

Stratus Click Pen Kit

PKKPEN24 • PKKPENCH • PKKPENGM • PKKPENBE

Kit Features:

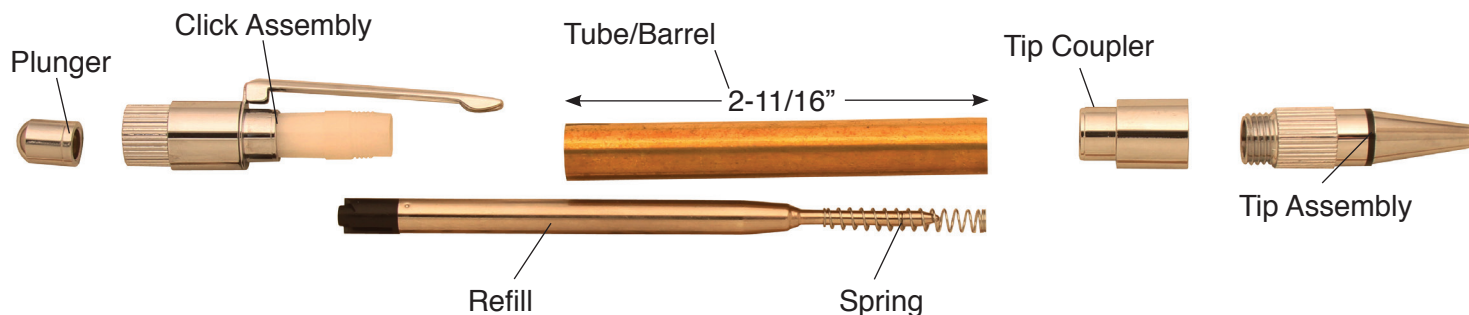
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker style refill
- Overall Length: 5-1/2"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-3/8
- PKCHPENBU Bushing set(2 pc)
- PKTRIM38 Barrel Trimming set
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 5/8" x 3"L

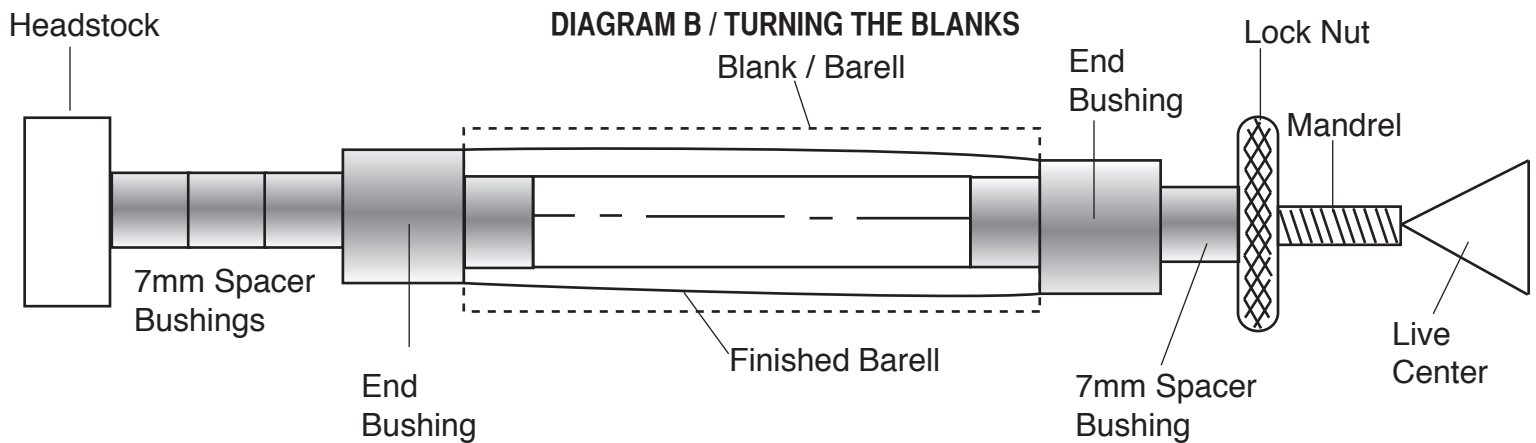


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert 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 blank. You can use a barrel trimmer. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly).



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 in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel).
- 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 the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure. Refer to polish instructions.

Assembly

- Layout parts according to diagram A
- Press the click assembly, recessed extension in first into either end of the barrel.
- Press the tip coupler, recessed extension in first into the opposite end of the barrel.
- Insert the spring over the refill and drop into the opening at the tip coupler.
- Screw the tip assembly over the refill.
- Screw the plunger over the threads at the click assembly opening.
- The pen is ready to use by clicking the plunger to advance or retract the refill tip.

Diagram C / Bushings #PKCHPENBU

