

Medical Care Click

Product : #186189, #186190, #186191

2/13/2023



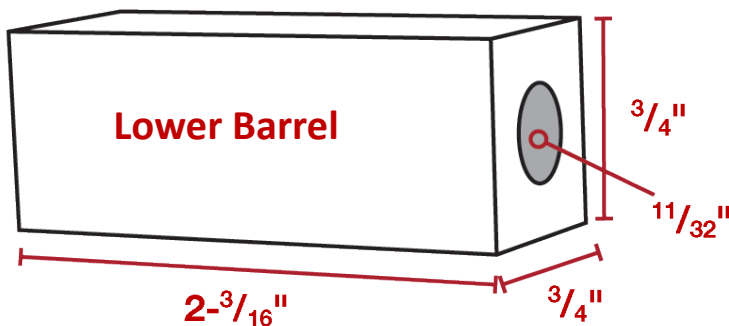
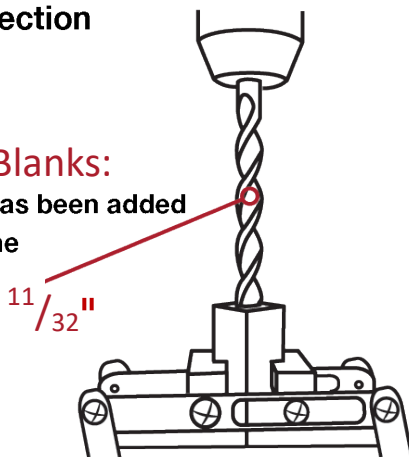
From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- ❑ 11/32" Pen Maker's Bit (149132)
- ❑ 3/4" x 3/4" x 2-3/16" Pen Blank Lower Barrel
- ❑ 3/4" x 3/4" x 2" Pen Blank Upper Barrel
- ❑ Letter "O" Pen Reamer Pilot Shaft (153204)
- ❑ Pen Mandrel
- ❑ Medical Care Pen Kit Bushings (186192)
- ❑ Thick CA or 5 Minute Epoxy
- ❑ Drill or Drill Press
- ❑ Sandpaper/Micro-Mesh
- ❑ Barrel Trimmer
- ❑ Pen Press
- ❑ Eye & Ear Protection
- ❑ Dust Mask

Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.

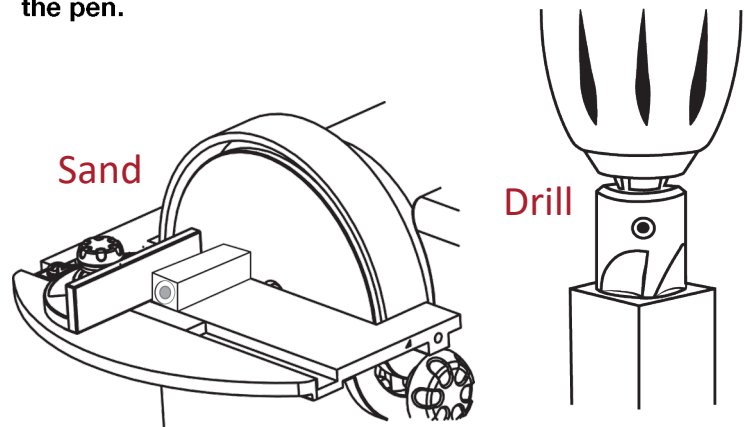


Gluing Blanks to Tubes:

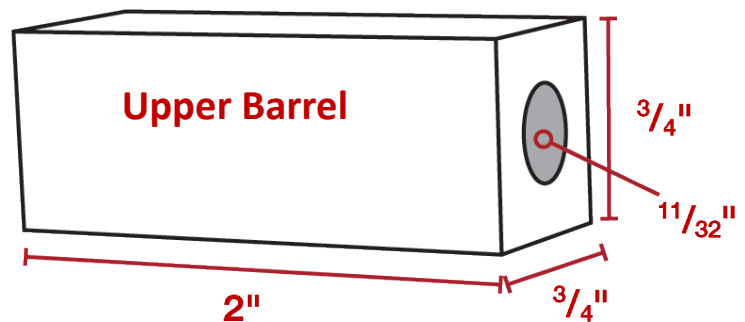
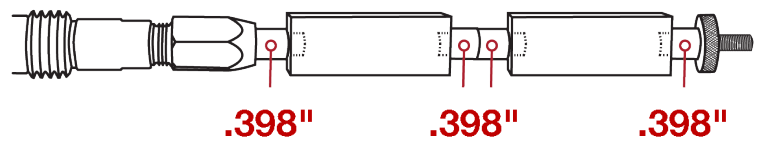
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.

