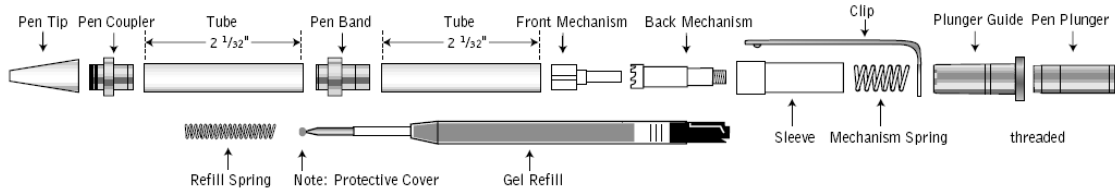


# GEL CLICK PEN INSTRUCTIONS



## KIT FEATURES

- Heavy Plating W/ Epoxy Coating
- N Tenons Required
- Overall Length: 5 $\frac{3}{8}$ "

## Blank Preparation

1. Cut your blanks from  $\frac{3}{8}$ " stock, cut the blanks at least  $\frac{3}{8}$ " longer than the tube to accommodate drilling and squaring the blank.
2. Drill an 8mm hole lengthwise through the center of each blank. To prevent breaking the blank, do not drill through the bottom of the blank. Only drill as deep as necessary to accommodate the tube and then cut off the excess on your band saw.
3. Sand the tube to create a rough surface for the glue to adhere to. Using Epoxy, CA or Gorilla Glue; spread the glue on the tube and insert the tube into the blank with a twisting motion to smooth out the glue into all areas. Center the tube in the blank and allow it to dry.
4. Using an 8mm barrel trimmer, or other sanding device, trim the ends of the blank flush to the ends of the tubes. **DO NOT TRIM INTO THE BRASS**, this will make your blanks too short and will result in kit failure in that the refill will not retract fully into the tip.

## Turning Sanding and Finishing the Blanks

1. Place the bushings and blanks on the mandrel, all bushings are the same outside diameter
2. Turn the blanks down to about the thickness of a fingernail above the bushings.
3. Sand the blanks starting with the coarse grit and move up to the desired smoothness. We recommend using Micromesh and sanding to 12000 grit.
4. Be sure the blanks are smooth to the bushings for a good fit of the parts.
5. Apply your finish choice

## REQUIRED ACCESSORIES

- 7mm mandrel
- 3 Piece Bushing Set PEN-XXBU
- 8mm Drill Bit
- 8mm Barrel Trimmer
- Your Choice of Adhesive

## Assembly

1. Line up the parts as seen in the picture above.
2. Press the Pen Couplers non-threaded end into the tip end of the lower barrel.
3. Press the short end of the center band into the opposite end of the lower barrel.
4. Insert the 3 part plastic mechanism (follow diagram) narrow diameter of the sleeve in first (threaded stub pointing upward) push in until flush with tube edge. Slide the lower barrel with the center band longer extension into the upper barrel pushing the mechanism sleeve further inside. Continue by pressing the remaining extension inside.
5. Slide the plunger guide, narrow end first into the clip hole. Press this assembly into the opposite end of the barrel.
6. Insert the refill through the coupler & push the mechanism towards the clip end until the threaded end of the back mechanism is held close to the end of the plunger guide. A little jiggling of the parts inside may be necessary to accomplish this and get everything lined up.
7. Drop in the mechanism spring over the threaded stem & screw the plunger onto the thread and tighten. Finger tight is adequate.
8. Slide the refill spring over the refill and screw on the pen tip to the coupler.
9. Your pen is now ready for operation.
10. Ballpoint Parker Style refills may also be used in this pen Item #PARKR5

For questions concerning this kit call Wood-N-Whimsies at 1-800-820-1099 or email us at [woodnwhimsies@woodnwhimsies.com](mailto:woodnwhimsies@woodnwhimsies.com)