

GROOVE CLICK PEN KIT

Kit Features:

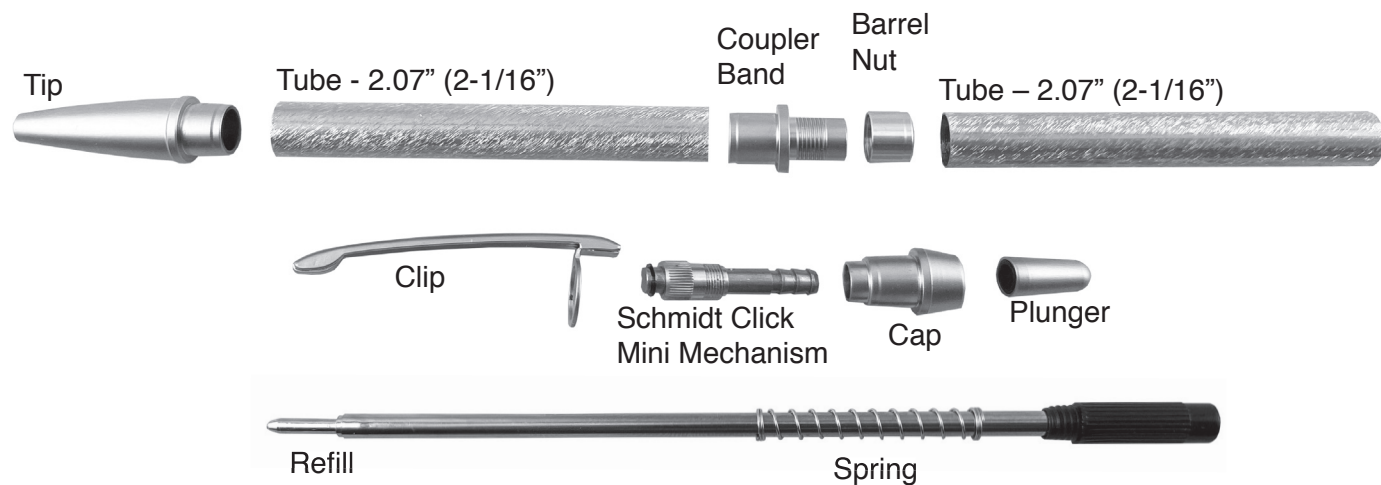
- Clean, Modern Design Elements
- Reliable Schmidt Click Mechanism
- 7mm Tube Allows for Thin Profile
- Easy to Turn With Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-23/32"
- USES Cross® REFILL: #PK-PEN-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: #PK-7MMSG for Plastic or #PK-7MM for Wood
- Bushing Set(3pc): #PKM-BUSH3
- Barrel Trimming set: PKTRIM7 or Pen Blank Squaring Jig and Disc Sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 4-5/16"L



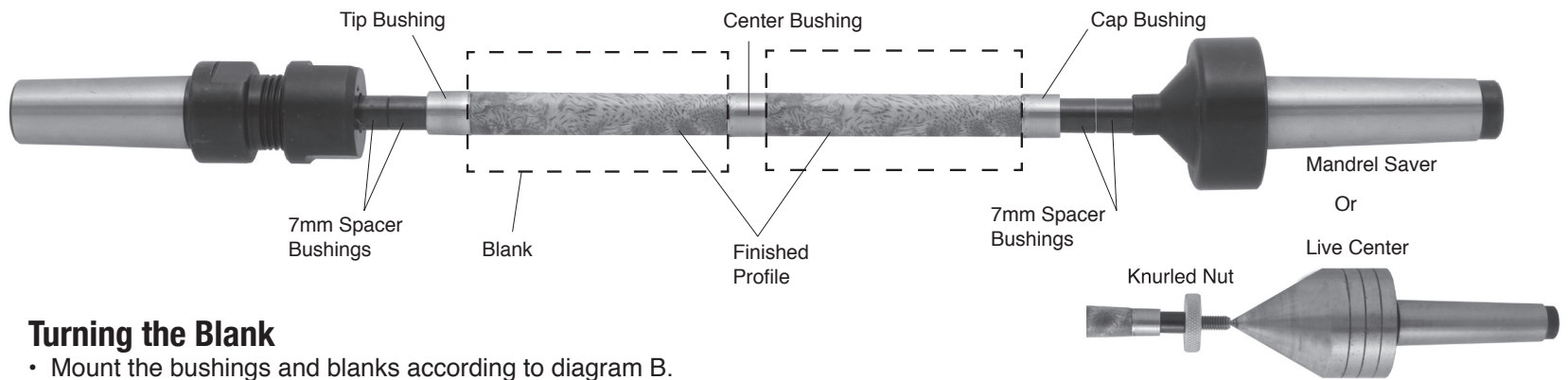
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tubes, adding 1/16" for squaring off.
- Drill 7mm hole lengthwise through the blanks.
- Spread glue over tube, insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 7mm barrel trimmer, or a pen blank squaring jig with 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 barrels using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