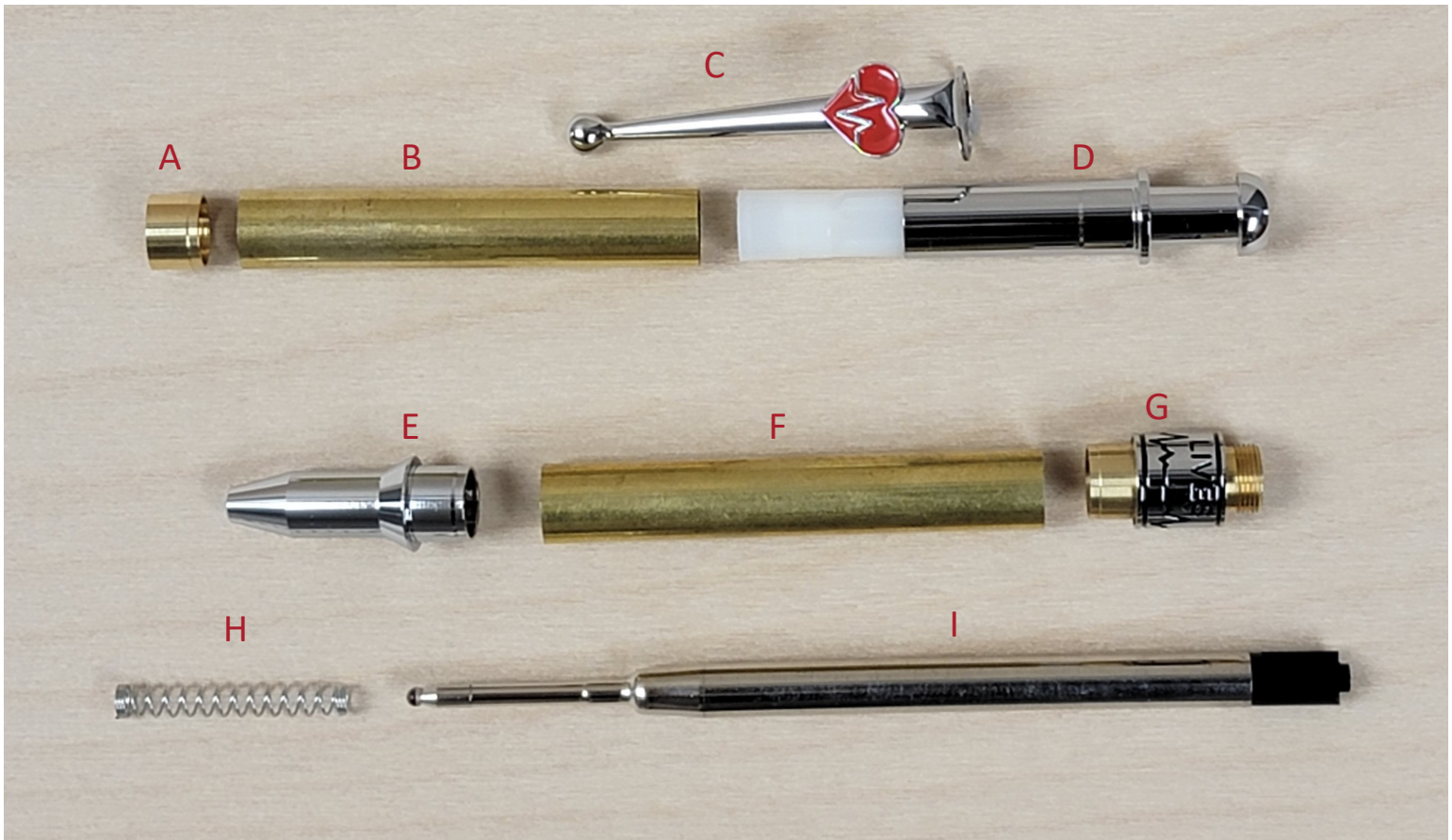
Squaring the Blank to Length:

When squaring the blanks work only the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.



Mandrel Preparation:





Turning & Finishing the Blanks:

Turn the blank to your desired profile, leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120-grit paper, progress through the finer grits, finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

Assembly:

- Press Threaded Coupling (A) tapered end first into one end of Upper Barrel (B).
- Next slide Clip (C) onto Click Mechanism (D) and press into the other end of Upper Barrel (B). Note: Do Not Press Directly on the Click Mechanism. Use of a press block will be needed to complete this step. Using a scrap block of wood drill a $\frac{3}{8}$ " diameter x $\frac{9}{16}$ " deep hole. Slide press block over the Click Mechanism and press into place.

- Press Nib (E) into one end of Lower Barrel (F).
- Press Center Band (G) into other end of Lower Barrel (F).
- Slide Spring (H) onto the end of Ink Refill (I). Insert Ink Refill Assembly down through Center Band (G).
- Thread Upper Barrel Assembly onto Center Band (G).

To advance the ink refill push down on click mechanism, to retract the ink refill press the click mechanism again.