

Firefighter's Pen Kit

Kit Features:

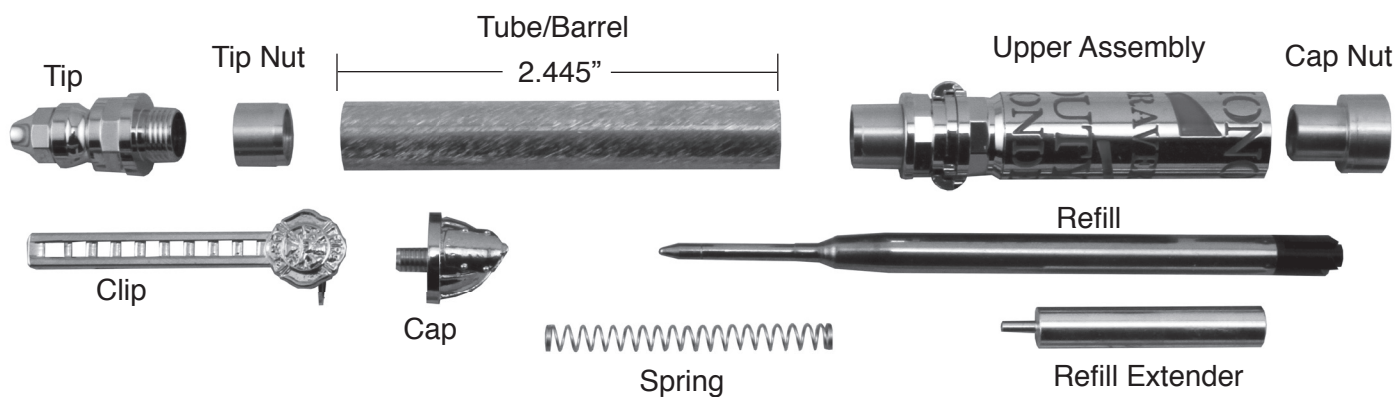
- Authentic Design Elements
- Innovative mechanism function
- Easy to Turn With Straight Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 6-1/16"
- USES PARKER STYLE REFILL: PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 10mm #PK10-10
- Bushing Set(2 pc): PKFIREBU
- Barrel Trimming set: PKTRIM10 or 10mm sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 2-1/2"

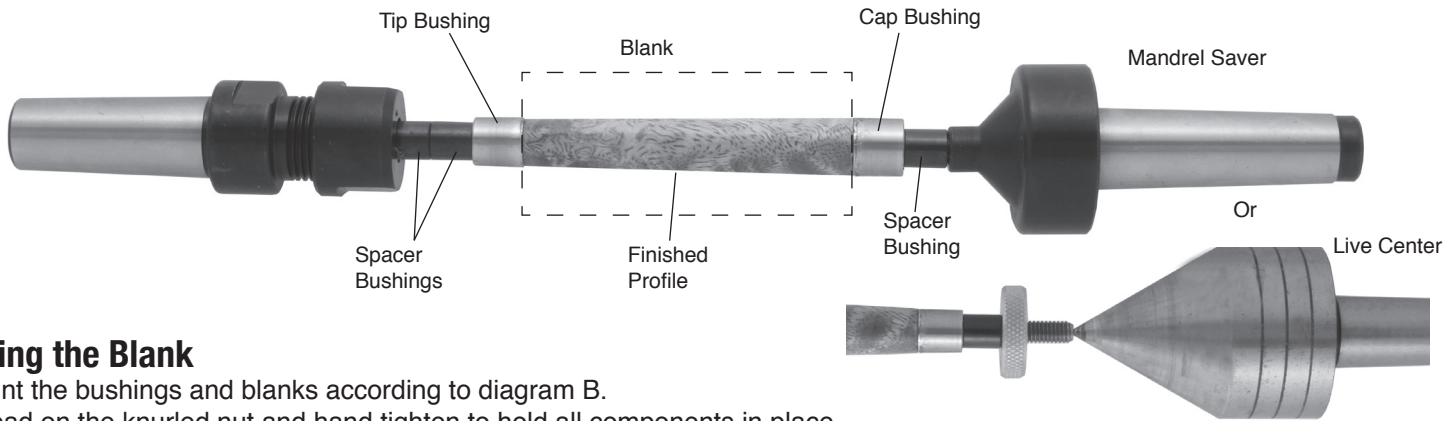


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

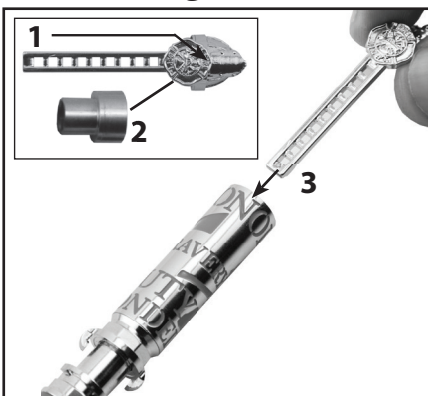
- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 10mm hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 10mm barrel trimmer, or a pen blank squaring jig with a 10mm 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

- Press Tip Nut, recessed end first, into small diameter end of Barrel.
- To prevent damage when pressing, push the ends of the Upper Assembly into the closed position and twist to lock.
- Thread the Cap through the Clip and Cap Nut, aligning the clip to the front of the cap to form the Clip Assembly and tighten.
- Orient the Clip Assembly on the Upper Assembly according to Diagram D.
- Push the Clip Assembly in slightly so it wedges in the Upper Assembly, then unthread the cap and clip to avoid pressing damage.
- Press the Cap nut fully into the Upper Assembly
- Press Upper Assembly into larger end of Pen Barrel.
- Thread cap and clip back onto the upper assembly.
- Twist Upper Assembly counter-clockwise to unlock.
- Place small post of Refill Extender into the back of Refill.
- Hold Refill so that extender is upright and insert refill and extender into open end of Pen until Upper Assembly is fully retracted.
- Turn pen over so that tip is pointed upward and place spring over tip of refill.
- Thread Pen tip over refill and spring.
- To extend refill, push Upper Assembly towards tip and twist clockwise to lock. To retract, unlock by pushing Assembly slightly towards tip and twisting counter-clockwise..
- To change refill, unscrew tip and remove old refill, spring and extender.. Insert new refill according to instructions above.

Diagram D

1. Align clip badge and helmet badge
2. Screw the Cap Nut onto helmet post tightly.
3. Align clip with the "N" in HONOR and push.

Diagram C / Bushings #PKFIREBU