

# Stratus Click Pencil Kit

## Kit Features:

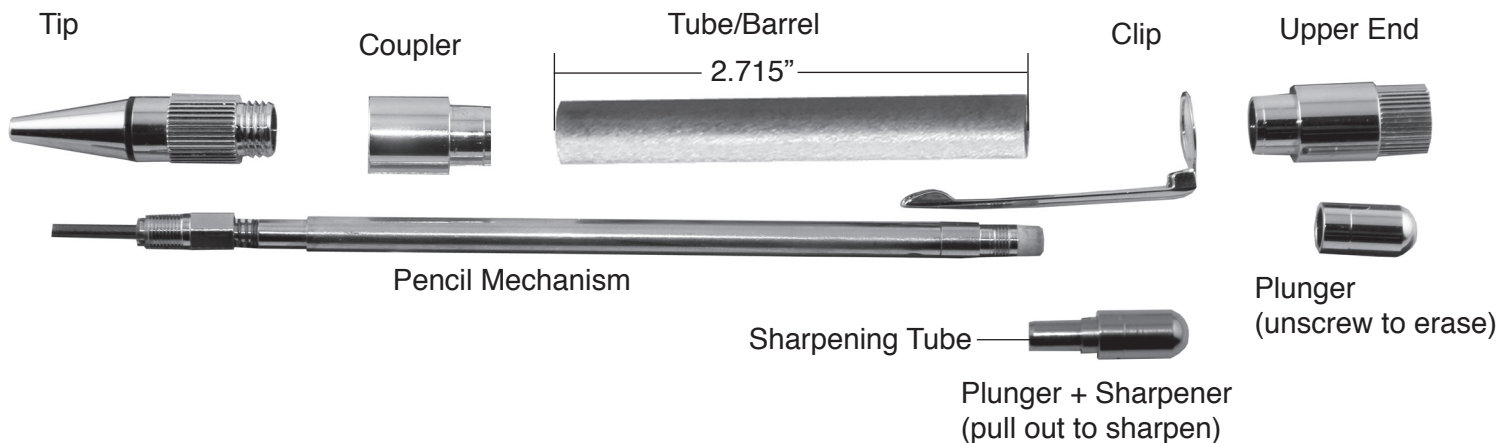
- Easy to turn with a single tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses 2mm thick replacement lead
- Overall length: 5-5/8"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC38
- Bushing set (2 pc) #PKCHPENBU
- Barrel Trimming #PKTRIM38
- Live Tailstock Center or Mandrel Saver
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/4" Long



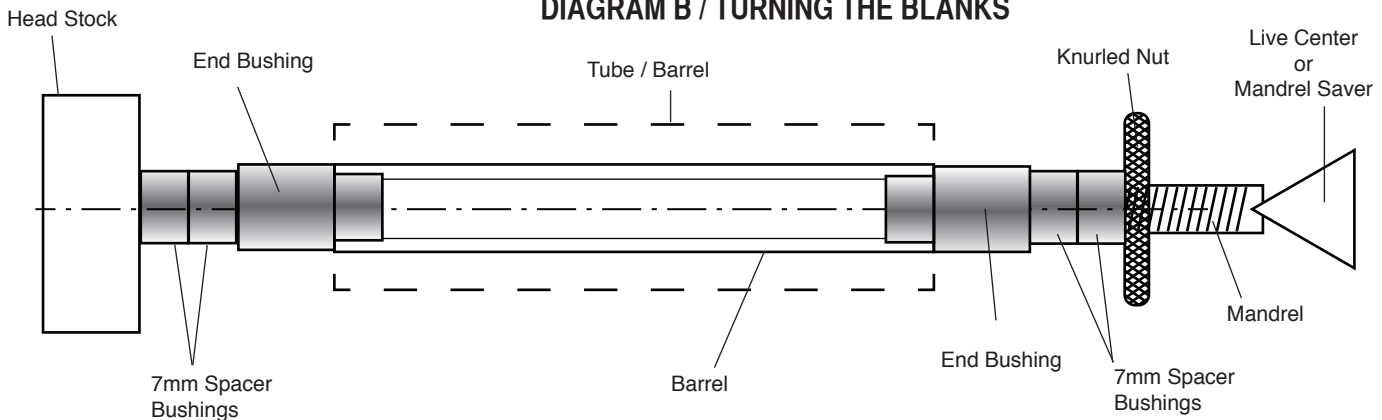
## DIAGRAM A / PARTS LAYOUT



## 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 tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use 3/8" 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). 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 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
- Press the coupler, recessed end in first into either end of the barrel.
- Place the recessed side of the upper end through the clip hole.
- Press this assembly into the opposite end of the barrel.
- Screw the plunger over the eraser on the pencil mechanism.
- Screw the tip onto the coupler.
- Place the pencil mechanism, tip first into the opening at the upper end of the pencil. Thread in until it bottoms.
- The pencil operates by clicking on the plunger to advance the lead. To retract the lead, click the plunger while holding the lead against a solid surface. The lead will slide inside.
- To use the eraser, unscrew the plunger to expose.
- To refill the lead just press the plunger to release the old lead and reload a new one into the opening at the tip.
- To sharpen lead - extend lead, pull plunger mechanism out. Insert lead into sharpening tube and rotate.

**Diagram C / Bushings #PKCHPENBU**