

USA CLICK PEN Instructions

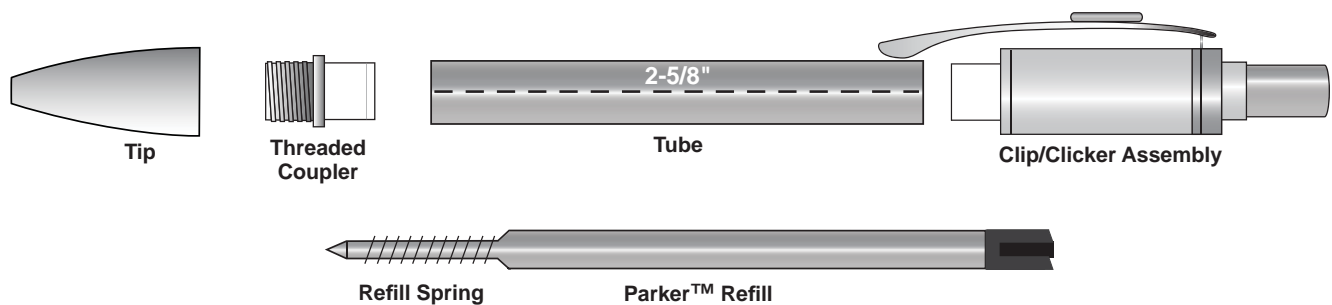
Kit Features

- Click mechanism
- Parker™ style refills (RE-PARK)
- Overall length: 5-1/2"

Required Accessories & Materials

- 7mm mandrel
- 2-pc. Race Car bushing set (PKRACEBU)
- 2-pc. Replacement Tubes (PKUSA-TU2)
- 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 USA Click pen has a tube measuring 2-5/8". **Cut** your blank approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. 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 USA 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 vise with covered jaws or one of WoodTurningz' pen presses.

1. Press the Threaded Coupler into the barrel.
2. Unscrew the plunger at the end and press the Clip/Clicker Assembly into the upper end of the barrel.
3. Slide the spring onto the refill and place inside the assembled Pen Body.
4. Screw Tip onto the Threaded Coupler.
5. Screw the plunger back into place.
6. The pen is now ready to operate.

Diagram B - Bushings

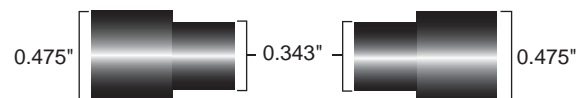


Diagram C - Turning the Pen

