

Lever Action Rifle Pen Kit

Kit Features:

- Unique and Authentic Lever Action
- Designed to Simulate a Genuine Rifle
- Customize your own Gunstock (Optional)
- (Band saw and sanding disc recommended for this)
- Easy to Turn With Straight Tubes
- Minimal Parts – easy to assemble
- Available in multiple finishes
- Overall Length: 6-3/8" (May Vary with custom Gunstock)
- Uses Parker Style Refill: #PKPARK-R5

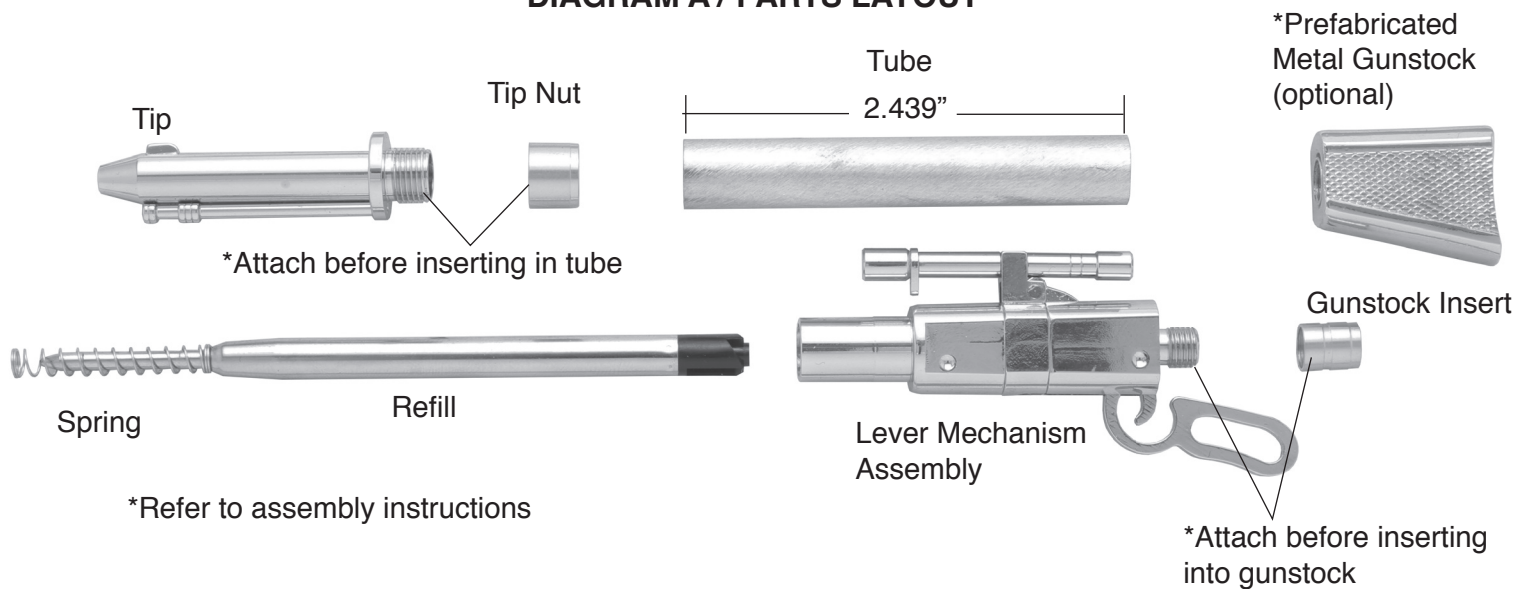


NOTE: *Gun stock NOT included w/ kit
– Purchase #PKLEVGSXX for fabricated gunstocks

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 10mm #PK10-10 and PK-7MM (for custom Gun Stock)
- Bushing Set(2 pc): #PKLEVBU
- Barrel Trimming: #PKTRIM10 or 10mm sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue and Masking Tape
- Pen Blank Minimum Size: 3/4" x 3/4" x 2-3/4"L & 3/4" x 3/4" x 1-1/16"L for Gunstock

