

# Whistle Kit: #PKKUAX (All Finishes)

## Secret Kit: #PKKUBX (All Finishes)

### FEATURES

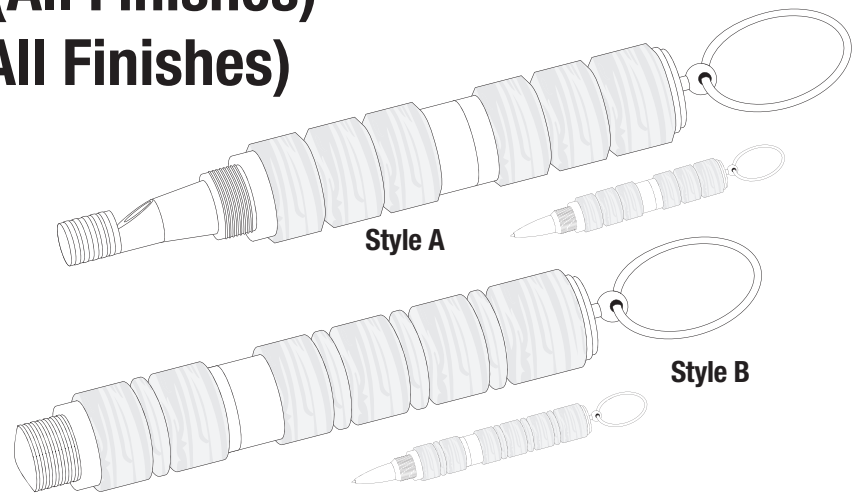
- A useful combinations of security features
- Available is either whistle pen or security pen
- Multi function kit with various wood design options
- Handy key ring - posting ballpoint pen
- Uses Mini pen refill #PKNINI-B5
- Overall length: 5 5/8"

### REQUIRED ACCESSORIES

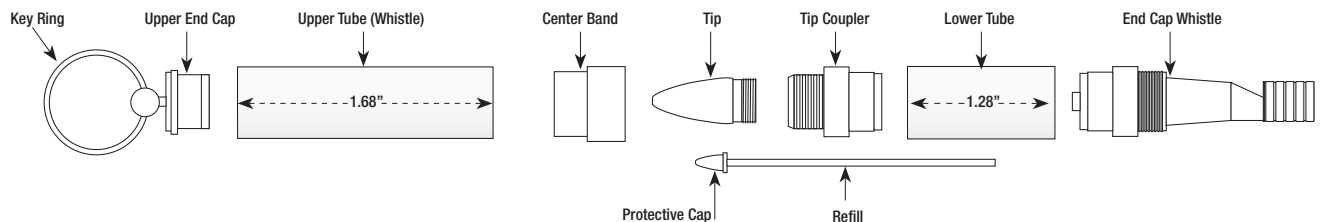
- 7mm Pen Mandrel
- 3 Pcs. bushing set #PKKUBU
- 2 Part epoxy glue or Insta Cure (cyanoacrylate) glue
- 1/2" drill bit # PKDB12

### PREPARING THE BLANKS FOR TURNING

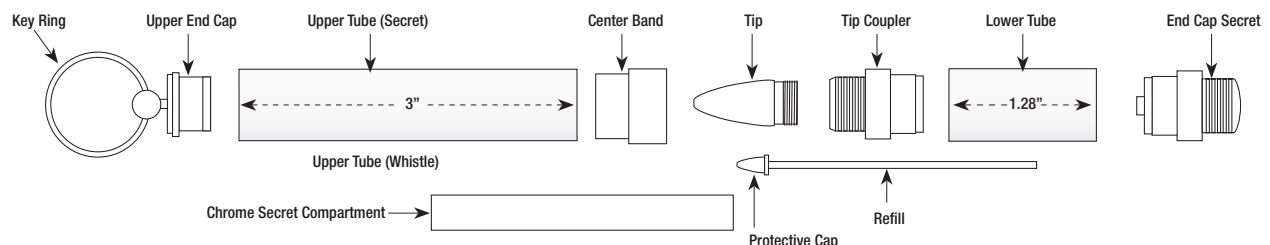
- Cut 3/4" or larger square blanks to the length of the brass tube (add 1/16" for squaring off).
- Drill 1/2" holes lengthwise through each blank.
- Spread glue over the tubes. Insert tubes into blanks with a twisting motion to spread the glue evenly inside. Center each tube Lengthwise in the blanks.
- When the glue dries, square the ends of the blanks. Use a disc sander or universal trimming jig. (#PKSQUARE)  
Take the wood down to the brass tube



### DIAGRAM A: STYLE A - PARTS LIST & ASSEMBLY



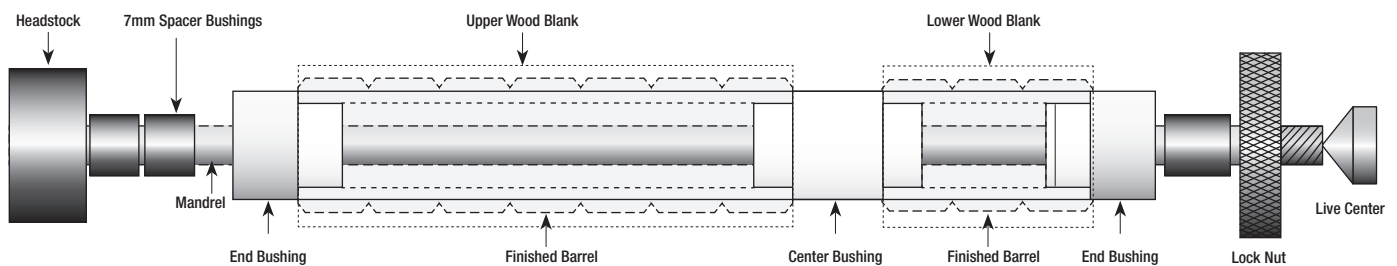
### DIAGRAM A: STYLE B - PARTS LIST & ASSEMBLY



## TURING THE BLANKS

- Slide 7mm spacer bushings onto the mandrel. Follow with end bushing, wide end first. Slide the upper blank (longer) slide in the center bushing. Insert the lower blank (shorter) over, follow with an end bushing smaller diameter in first. Add additional spacer bushings as necessary to reach the mandrel threads.
- Thread on the lock nut, hand tight to hold the items in place. Slide the tail stock snug to the mandrel shaft.  
**NOTE: Do not over tighten, it will damage the mandrel. Lock in place.**
- Turn the wood down to the bushings using lathe tools and gradual higher grids of sand paper.
- Finish the barrels with your choice of polishes.

### DIAGRAM B - TURNING THE BLANKS



## ASSEMBLY

**NOTE:** Line up per Diagram A

- Insert and press the upper end cap, narrow end first into the opening at the upper tube (longer)
- Insert and press the center band, plastic end first into the opposite end of the upper tube.
- Insert and press the end cap, un-threaded end in first into the opening at the lower tube (short)
- Insert and press the tip coupler, un-threaded end in first into the opposite end of the lower tube.
- Remove the protective cover off the refill, insert the refill through the opening into the seat inside the end cap.
- Screw on the tip into the tip coupler.

**NOTE:** Style A: end cap includes whistle, Style B: insert chrome secret compartment tube into upper tube.

### DIAGRAM C - BUSHINGS #PKKUBU