Assembly

1. Press Barrel Nut, reduced diameter first, into Lower End of Upper Barrel. It is important to make sure reduced diameter side goes in first. If pressed backwards, Coupler will not thread into it.
 2. Thread Click Mechanism into bottom of Cap – make sure it is tightly seated.
 3. Push Plunger (by hand) into top of Cap onto Mechanism barbs. To make sure Plunger is fully seated, put bottom of retracted mechanism against a hard surface and push Plunger on.
 4. Press Cap into Barrel through hole in Clip.
- NOTE: You must press around the top of Plunger. You can use the back of the un-pressed Tip of the pen or a scrap piece of blank with a 3/16" hole drilled into it to press on the rim of Cap without pressing directly on Plunger.
5. A. Press Tip into Lower Barrel.
B. Press Coupler Band into opposite end of Lower Barrel
 6. Slide Spring over front of Refill to back end and insert Refill into opening in Coupler Band. NOTE: Spring will seat at center.
 7. Thread Upper Barrel onto Coupler Band. Screw top and bottom together to complete.
 8. To replace refill: unscrew pen at center. Replace refill, re-seat spring

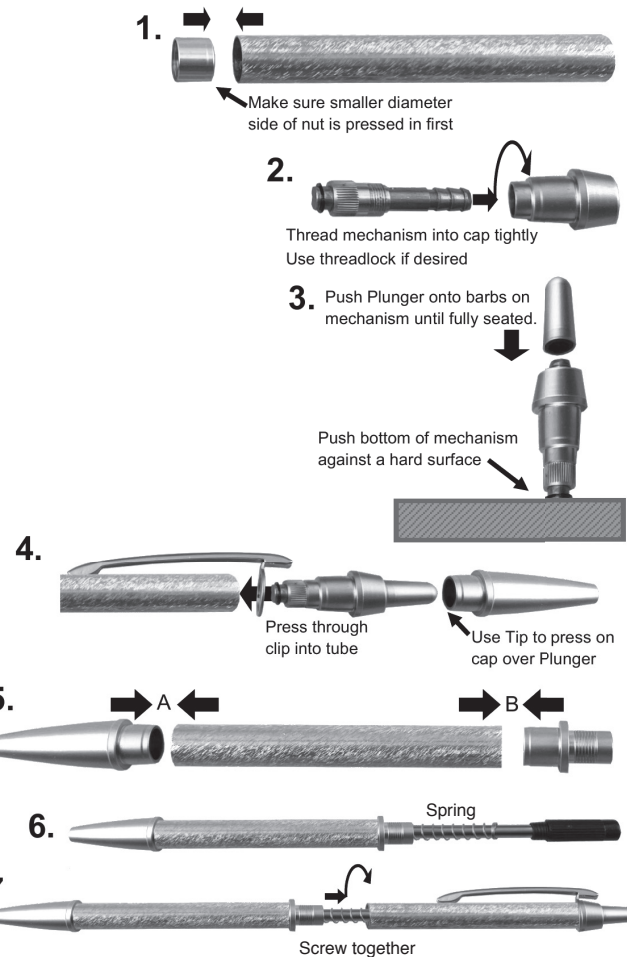


Diagram C / Bushings #PKM-BUSH3

