

Smitty's Pen Works

Instructions for Le Roi Elegant click pen kits

REQUIRED ACCESSORIES

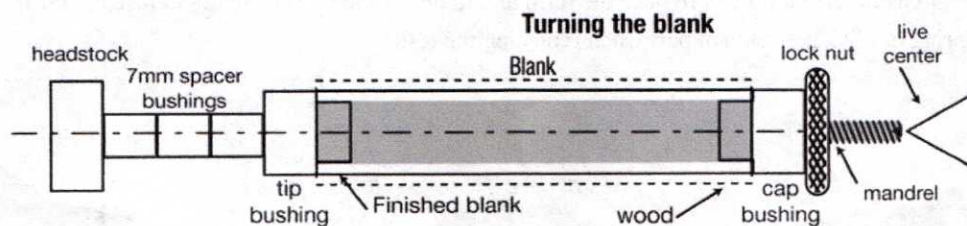
- 7mm pen mandrel
- 2-pc bushing set
- 27/64" drill bit
- *Barrel trimming sleeve
- *Universal trimming kit
- 2-part epoxy glue or other suitable glue

Preparing the Material Blanks

1. Only 1 material blank is required for this pen. Cut the material blank slightly longer than the brass tube.
2. Drill the blank through the center with a 27/64" drill bit. It is advised that you do not drill completely through the blank, but stop slightly short and cut the blank to the final length to avoid tear out.
3. Insert and glue the tube in the blank, spread the glue evenly over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise inside the blank. Allow the glue to set per the manufacturers directions.
4. When the glue has set, use a 7mm barrel trimmer with the adapter sleeve square the ends of the blank. **Be careful not to shorten the brass tube when squaring.** Alternate methods of squaring, such as sanding, may be used if desired.

TURNING THE BLANK

- Mount 7mm spacer bushings on the mandrel. . Slide one Le Roi bushing, wide end first, onto the mandrel. Install the blank. Follow with the other bushing, narrow end in first. Mount spacer bushings if needed to fill the space to the mandrel's threads. Screw on the lock nut hand tight. Do not over tighten the lock nut, it may damage the mandrel or blank.
- Turn the blank close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings. .
- Apply the finish of your choice and polish.
- Remove the blank from the mandrel.



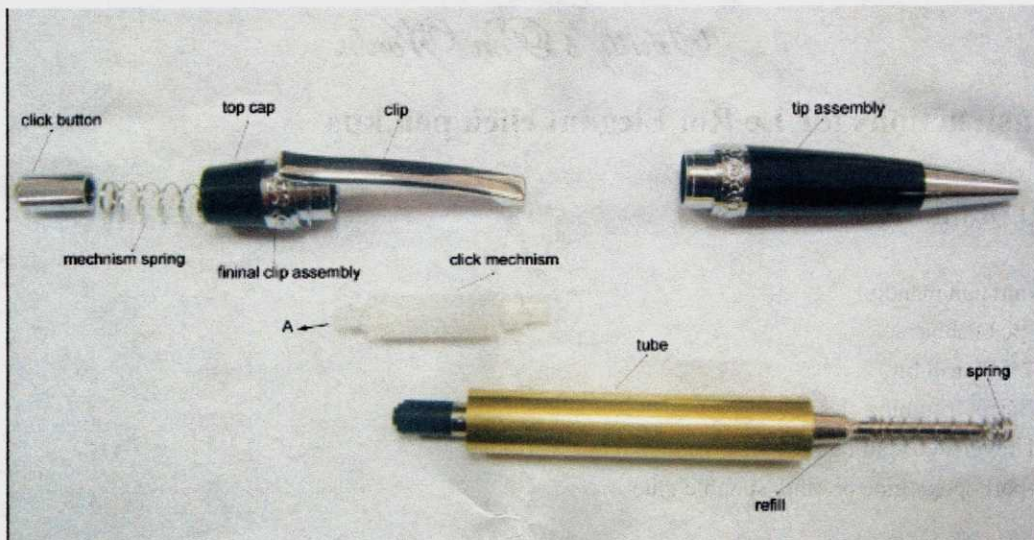


diagram B

ASSEMBLY:

- NOTE: Line up finished parts according to diagram B. Study the diagram and become familiar with all of the parts and read all of the instructions before proceeding with assembly. **Use great care in the next few steps it is important to have the click mechanism housing in place before pressing the cap/clip assembly into the tube.**
- Press the tip assembly into one end of the brass tube.
- Assemble the clip to the top cap. Push the plastic click mechanism housing into the chrome end of the cap, the smaller hole goes inside the cap. **You might want add a drop of loctite to hold this housing in place.**
- Insert the threaded end on the click mechanism(end A) into the housing so the threads extend through the top cap
- Press this finial clip/cap assembly into the barrel
- Affix the refill spring over the refill tip. Unscrew the tip assembly from the tip band. Insert the refill(black end first) into the barrel **taking care to assure the click mechanism remains in place**
- Thread on the tip assembly over the refill
- Drop the mechanism spring into the opening at the top cap
- Insert the click button and screw tight
- The pen operates by clicking on the button to extract or retract the refill. Be sure to instruct your customers on how to replace the refill and to be extremely careful not to lose the refill spring or click mechanism part when replacing the refill.