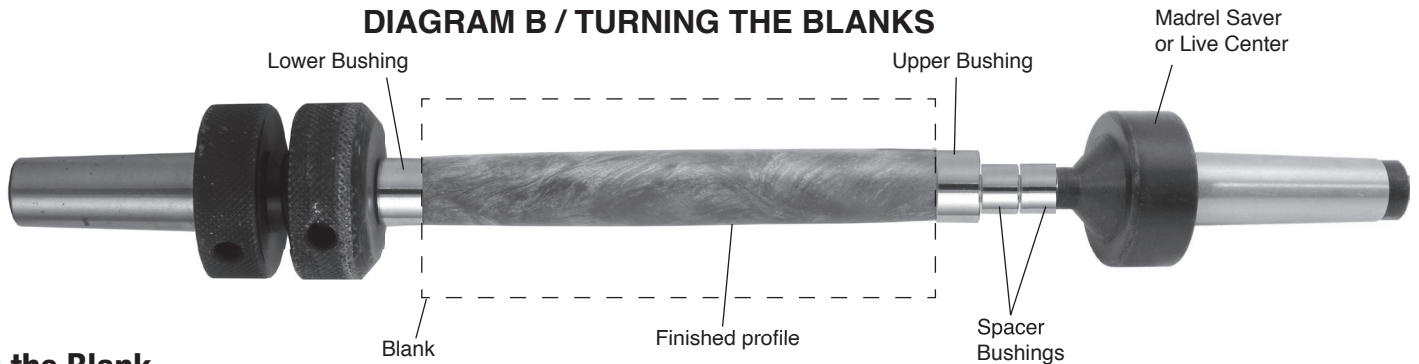
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 10mm 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 10mm barrel trimmer, or a pen blank squaring jig with a 10mm 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

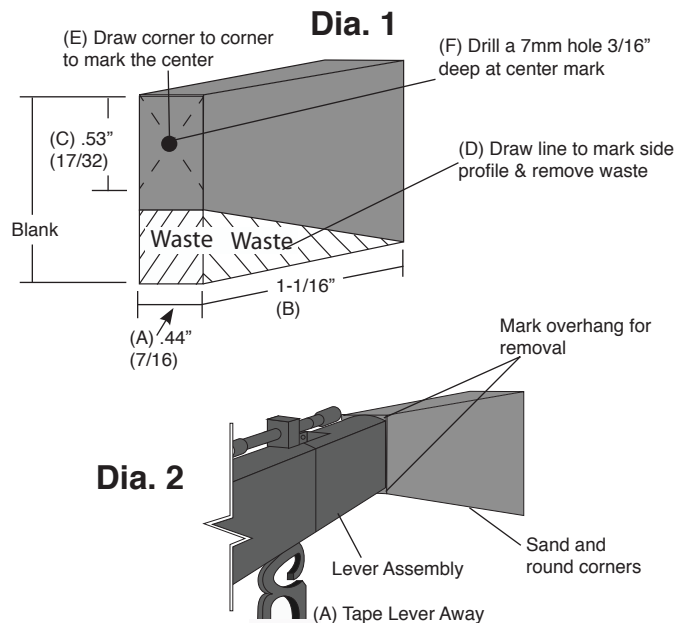


Turning the Blank

- Mount the bushings and blank 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.

Making Custom Gunstock: We recommend using scrap piece from the same blank that barrel was cut from. Use Diagrams 1 & 2 for reference.

- Mark top of piece with a line .44" (7/16") from edge (see Diagram 1.A). Cut piece lengthwise along line. Alternative, you can use a Sanding Disc to reduce piece to the correct thickness. Cut Blank to 1-1/16" long. (1.B)
- Mark a line across the front end .53" (17/32") from the top of the blank (1.C). Draw line on side from this mark to bottom, back corner. (1.D)
- Draw an X from corner to corner on front end to mark center (1.E)
- Drill 7mm hole 3/8" deep at center mark (1.F).
- Cut away waste from bottom front corner area along the line made (1.F).
- Glue Gun Stock Insert as described in Gluing Gun Stock Instructions below.*
- Thread Gunstock back on (Dia. 2). Use pencil to mark end where it overhangs the Lever Assembly. You can now remove tape from Lever.
- Sand and polish Gunstock, rounding the corners to desired shape. Shape the front section to match the marks made in previous step. (2.C)



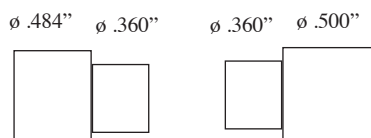
***Gluing Gun Stock to Gunstock Insert:** This procedure must be done for both custom and pre-fabricated Gunstocks.

