

# Dog Click Pen Kit

## Kit Features:

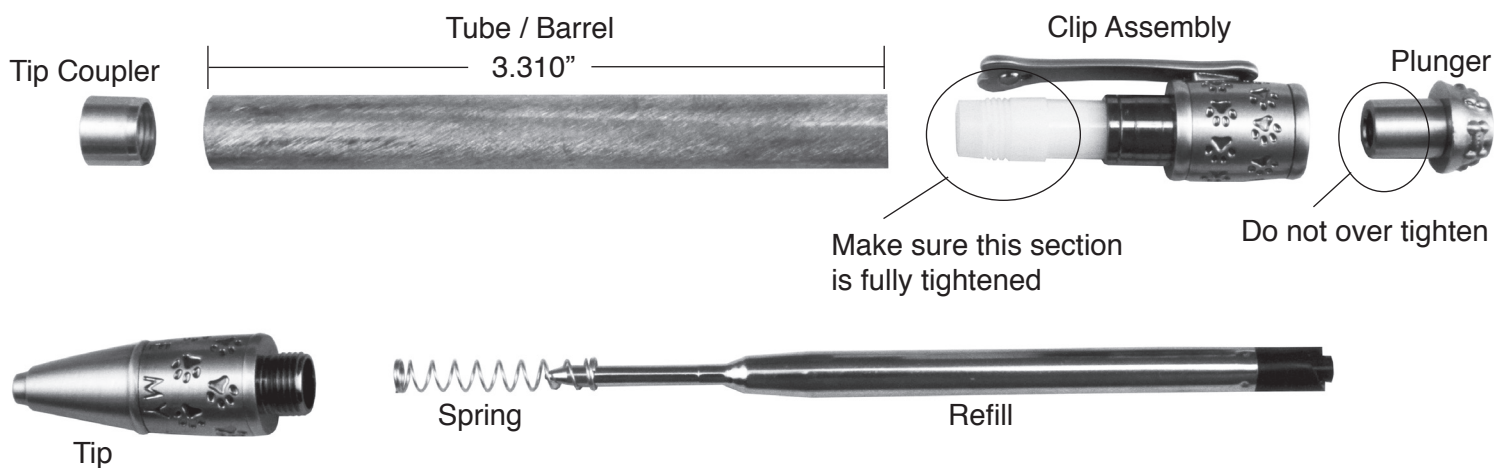
- Fun and Whimsical Design
- Extra Long Barrel to Display Your Creativity
- Easy to Turn with Straight Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-3/4"
- USES REFILL: #PKPARK-R5

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38 for Plastic or #PK-38BP for wood
- Bushing Set (2 pc): #PKMAJSQBU
- 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 3-3/8"



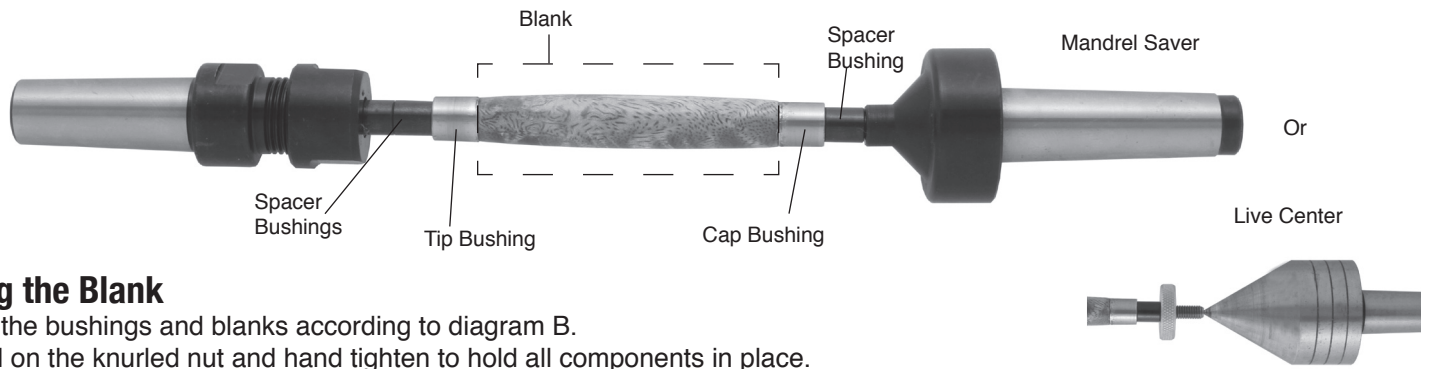
## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 3/8" hole lengthwise through the blank – Blank length may require re-positioning Blank to fully drill hole.
- 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 blank, 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.

**There are several methods to decorate a pen tube with a printed or published image. These include:** Decals, labels, stamps, photos, printed images off a computer. Regardless of the method you should follow these steps on wood and or plastic:

- Apply image to align with tip and band. Background color should match blank color as closely as possible (A clear “decal” or “cutting” out the figures is an option to eliminate this problem. Secure the image firmly to the blank and allow any adhesive to dry.) If image does not have adhesive backing - use 2 faced tape
- Seal over the image with a spray sealer, Mod Podge craft sealer or any glue that dries clear. Allow the sealer to dry completely.
- Use CA glue finishing techniques over the sealer to give a shiny, clear acrylic like seal over the image.

### Assembly

- Lay out Parts according to Diagram A.
- Press Tip coupler into either end of Barrel.
- TIP: Examine Click Assembly and make sure plastic mechanism is threaded tightly into bottom of sleeve to prevent malfunction. (See Dia A)
- Press Click Assembly into opposite end of Barrel.
- Thread Plunger into top of Click Assembly. Do not over-tighten!
- Insert refill into Tip Coupler.
- Place Spring onto Refill shaft
- Screw Tip over Refill into Tip Coupler
- To extend and retract pen tip, push down on the plunger.
- To change the refill, unscrew Tip from Tip Coupler. Be careful not to lose spring when transferring to new refill.

### Diagram C / Bushings #PKMAJSQBU

