

SAXA EDC CLICK PEN KIT

Kit Features

- Easy to Turn with Straight Tube
- 7mm single tube click design
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-25/32"
- Flawless Schmidt® click mechanism

Required Accessories

- 7mm Pen Mandrel
- Drill Bit: #PK-7MM for Wood, #PK-7MMSG for Plastic
- Bushing Set(3pc): #PKM-BUSH3 (use any two)
- Barrel Trimming: #PKTRIM7 or squaring jig on 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 3-3/16"L



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.
- 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 use 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 manufacturer's instructions.

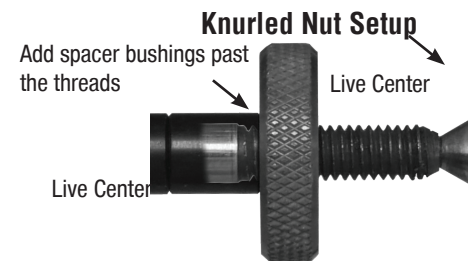


Diagram C / Bushing #PKM-BUSH3
(use any two)

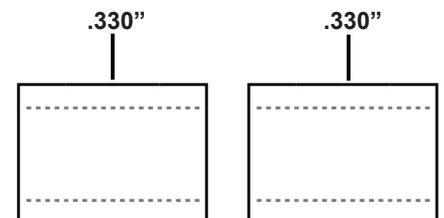
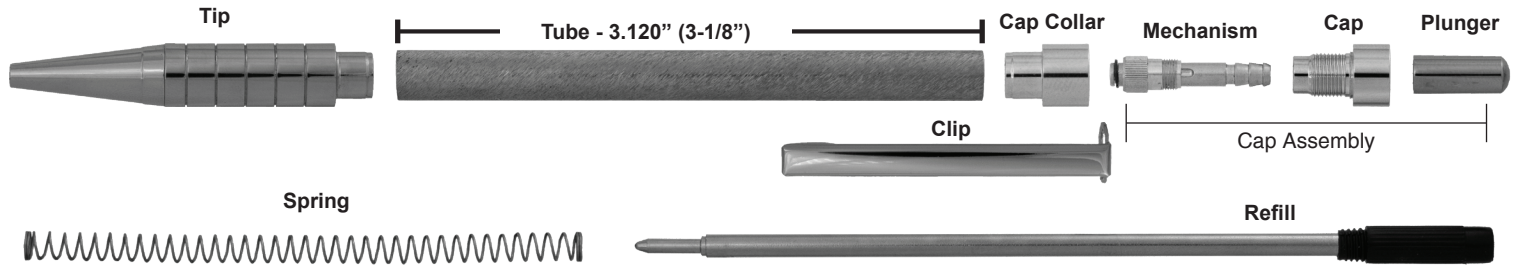


Diagram D / Parts Layout

**Assembly:**

- Press Cap Collar, reduced diameter first, into either end of Barrel. Note: if you prefer the Clip to be lower, Cap Collar can be pressed through the Clip at this stage (see diagram E)
- Press Tip into remaining, open end of Barrel.
- Slide Spring onto Refill Shaft.
- Slide Refill into opening in Cap Collar.
- Make sure Mechanism is firmly threaded into Cap.
- Push Plunger onto Mechanism barb through the opening in the top of the Cap.
- Thread Cap assembly (with plunger & mechanism attached) into Cap Collar, If you prefer the clip to be higher, then Clip can be held between the Cap assembly and the Cap Collar at this stage.
- To extend and release refill, push down on plunger.
- To change Refill, unscrew Cap assembly from Cap Collar.

Diagram E / Clip Position Options

