

# Flip Stylus LED Pen Kit

PKTS300 • PKTS301 • PKTS302

## Kit Features:

- 3 Functions: Pen, Light, Stylus
- Easy to turn with straight or profiled barrel
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses mini refill #PKMINI-R5
- Uses (3) batteries LR41 Button Cell (included)
- Overall length: 5-1/8"

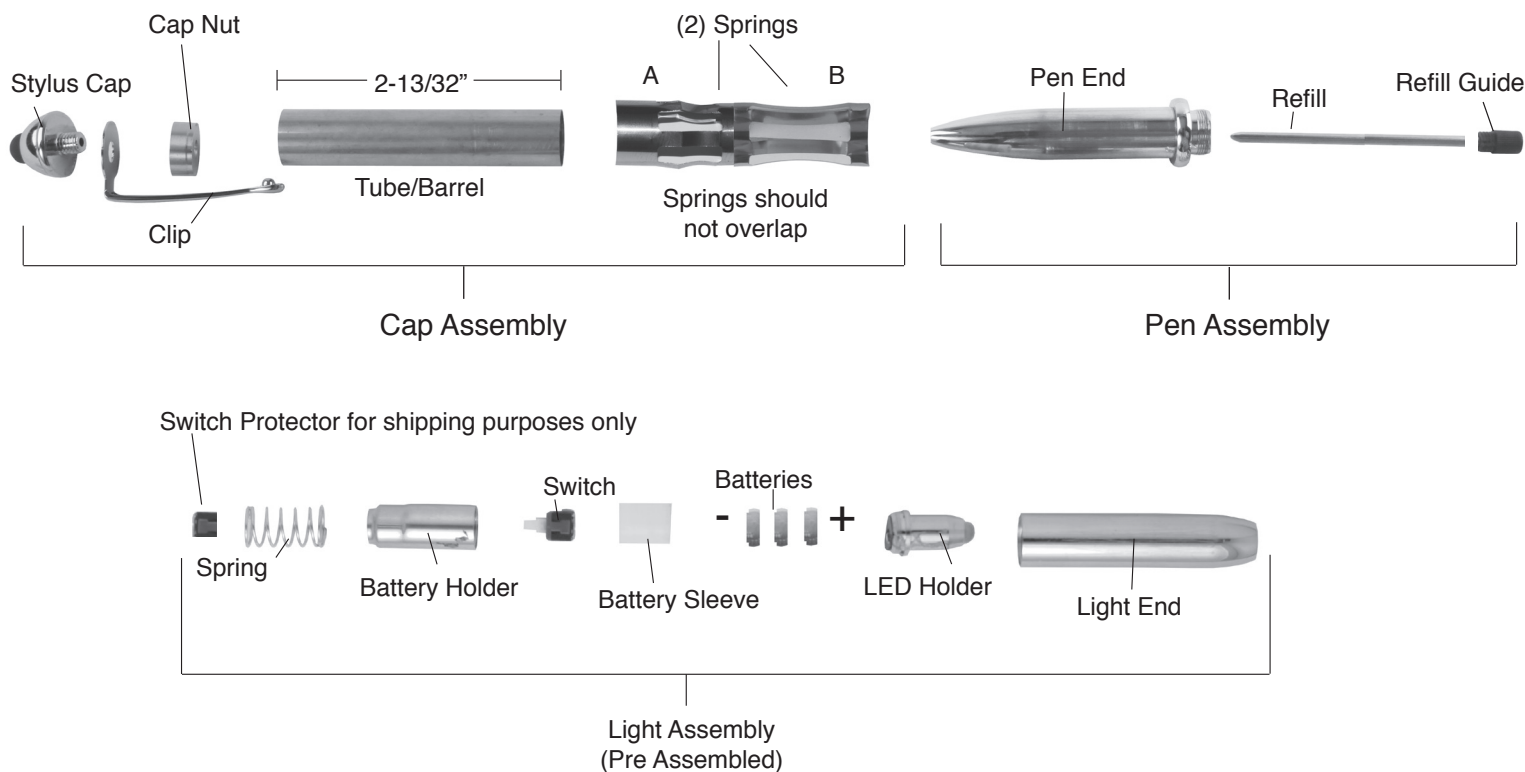
## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 12.5mm #PKPLI-DB
- Bushing set (2 pc): #PKCKBU
- Barrel Trimming Set: PKMAJJRBTs (Use the 12.5mm Larger Sleeve with 7mm shaft)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 2-1/2" L x 3/4" SQ

Press to light

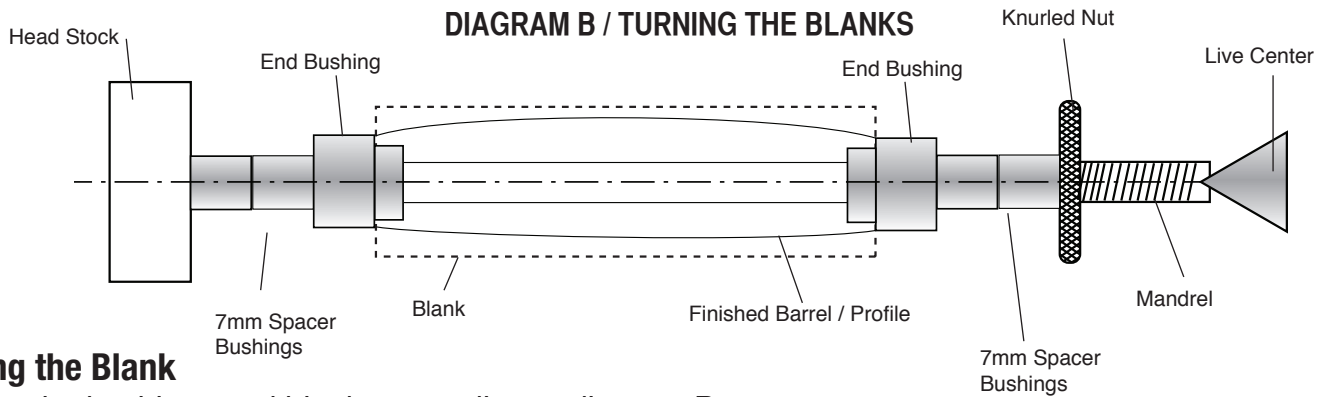


## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 12.5 mm hole lengthwise through the blank.
- Spread glue over the tube, insert 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 a 7mm barrel trimmer with the listed sleeve, 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.



### 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

#### Preparing Light Assembly:

- Layout parts according to diagram A (**LED module supplied assembled**)
- Unscrew pen assembly from light assembly.
- Remove the switch protector to allow the LED to function.
- Screw in refill assembly.
- Rescrew pen assembly to light assembly. Test light by pressing in.

#### Assembling the Cap:

- Press the cap nut. Recessed end in first into either end of the barrel.
- Affix the stylus cap stem through the clip, and thread into the cap nut.
- Insert the retaining spring (**A**) into the opening of the barrel followed by spring (**B**). Narrow side in first. Flush with the outside rim. (**See diagram A**)
- Insert either end of the module assembly into the barrel for lighting or writing.
- **To change the mini refill:** unscrew the light end of the assembly. Unscrew and remove the refill, replace.
- **To change batteries:** remove the light end of the assembly. Unscrew the battery holder from the LED holder. Remove and replace 3 batteries with #LR41 button cells. Insert with (+) side towards the LED. Reassemble with spring in place.

#### Diagram C / Bushings #PKCKBU

