

Semi-Automatic Hand Gun Pen Kit

Kit Features:

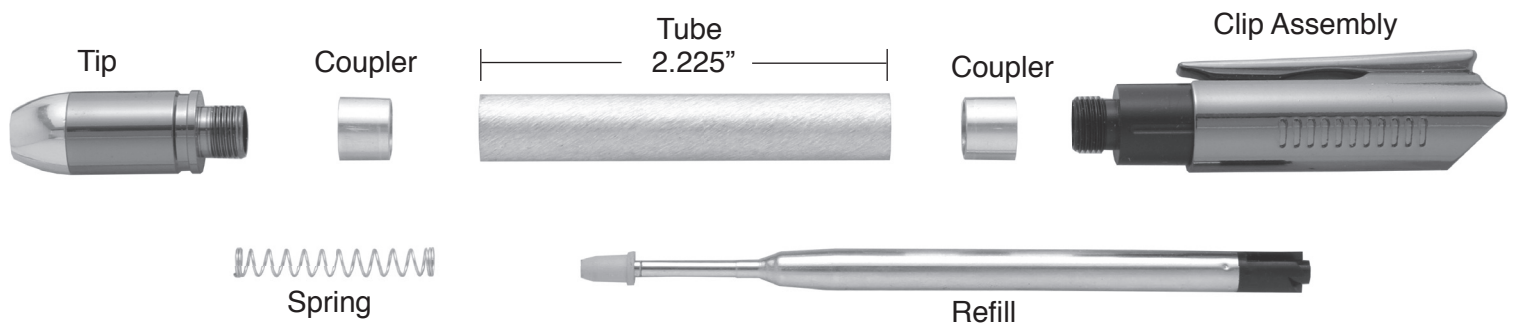
- Sleek, Industrial Appearance
- Clicking action mimics slide on genuine sem-automatics
- Easy to Turn With Straight Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-5/16"
- USES REFILL: #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: #PKEXEC-38
- Bushing Set(2 pc): #PKABBU
- Barrel Trimming set: #PKTRIM38 or 3/8" 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 2-3/8"



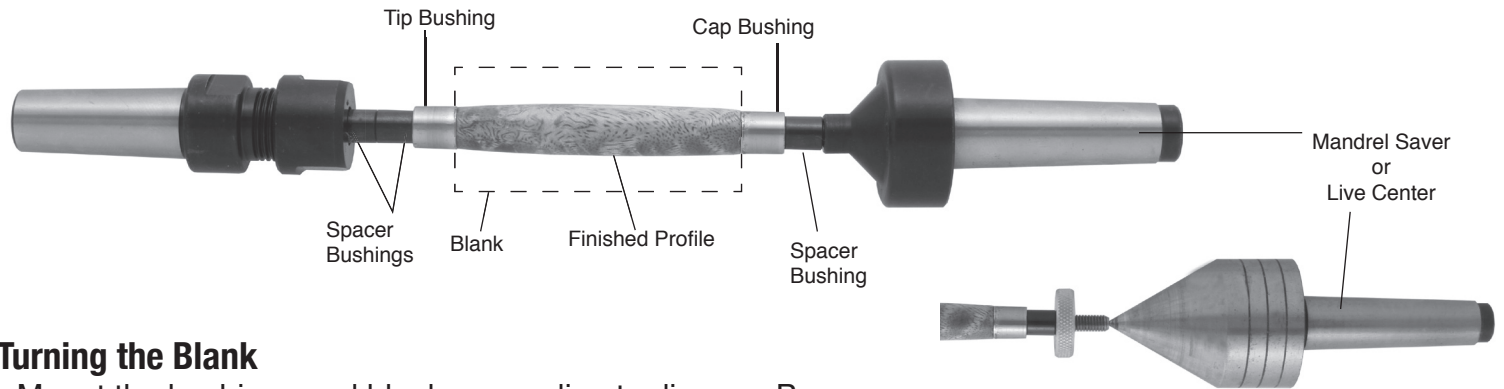
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 3/8" 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 blank, making sure the trimmed ends are 90° to the tube. Use a 3/8" barrel trimmer, or a pen blank squaring jig with a 3/8" 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.
- 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.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the 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. This pen may do best with a straight profile.
- 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

- Layout parts according to diagram A
- Press couplers into both ends of the Barrel until they are flush
TIP: If you want to orient the clip in a certain direction, thread the coupler onto the Clip Assembly and push it by hand into the Barrel in the preferred orientation until it stays fixed, then remove the Assembly and complete with press.
- Once couplers are in place, thread the Clip Assembly onto your preferred end. There will be a slight ledge, this is intended to enhance the the piston-like appearance of of the assembly.
- Insert Refill into open end of the Barrel.
- Place spring over the shaft of the refill and thread tip over it.
- To extend or retract pen, press on the top of the Clip Assembly To change refill, unscrew tip.

Diagram C / Bushings #PKABBU

