

GUARDIAN PEN

KIT FEATURES

- Heavy plating w/ epoxy coating
- Wide rubber grip is easy to hold in a contemporary design.
- Convenient click mechanism with gel ink refill.
- Oversized designs are better for arthritis sufferers.
- Parker™ style gel refill - PKPARK-R5
- Overall length: 5-1/2"

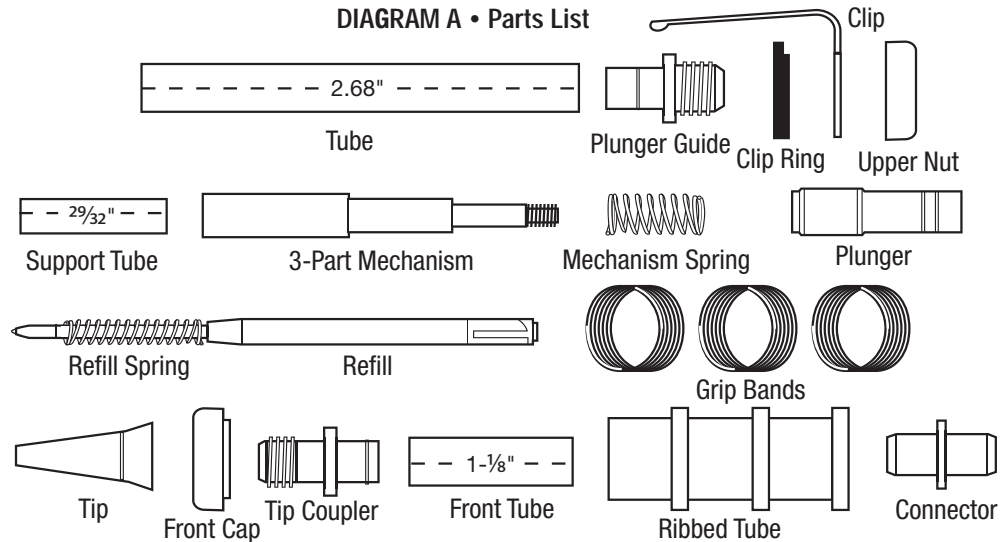
REQUIRED ACCESSORIES

- 7mm pen mandrel
- 8mm drill bit - #PKPARK-8MM
- 2-pc bushing set - #PKGDPENBU
- Universal barrel trimmer - PKTRIMKIT
- 2 part epoxy #PKGLUE2 or insta-cure (cyanoacrylate) glue

PREPARING THE BLANK

- Cut 3/4" or larger pen blank to the size of the brass tube (add 1/16" for trimming). Mark the center blank.
- Drill an 8mm hole through the blank.
- NOTE:** Sand tubes with 220 grit abrasive for better adhesion.
- Spread glue over tube and insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center tube in blank.
- When glue dries trim the ends of the blank. Trim the excess wood down to the brass tube.

DIAGRAM A • Parts List



TURNING THE BLANKS

- Place 7mm spacer bushings onto the mandrel, followed by tip bushing, wide end in first. Place the barrel over the bushing. Slide on the cap bushing, narrow end first. Add spacer bushings as necessary. Thread on the lock nut; hand tight over the mandrel shaft. Bring the tailstock snug to the mandrel and lock it in place. Tighten the lock nut for turning. Do not over tighten the nut, it could damage the mandrel.
- Turn the wood down in a straight profile and sand to the bushing diameter.
- Finish the wood with your choice of polish.

