

Shake Pen Kit

Kit Features:

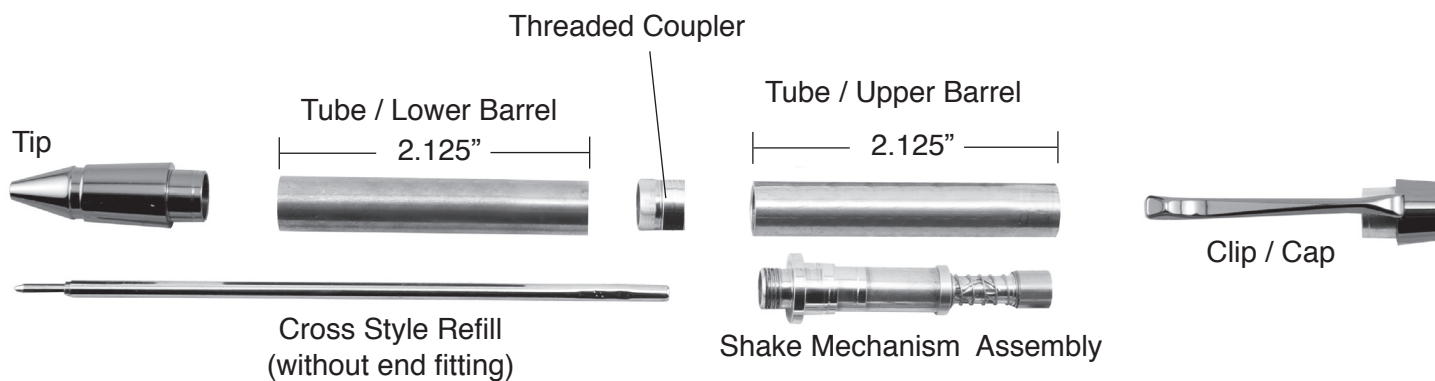
- Fun “shake” style mechanism
- Uses popular “Cross Style” Refill
- Easy to turn profile
- Available in multiple finished
- Tube size 10mm

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 10mm #PK10-10
- Bushing Set(2 pc): #PKSHAKEBU
- Barrel Trimming set: #PKTRIM10 or Squaring Jig
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4” x 3/4” x 4-3/4”



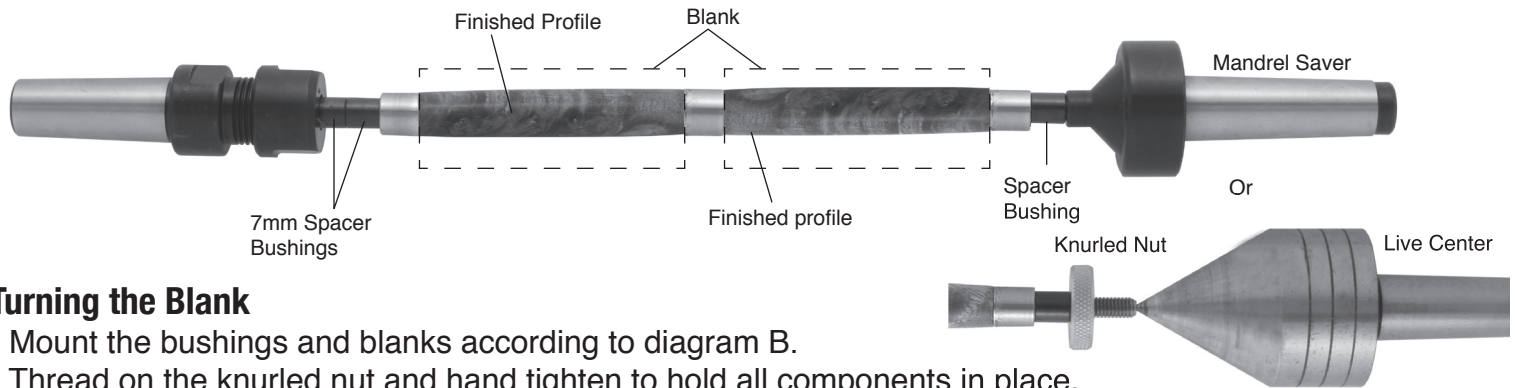
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tube, adding 1/16” for squaring off.
- Drill a 10mm 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 blanks, making sure the trimmed ends are 90° to the tube. Use a 10mm barrel trimmer, or a pen blank squaring jig 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.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- 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.
- 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 instructions.

Assembly

- Line up parts according to Diagram A
- Press the tip into the smaller diameter end of either barrel.
- Press the coupler, recessed end in first into the opposite end of the barrel.
- Press the cap/clip assembly into the smaller diameter end of the other barrel.
- Insert the shake mechanism assembly, into the opposite end of the barrel. Press in.
- Slide the back of the plain refill into the opening at the thread and into the hole inside the mechanism. Press in place to bottom.
- Guide the refill into the large opening at the lower barrel. Screw both ends together at the center.
- The pen is ready to use.
- When ready to write, just shake the pen downward. The tip will extend out, ready to write. To retract the tip, shake the pen again. The tip will retract and stay safely below the tip surface.

NOTE: Be aware to check the position of the tip before inserting into your pocket.

Refill Replacement

- Unscrew pen at center
- Remove old refill
- Remove end filling from Cross Style Refill.
- Press into mechanism and re-assemble.

Diagram D / Bushings #PKSHAKEBU