

BULLET CARTRIDGE CLICK Pen Kit



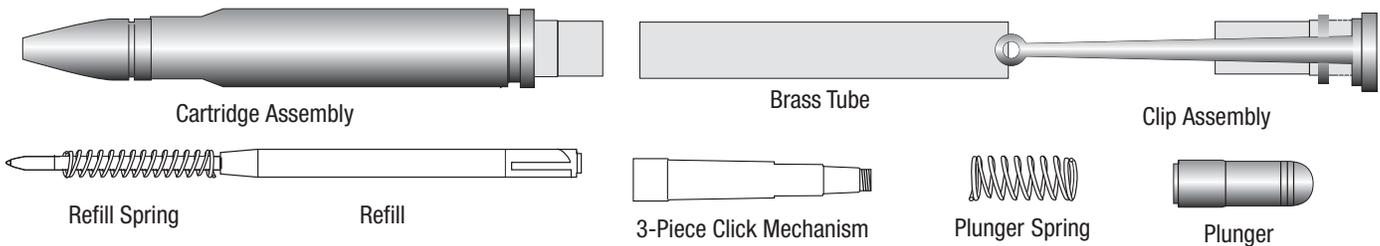
KIT FEATURES

- Replicates an actual 30-caliber shell casing
- Click-type mechanism
- Bull's-Eye Clip Style
- Uses Parker™style refill (Gel Compatible)
- Overall length is 5-5/8"
- Simplified Assembly

REQUIRED ACCESSORIES

- 7mm, Pen Mandrel
- 8mm Drill Bit #PK PARK-8 mm
- 2-piece Bushing Set #PKCP2400 BU
- Universal Barrel Trimmer system #PKTRIMKIT (Use 8mm Shaft)
- 2-part epoxy glue or Insta-cure (cyano acrylate) glue

DIAGRAM A • Parts



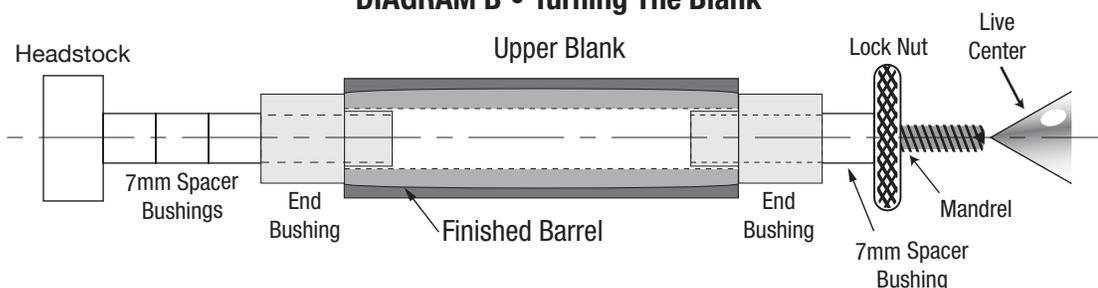
PREPARING THE BLANK

- Cut 5/8" square blank to the size of the Upper Brass Tube. Add 1/16" to each end for squaring off.
- Drill an 8mm hole through the center of the blank.
- Apply glue to the tube and insert it into the blank with a twisting motion to spread the glue evenly. Center the tube within the blank and allow to dry.
- Use a barrel trimmer (#PKTRIMKIT) to square the ends of the blank to the brass tube.

TURNING THE BLANK

- Place spacer bushings on the mandrel. Place one end bushing on, followed by the prepared blank.
- Assemble the second end bushing. Follow with additional spacer bushings as needed.
- Thread the lock nut hand tight onto the mandrel. Do not overtighten, it could damage the mandrel.
- Bring tailstock snug to the mandrel and lock it into place. Tighten the lock nut for turning.
- Using sharp tools, turn the blank down and sand it to the size of the end bushings.
- Finish the blank with your choice of polish.

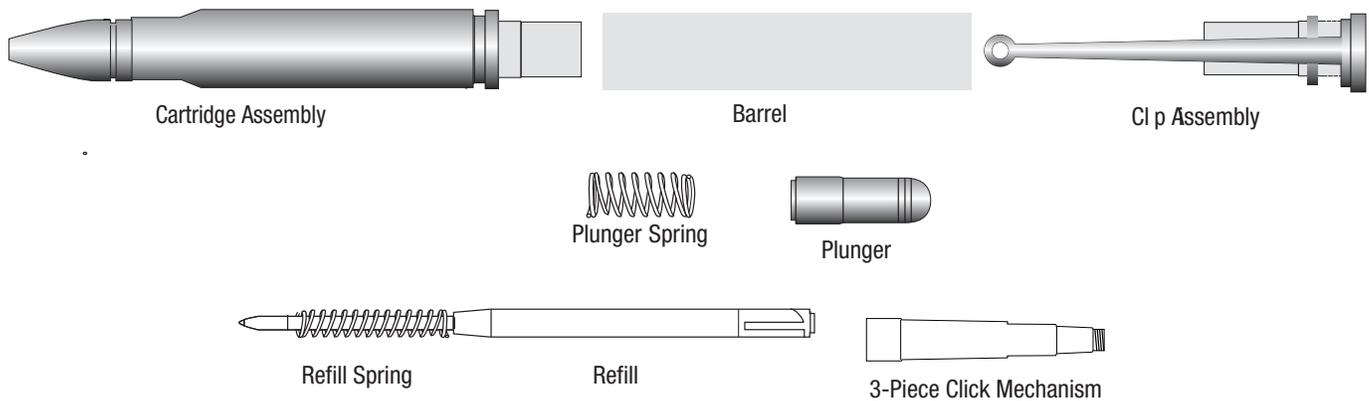
DIAGRAM B • Turning The Blank



ASSEMBLY

- Line up the pen parts according to DIAGRAM C.
- Insert the clip assembly into the barrel, press in.
- Insert the 3-piece mechanism, threaded end in first, into the opposite end of the barrel.
- Press the cartridge assembly into the opposite end of the barrel.
- Unscrew the tip off of the front end of the cartridge assembly.
- Insert the refill spring over the refill end.
- Insert the refill, black end in first into the opening at the tip, screw the tip back on.
- Press the plunger coupler through the clip assembly into the opposite end of the barrel.
- Drop the plunger spring into the opening at the clip end, follow with the plunger, screw in.
- The pen is ready to operate by clicking on the plunger to extract or retract the refill tip.

DIAGRAM C • Assembly



BUSHINGS

DIAGRAM D • PKCP2400BU

