

Every Day Carry (EDC) Dura Click Pen Kit

Kit Features:

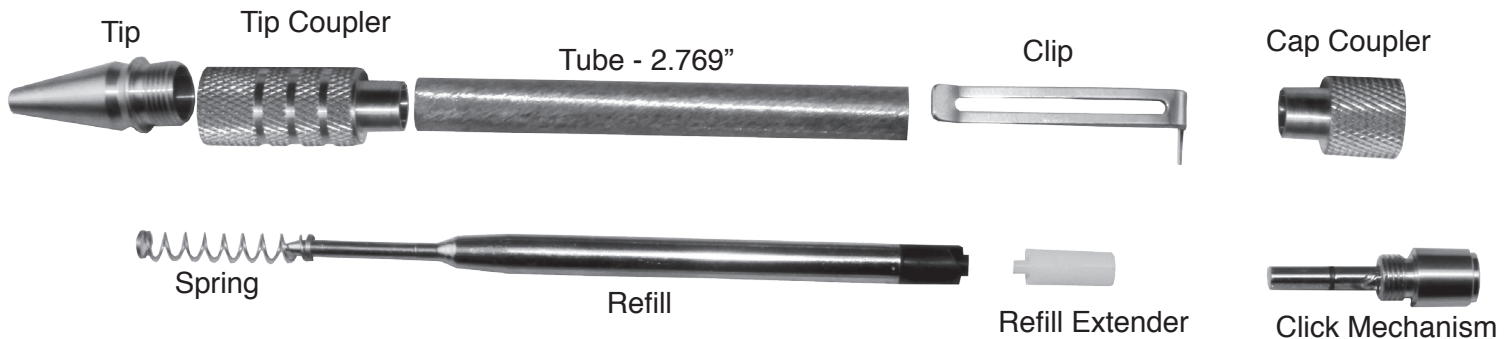
- Knurled design assures a firm grip
- Reliable Schmidt™ Click Mechanism
- Easy to Turn With a single Straight Tube
- Easy to replace mechanism
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-1/2"
- USES REFILL: Parker style #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 8mm #PKPARK-8MM for wood, #PK-8MMSG for plastic
- Bushing Set (2 pc): #PKSPCL3BU
- Barrel Trimming set: #PKTRIM8 or 8mm sleeve from PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 2-13/16"

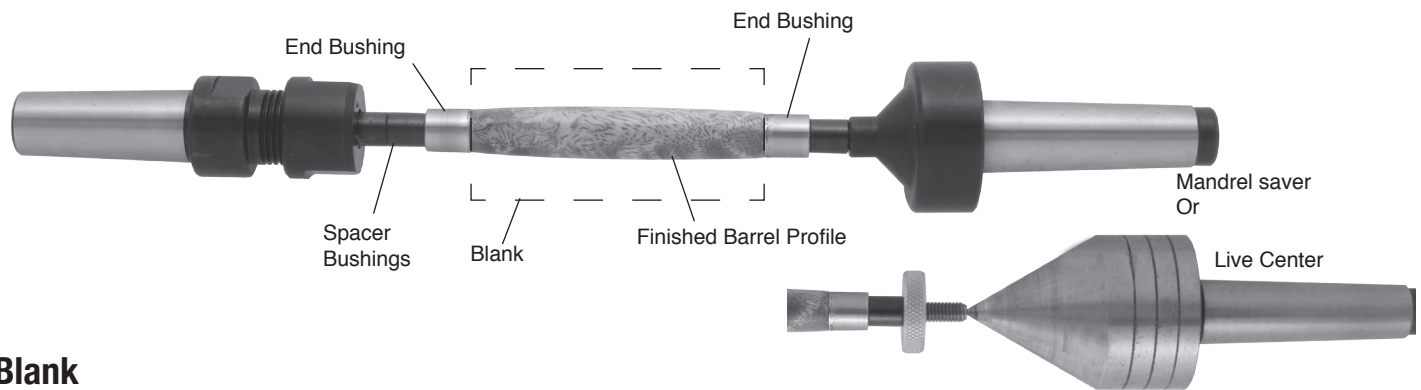


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 8mm hole lengthwise through the blank.
- Spread glue over tube, insert the tube into 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 blanks, making sure the trimmed ends are 90° to the tube. Use 8mm barrel trimmer, or a pen blank squaring jig with 8mm sleeve on 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 barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

Assembly

- Press Tip Coupler into either end of Barrel
- Insert Cap coupler through Clip ring and Press into open end of Barrel.
- Thread Click Mechanism into Cap Coupler
- Insert the post of the Refill Extender into the back of the Refill.
- Insert Refill into opening of Tip Coupler and slide Spring onto the Refill shaft.
- Thread Tip over the Refill and into the Tip Coupler.
- To extend Refill, push on the click mechanism. Push again to retract.
- To change Refill, Unscrew cap and replace. Remember to switch Spring and Refill Extender to new refill when changing.

Diagram C / Bushings #PKSPCL3BU