

# The Flip Stylus Pen Kit - V2

PKFLIP224 • PKFLIP2CH • PSFLIP2GM

## Kit Features:

- Functions as a stylus or pen by flipping the pen body
- Stores easily in pocket or purse
- Uses standard mini pen refill
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Overall pen length: 5-1/4"
- Overall stylus length: 4-1/4"

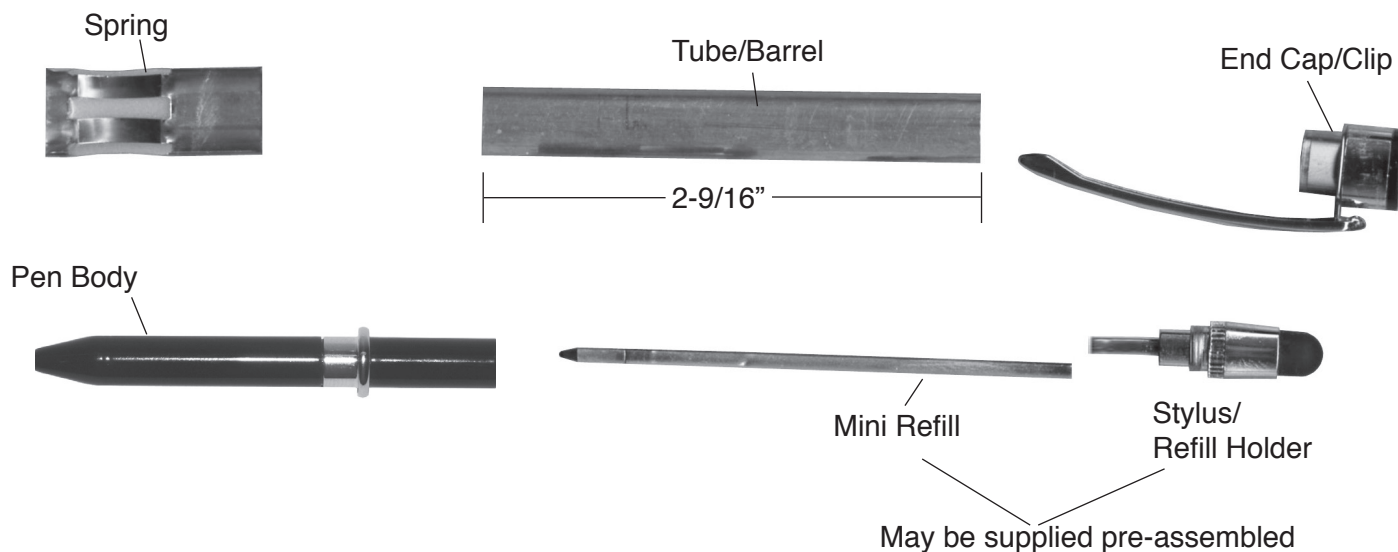
**Note:** Use these instructions instead of v12/12



## Required Accessories:

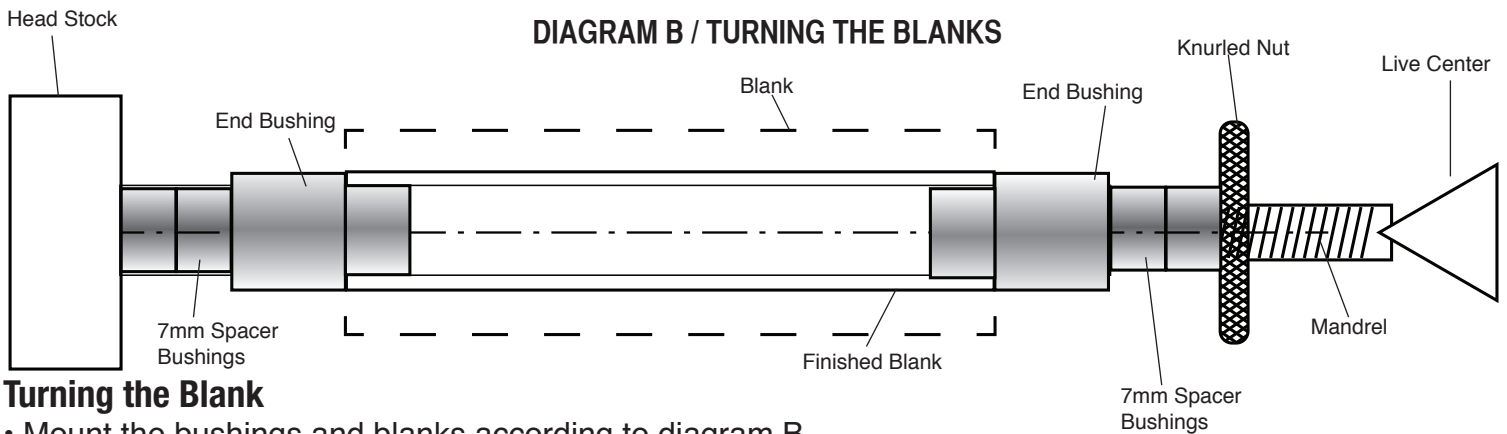
- 7mm Pen Mandrel
- Drill Bit: 3/8", #PKEXEC-3/8
- #PKFPBU, Bushing set(2 pc)
- PKTRIM7, Barrel Trimmer (see barrel trimming below)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 5/8" x 2-3/4"

**BARREL TRIMMING:** use (3ea) 7mm spacer bushings inside tube as a guide for 7mm barrel trimmer. (3/8" trimmer will not work!)



## Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert into the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use a 8mm barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly).



### 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 in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel).
- 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 the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure. Refer to polish instructions.

### Assembly

- Layout parts according to diagram A
- Insert the refill, open end first into the opening at the stylus/refill holder. (may be supplied pre-assembled) Insert and screw this assembly into the pen body.
- Insert and press the end cap/clip, recessed end in first into either end of the tube/barrel.
- Roll the spring into a narrow cylinder. Place this cylinder into the open coupler end of the tube, making sure the slotted end goes in last. DO NOT allow the spring to expand until it is pushed at least 3/4 of the way into the tube.
- Push the spring flush with the end of the barrel.
- Your pen is now complete. Insert the stylus (short end) into the coupler to use the pen part. Insert the pen end (larger) into the coupler to use the stylus.

### Diagram D / Bushings #PKFPBU