DIAGRAM B • Turning the blank

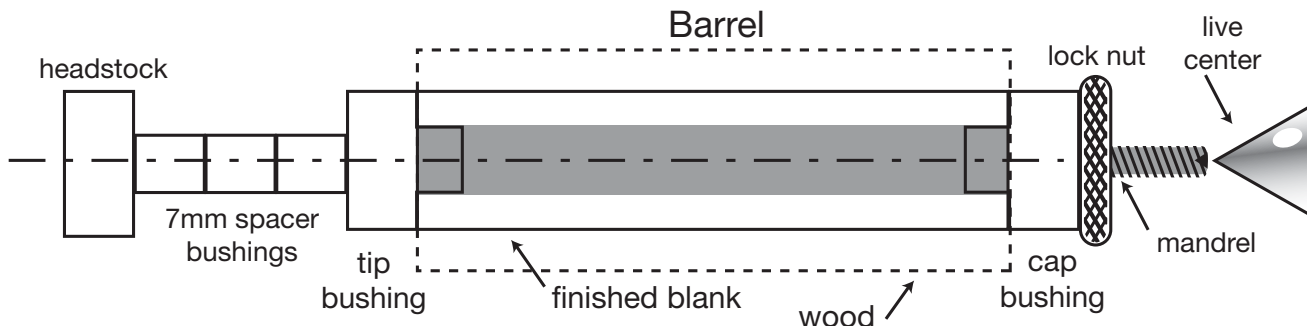
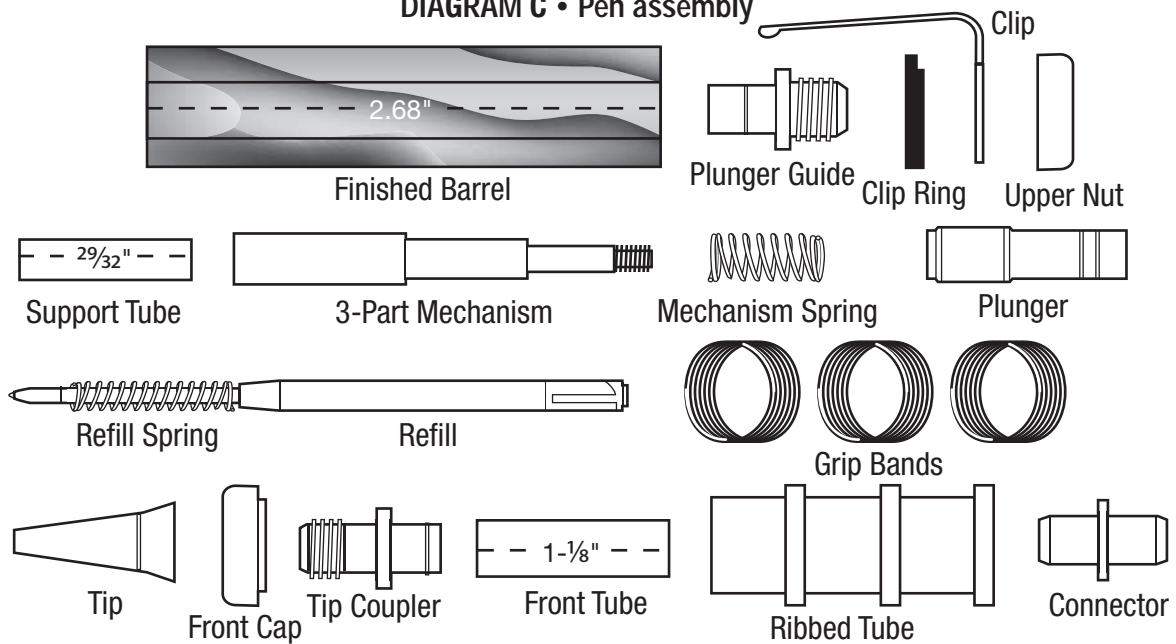


DIAGRAM C • Pen assembly



PEN ASSEMBLY

NOTE: Line up the components according to Diagram 'C'. To avoid damage to components when assembling pen use vise with covered jaws or PSI #PENPRESS3.

- Press the plunger guide into the top of the barrel.
- Insert the 3 part plastic mechanism, threaded end in first into the bottom of the barrel. Follow with the support tube.
- Press the connector into the barrel after the support tube.
- Press the front tube into the connector.
- Press the front coupler into the opposite end of the front tube.
- Wrap the grip bands around the ribbed tube.
- Insert the front cap over the unribbed end of the ribbed tube.
- Insert the above assembly over the front tube, uncapped side in first.
- Insert the refill and spring, black end in first into the opening. Thread the tip over refill until it bottoms.
- Insert the mechanism spring into the opening at the top of the pen. Insert the plunger, open end first and thread over the plastic threads until tight.
- Insert the clip ring, flat end first, over the threads. Place the clip into the slot in the clip ring.
- Thread the upper nut and tighten.
- Operate the pen by clicking on the plunger.

DIAGRAM D • PKGDPENBU

