

Police Click Pen Kit

Kit Features:

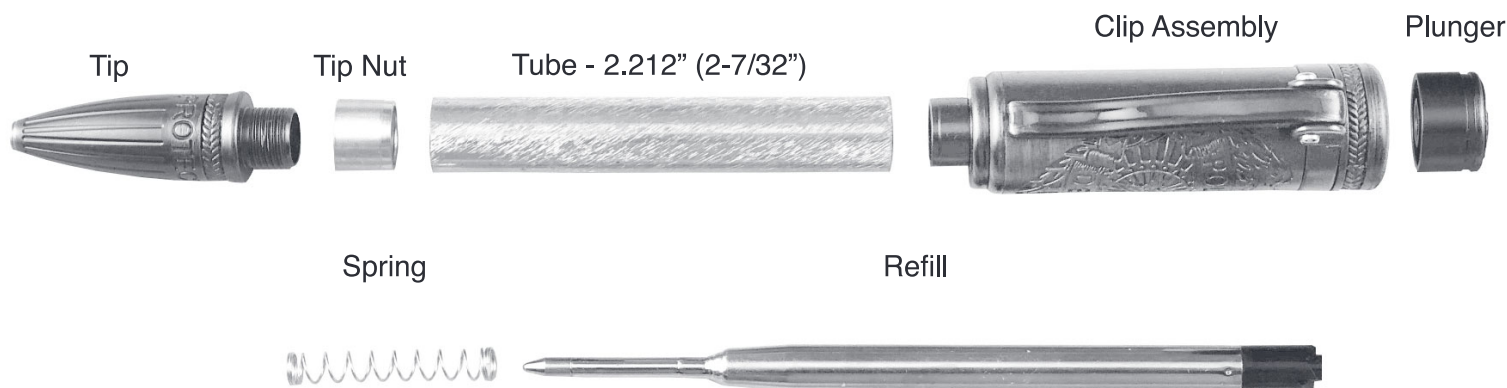
- Decorated to Honor Those Who Protect and Serve
- Accessible Smooth & Silent Click Mechanism
- Reliable and Solidly Weighted
- Minimal Parts - easy to assemble
- Spring Clip
- Available in multiple finishes
- Overall Length: 5-5/8"
- USES REFILL: #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: #PKEXEC-38 for Plastic, #PK-38BP for wood
- Bushing Set(2 pc): #PKPOLICEBU
- Barrel Trimming set: #PKTRIM38 or 3/8" sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 2-1/4"L



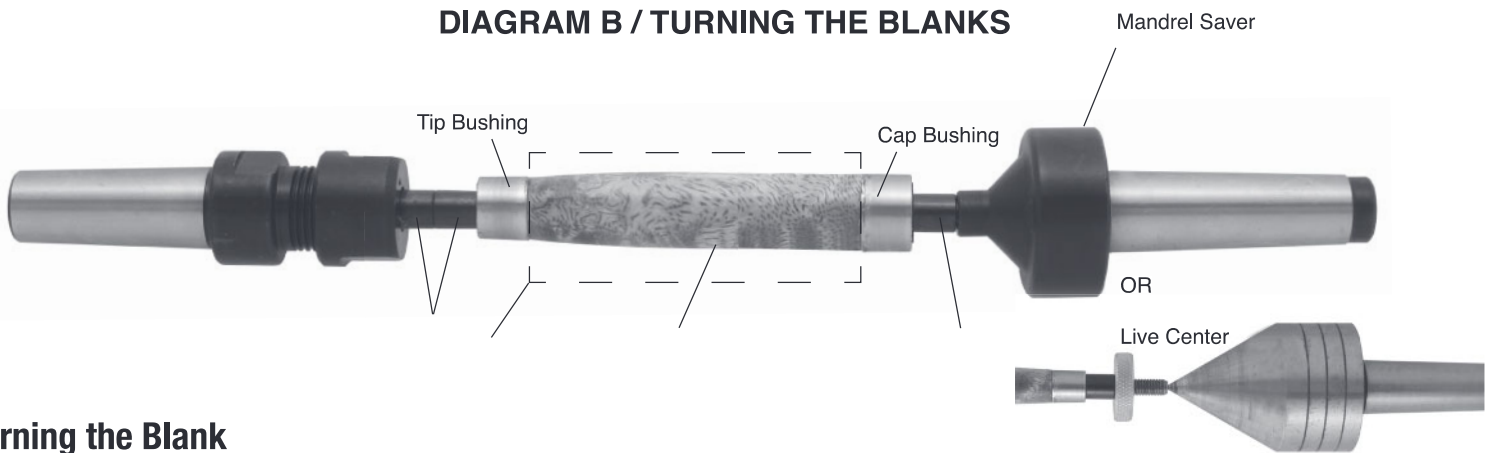
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the to the length of the tube, adding 1/16" for squaring off (approx. 2-1/4")
- Drill 3/8" 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 a 3/8" barrel trimmer, or a pen blank squaring jig with a 3/8" 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 Nut into smaller diameter side of barrel. Tip nut has a recess on one side; this recess must go into tube first.
- Press Clip Assembly into larger end of barrel.
- Insert Refill into opening.
- Place spring, narrow side first, over refill shaft.
- Thread Tip into Barrel, over Refill.
- Thread Plunger onto Mechanism inside of Clip assembly – **IMPORTANT NOTE:** do not overtighten the plunger. If you feel the plunger click while threading over mechanism, you have overtightened. If this occurs, do not press the plunger down into the mechanism trying to test it. Instead, immediately turn the plunger counter-clockwise until you hear a click again. Leaving this overtightened causes the mechanism to misalign internally and may not click properly.
- To extend and retract refill, press on plunger.
- To change refill, unscrew tip from barrel. Be careful not to lose spring when changing refills.

Diagram C / Bushings #PKPOLICEBU

