

### One Piece Click Ballpoint

This short tutorial is done using the PSI Jell Writer Pro click ballpoint. Kit info is PK-PENXX and can be found here: <http://www.pennstateind.com/store/slimpro.htm> The same technique can be done the slimline pencil kits which I find nice to make exactly matching Pen/Pencil kits as seen here, the third picture down on the right column: <http://www.redriverpens.com/Unique%20pens.htm>

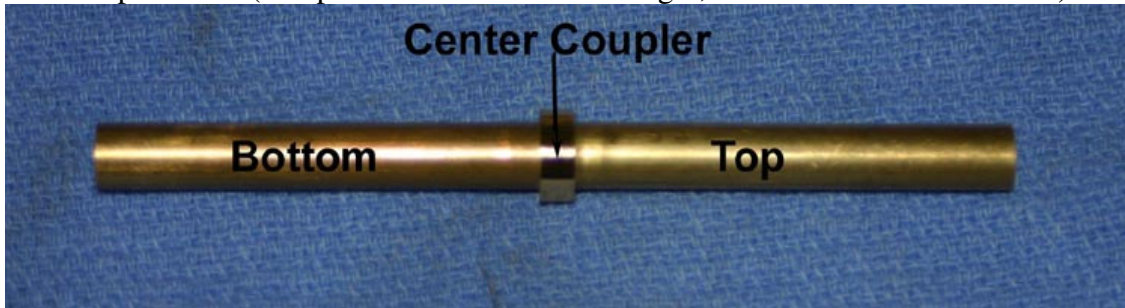
Figure 1 shows the two tubes and the pen band, which I think should be called the Center band/Coupler. The instructions for this pen:

<http://www.pennstateind.com/library/PKPENXX-PKPCLXX.pdf> . Notice the longer shoulder on the right side. It is very important that this longer shoulder is pressed into the top section and care must be taken to keep track of which end of the blank is the TOP. If the top and bottom are switched, the click mechanism will not function.

**Figure 1**

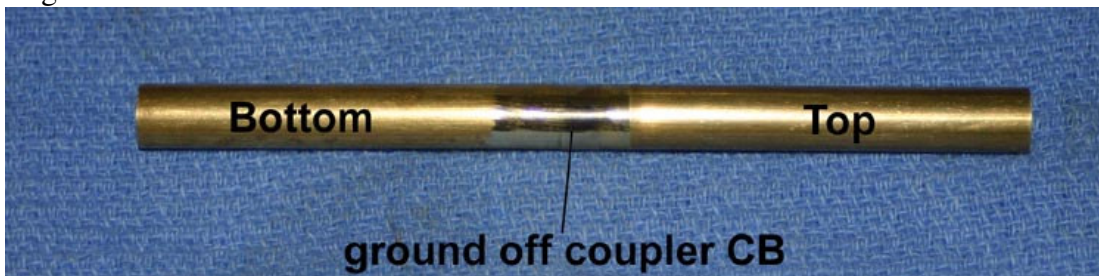


Figure 2 shows the tubes pressed onto the pen band (CB coupler) ready for the actual CB to be removed. Be sure to keep the top and bottom of the pen identified. This is an important part. ☺ It may be a good idea to place a drop of glue to help secure the tubes onto the pen band. (that part name doesn't sound right, but that is what PSI calls it)



**Figure 2**

Figure three shows the actual CB removed. I place the tubes and coupler on the mandrel using the two end bushings and turn the CB off using a parting tool. The piece is brass and is soft enough to turn off using a parting tool. Or, the CB can be removed using a grinder. Part off or grind off the CB so the two tubes and CB make one long tube with no ridge at the CB.



**Figure 3**

The tube structure is now ready to be glued into place. Pick a blank long enough to accept the tube/CB structure. If the CB is not removed down to the surface of the tube's OD, then it will not slide into the hole. If you use CA for gluing tubes into planks, I would suggest to use another glue for this one. If the insertion halts at the CB, then I can almost guarantee the tube will be stuck there. Epoxy or polyurethane glue will work best here.

Glue in the tube and square the end. The blank is now ready to place on the mandrel and turn. The bushing set is a three piece set and the center bushing is not used. I have two short sleeves that slide inside the click pen's tubes, one on each side of the pen band. They are not needed but they give a little support to the center of the pen since the center bushing is not used and the wood blank tends to flex somewhat when the final diameter is reached.

Turn the pen to the proper end diameters and fashion the blank between the ends. Sand and apply the finish of choice.

The click mechanism will normally be inserted into the bottom of the top tube before it is pressed onto the pen band (CB coupler). This is not possible now, but the click mechanism can be carefully inserted into the top of the pen. I do hope you have kept the top and bottom of the pen identified and have not reversed them. Follow the kit's instructions and just insert the click mechanism carefully into the top. It will be a tight fit, but it will go.

I do hope this helps and several of these pens get posted in the near future. Email me with and questions or comments: donATRedRiverPens.com replacing AT with @

Do a good turn daily!  
Don