- Take one of the plastic bags from the kit parts and push it onto the threaded post on Lever Assembly until post breaks through plastic to form seal around post. This will protect parts from getting glued together
- Thread Gun Stock Insert fully onto Lever Assembly.
- Use tape to hold Lever away from Assembly.
- Mix a small amount of 2part Epoxy and spread thin layer inside hole in Gunstock and on the outside of Gunstock insert.
- Push and twist Gunstock Insert into hole in gunstock. Position gunstock blank with Lever Assembly so the edges align. Use Tape to hold together and allow glue to cure.
- Unscrew Gunstock and remove plastic.

Assembly:

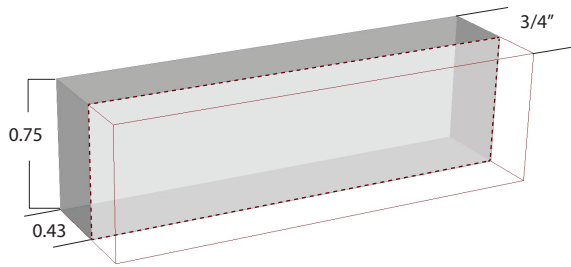
- Lay out parts according to Diagram A
- Thread Gunstock onto Lever Assembly.
- Align and press Lever Assembly into Larger end of Barrel.
- Thread Tip Nut onto Tip, align with Lever Assembly and press into open end of Barrel.
- Unscrew Tip and insert Refill. Place Spring over tip of Refill and screw tip back in place.
- Install Gunstock.
- To operate pull back of lever down and away from the stock until mechanism clicks.
- To change Refill, unscrew tip. Remember to switch the spring onto new refill.

Diagram C / Bushings #PKLEVB

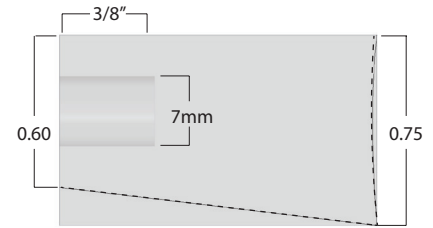


GUNSTOCK FOR PSI LEVER ACTION PEN

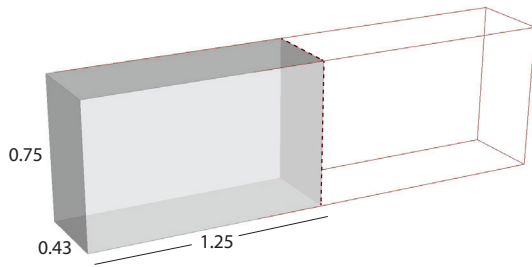
1. Cut 3/4" blank 0.43" lengthwise.



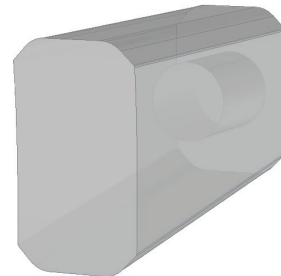
5. Mark and cut to shape.



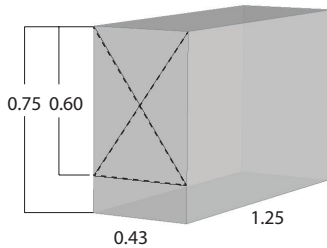
2. Cut to 1.25" long.



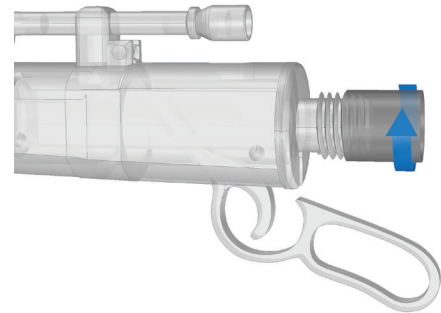
6. Sand edges to shape.



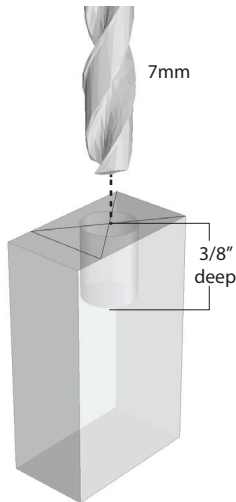
3. Measure 0.6" from top- draw cross edge to edge.



7. Tighten fitting onto body.



4. Drill 7mm hole through X 3/8" deep.



8. Glue in gunstock.

