

Mini Bolt Action Keychain Pen Kit

Kit Features

- Reliable Bolt Action mechanism
- Clean, Compact Styling
- Easy to Turn with a single tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 3-13/16"

Required Accessories

- 7mm Pen Mandrel
- Drill Bit: #PK-7MM or Wood, #PK-7MMSG for Plastic
- Bushing Set(2pc): #PKCPMINBU
- Barrel Trimming: #PKTRIM7 or #PKSQUARE Jig and Disc Sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 1-11/16"L
- Replacement Refill - 5 pack #PKMINI-R5 black ink



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 7mm 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 7mm Barrel Trimmer or a pen blank squaring jig 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 assembly and the operation of the mechanism. Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANK



Turning the Blank:

- Mount the bushings and blanks according to diagram B. Spacers can be added to provide extra working room.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To Used Knurled Nut setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- 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 and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- 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.

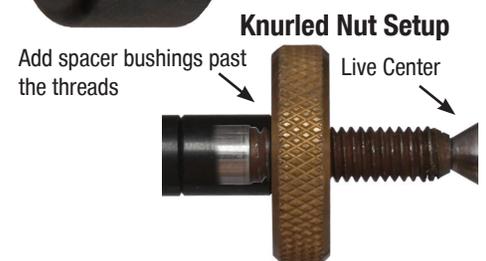


Diagram C / Bushing #PKCPMINBU

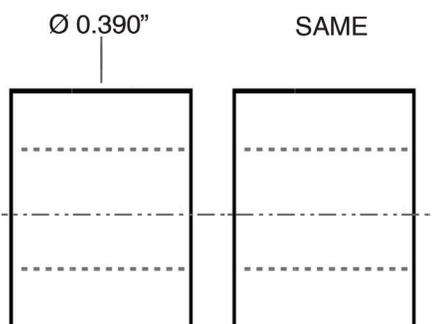
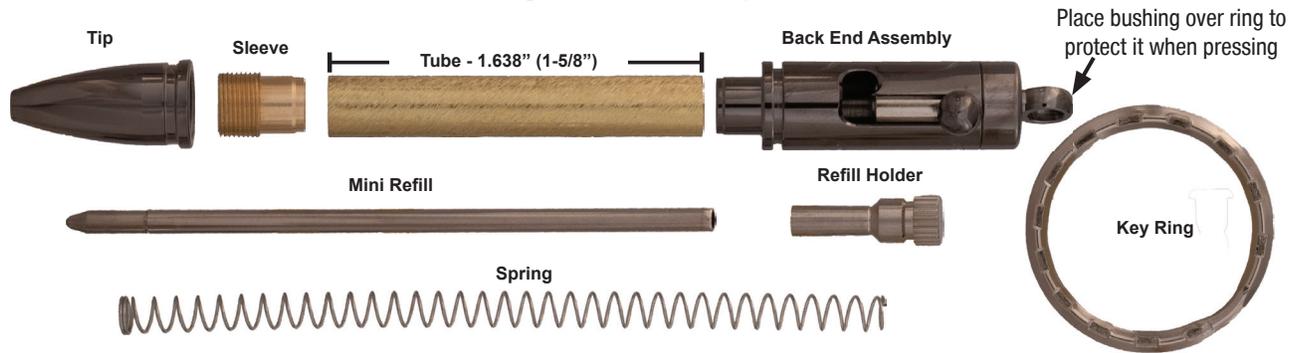


Diagram D / Parts Layout

**Assembly:**

- Press Sleeve, reduced diameter first, into either end of the the Barrel.
- Placing one of the bushings over the ring on the end to protect it, press the Back End Assembly into opposite, open end of Barrel.
- Make sure refill holder is fully on the back of the Mini Refill.
- Slide Spring over the tip of the refill. Tapered side of Spring should go onto the refill first. Spring should stop at Refill Holder; it should not slide over it.
- Insert Refill into the opening in the Sleeve.
- Thread Tip, over the Refill and Spring, onto the Sleeve.
- Attach Key Ring to the Back End Assembly.
- To extend Refill slide the bolt down and over into the locking slot. Retract by moving the bolt out of the locking slot.
- To change refill, carefully unthread tip. Be sure to hold onto tip when removing. Spring can launch the tip and itself away from pen and get lost. Remove Refill Holder from old Refill and transfer it and spring to the new Refill.