

TACTICAL PEN

Instructions

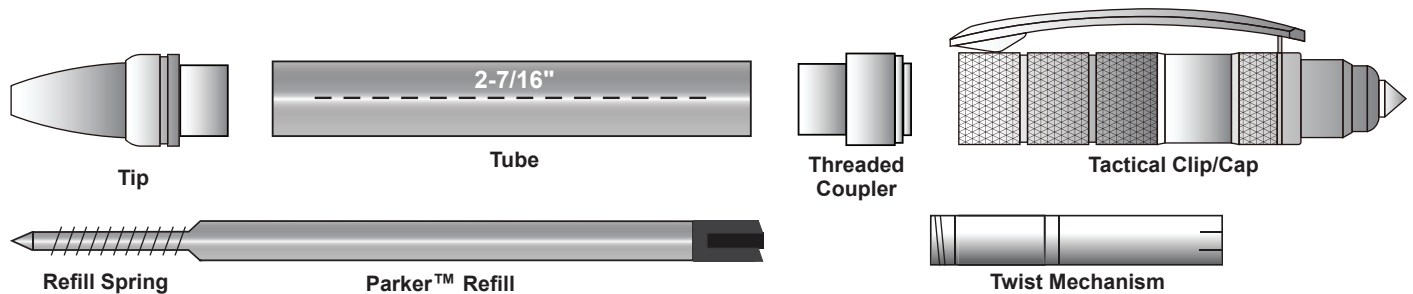
Kit Features

- Twist mechanism
- Parker™ style refills (RE-PARK)
- Overall length: 5-7/8"

Required Accessories & Materials

- 7mm mandrel
- 2-pc. Race Car bushing set (PKRACEBU)
- Drill bit – 3/8" (DB3/8)
- Universal trimming kit (BTRIMKIT9)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Parts and Assembly



BLANK PREPARATION

The Tactical pen has a tube measuring 2-7/16". **Cut** your blanks approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer (carefully trying not to remove any of the brass tube). Use a medium drill speed to **drill** the blank. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blank, **sand** the exterior of the brass tube to roughen its surface and use **CA glue** to glue the tube inside the blank. Sand or barrel trim to **square** the ends of the blank.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. The Tactical pen's upper and lower bushings both have an outside diameter of .475" (see Diagram B). **Turn** the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

ASSEMBLY

(Line up finished parts according to Diagram A)

To avoid damage to components when assembling, use a pen press or a vise with covered jaws.

1. Press the tip into the lower end of the long pen barrel.
2. Press the threaded coupler into the opposite end of the lower pen barrel.
3. Drop the ink refill with the refill spring into the threaded twist holder and screw on the twist mechanism. Check for proper refill retraction. If it doesn't retract fully, the lower tube dimensions have most likely been shortened.
4. Slide the Tactical Clip/Cap onto the Twist Mechanism.

Diagram B - Bushings

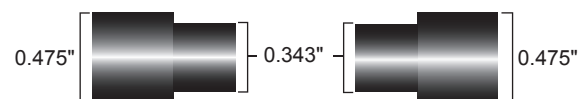


Diagram C - Turning the Pen

