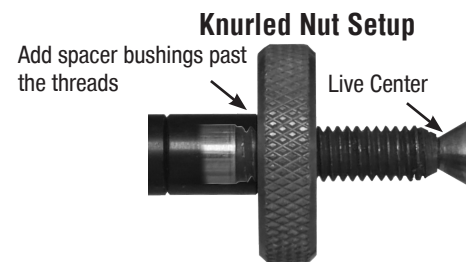


Diagram C / Bushing #PKDUSLIMBU

Use only two bushings

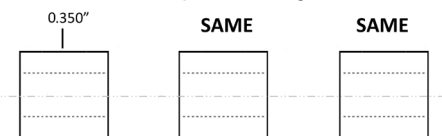
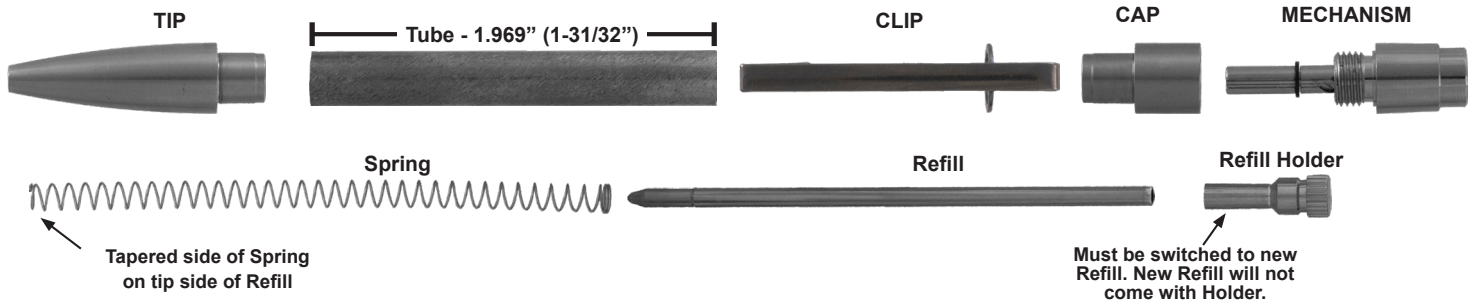


Diagram D / Parts Layout

**Assembly:**

- Press Tip into either end of the Barrel.
- Insert Cap into Clip and press into remaining, open end of Barrel.
- Slide Spring onto Refill, tapered side first so Spring should be on the same side as the tip of the Refill.
- Insert Spring and Refill (point side first) into the opening in Cap. Spring should wedge in Tip so it does not fall out and get lost. This should not interfere with function of Refill.
- Thread Mechanism into Cap pushing in Refill.
- To operate, push down on the button. Pen tip will extend and retract.
- To change Refill, unthread Mechanism from the back end. Remember to switch Refill Holder to new Refill. New Refill packs do not include Refill Holders.