

# Majestic Squire EDC Click Pen

## Kit Features

- Easy to Turn with Single, Straight Tube
- Minimal Parts—easy to assemble
- Available in multiple finishes
- Uses Parker style refill #PKPARK-R5
- Uses a Reliable Schmidt Click Mechanism
- Overall Length: 5-3/32"

## Required Accessories

- 7mm Pen Mandrel
- Drill Bit: #PK-38BP for Wood, #PKEXEC-38 for Plastic
- Bushing Set(pc): #PKMAJSQBU
- Barrel Trimming: #PKTRIM38 or 3/8" sleeve from #PKTRIMSET with squaring jig on disc sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 2-5/16"L



## Preparing the Blank:

- Prior to cutting and gluing, always verify tube length is correct (see parts diagram on back page)
- 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 while twisting 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 #PKTRIM38 or A 3/8" barrel trimming sleeve with a pen blank squaring jig on a disc sander. Take the excess material down flush to the ends of the tubes. **IMPORTANT: Do not trim past the end of the tube since this can interfere with assembly and impact the correct operation of the mechanism.** Use a barrel trimmer to clean the inside of the tube.

## Diagram B / Turning the Blank

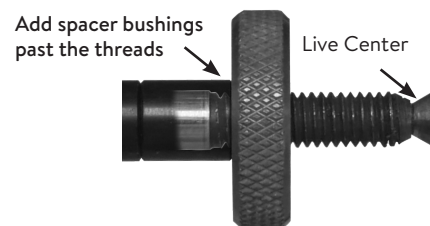
Headstock

Mandrel Saver  
Tailstock

## Turning the Blank:

- Mount the bushings and blanks according to diagram B.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To use Knurled Nut Setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- 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 and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage 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.
- 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 manufacturer's instructions.

## Knurled Nut Setup



## Diagram C / Bushing #PKMAJSQBU

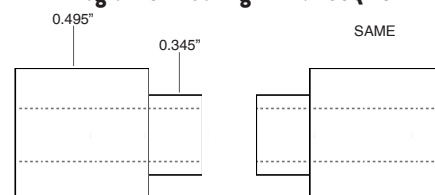
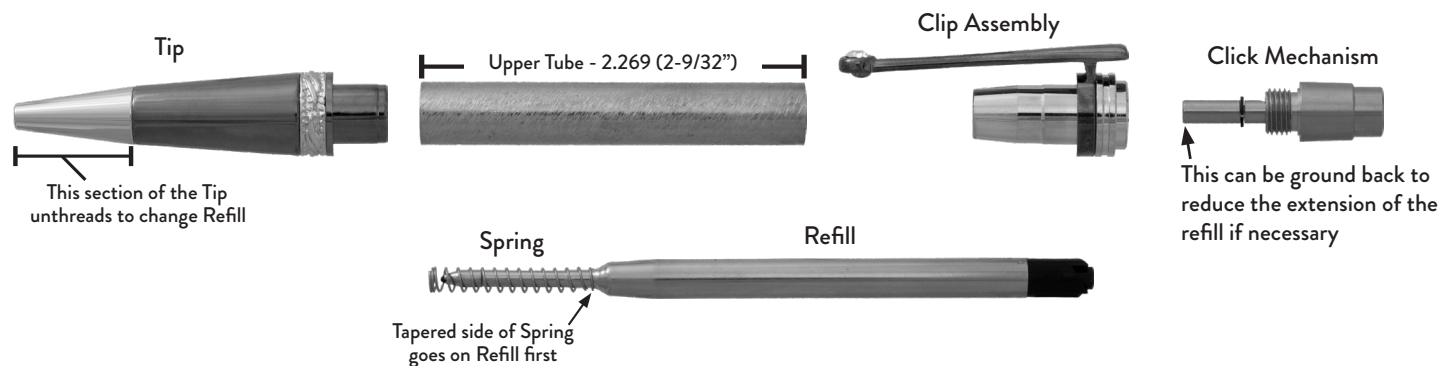


Diagram D / Parts Layout

**Assembly:**

- Press Clip Assembly into you chosen upper end of the Barrel.
- Press Tip into remaining, open end of Barrel. Note that you may unthread the front section of the Tip to get a flatter pressing area.
- Thread the Click Mechanism into the opening in the top of the Clip Assembly.
- Slide Spring, tapered side first, onto the tip of the Refill. The Spring should grab the Refill shaft and not fall off accidentally.
- Unthread the front section of the tip if you have not already done so.
- Insert Refill, back end first into the tip.
- Thread front section of Tip back on, over the Refill.
- To extend and retract the Refill simply press on the plunger on the Click Mechanism.
- Tip: If you accidentally shorten the blank when trimming and the refill is extending a little too far, you can grind back the end of the Click Mechanism to reduce how far the refill extends.
- To change the Refill, unthread the front section of the Tip. Remember to switch the Spring to the new Refill.

