

MODEL #1216 - 1217 'Penlight' Click On/Off Kit

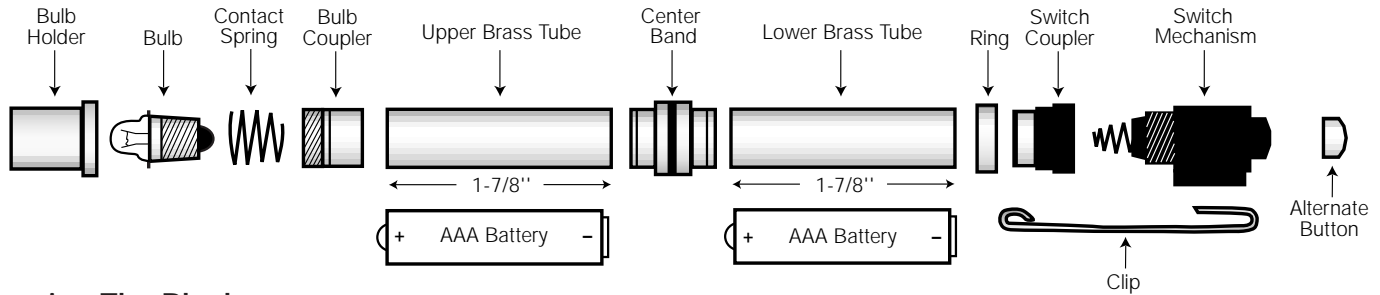
Kit Features:

- 24 kt gold plated parts with epoxy coating
- Smooth operating on/off click switch
- Uses 2, AAA batteries (not included) and a standard flash light bulb
- Overall length: 5-3/4"

Required Accessories:

- 7mm PSI Long Mandrel
- 3 pc. Bushing Set #P1218
- .492" Dia. drill bit #1219 or 1/2" dia bit
- Universal Barrel Trimmer # 1588 (optional)
- 2-Part Epoxy Glue or Insta-Cure Glue(cyanoacrylate)

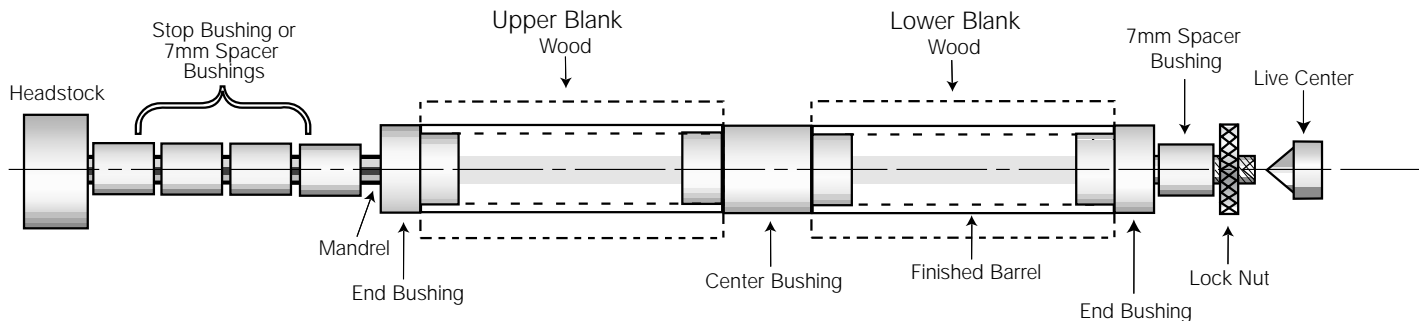
Diagram A / Parts List



Preparing The Blanks:

To avoid cracking the wood in the drilling process, cut about 1" square wood blanks to the length of the brass tubes (add 1/16" for squaring off). Drill a hole lengthwise in the center of each blank. For best results, use PSI #PKPLI-DB or use a 1/2" Dia. Drill Bit. Glue tubes inside blanks. Use a liberal amount of glue to fill the gap. Push tubes inside with a twisting motion, to spread the glue evenly throughout. Center the tubes lengthwise inside the blanks. When the glue dries, square the ends of the blanks. Use a belt/disc sander or with Universal Barrel Trimmer #1588 (optional). Sand the wood down, flush to the brass.

Diagram B / Turning The Blanks



Turning The Blanks

Place the stop bushing onto the mandrel hand tight or use 3-4, 7mm bushings. Place one of the end bushings (wider Dia. first) on the mandrel. Then, slide on either blank. Place the center bushing on the mandrel. Slide on the other blank and follow with the other end bushing (narrow Dia. first). Slide the stop bushing (if used) toward the blank adjusting to remove excess space, or add additional bushings if necessary, then tighten the set screw (if used) and tighten the lock nut. Bring the tail stock snug with the mandrel. (Do not over tighten, it could damage the mandrel). Turn the wood down, flush with the bushings, using a lathe chisel and gradual higher grits of sandpaper. Finish the blanks with your choice of polish and wax available through TWP.

Assembly

Line up finished parts according to Diagram A. Press the center band into the barrel. Press the opposite end of the center band into the other barrel. Place the ring over the switch coupler. Press the switch coupler assembly into either end of the body. Press the bulb coupler, threaded end facing out, into the opposite end of the body, stopping at the shoulder. Insert the clip into slot in the switch mechanism (you may need to bend the clip to make contact with wood). Thread the switch assembly into the coupler. Insert 2, AAA batteries into the chamber. Align the positive ends toward bulb. Place the contact spring over the bulbs threaded socket. Place the bulb inside the bulb holder. Thread the bulb holder into pen light. The light operates by depressing the button to turn On/Off.

NOTE: This kit includes an alternate choice for the on/off button. If you prefer to change the black plastic button to a gold plated button, use a pair of pliers to remove the plastic button and install by pressing the gold button into the stem.