

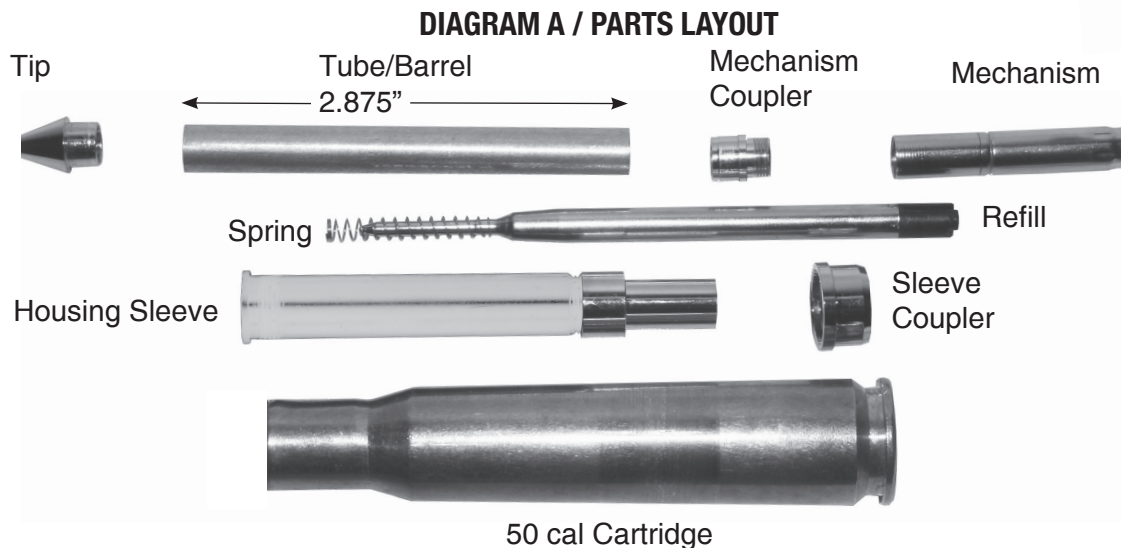
50 Caliber Cartridge Twist Parker Pen Kit

Kit Features:

- Use genuine once fired 50 cal bullet cartridge
- Parker® style ball point refill
- 24kt gold-plated components
- Makes a freestanding desk accessory

Required Accessories:

- 7 mm Pen Mandrel
- Drill Bit: 8 mm #PKPARK-8MM
- Barrel Trimmer #PKTRIM8
- 3-pc bushing set #PK50CALPBU
- Live Tailstock Center
- 2 part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size 3/4" x 1-3/8" Long



Preparing the Blank:

- Cut a 3/4" square blank to 1-3/8" (for a 5-1/2" overall length pen), up to 1-5/8" long (for a 5-3/4" overall length pen).
- Drill a 8mm hole through the blank.
- Spread glue over an end of the tube to the size of the blank. Slide on the wood. Leave some wood over the edge of the brass tube for trimming. (Note: The wood only covers a section of the tube)
- When the glue dries, use an 8mm barrel trimmer to trim the wood flush to the end of the brass tube at the tip end only.

DIAGRAM B / SQUARING THE BLANK

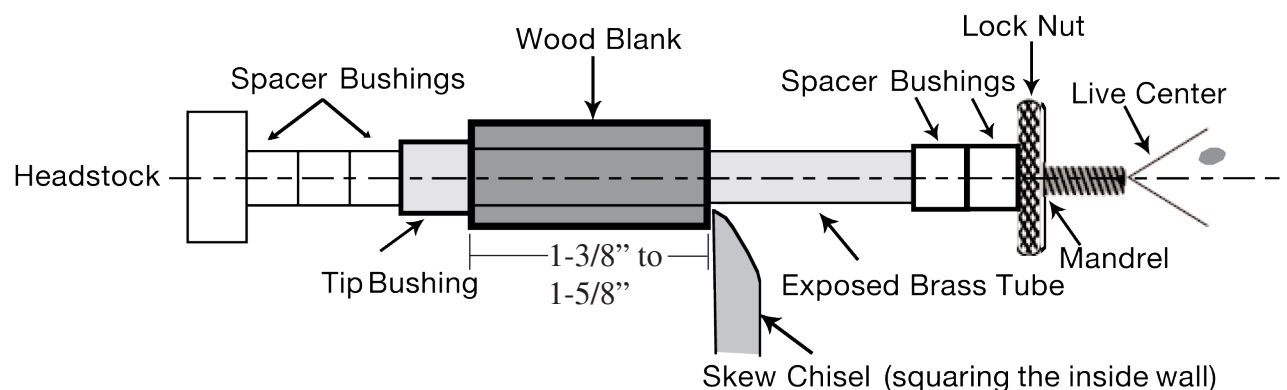
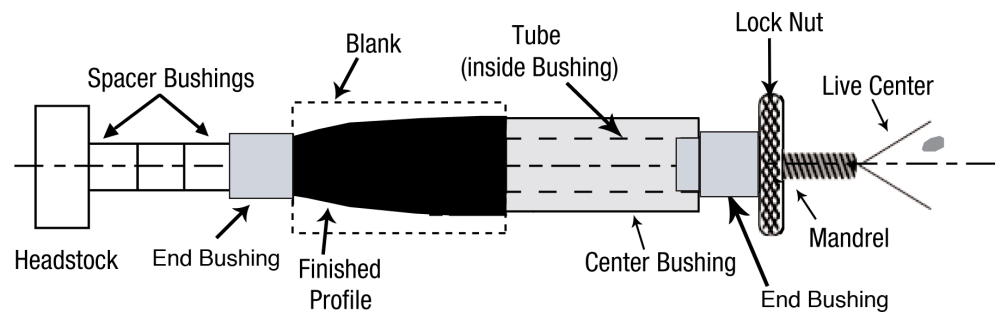


DIAGRAM C / TURNING THE BLANK

**Turning the Blank** (See Diagram B)

Note: Before turning the blank the inside wall of the blank needs to be trimmed square on the lathe.

- Mount spacer bushings on the mandrel shaft. Insert an end bushing. Insert front-end assembly, wood side in first and the other end bushing. Follow with a 7mm spacer bushings, fill to the mandrel threads. Use locknut to lock in the setup then position the tailstock for turning. Use a skew chisel or a parting tool to square the inside wall of the wood blank. When squared, remove the nut and spacer from the mandrel.
- (See Diagram C) Slide the center bushing over the brass tube, slide up tight to the wood. Add bushings as needed to close the space behind the outer bushing to the threads. Lock in the set up then position the tailstock for turning. Turn the wood down close to the bushings. Follow the profile of an actual bullet on the wood barrel. Sand and polish the wood.

Note: Before assembly of the pen parts: polish the brass cartridge to desired level of shine.

- Use a brass polish or #ONESTEP to polish the brass

Assembly

- Press the tip into the blank end of the barrel assembly—not the bare brass end.
- Press the mechanism coupler into the opposite, brass end of this assembly.
- Affix the spring over the refill, drop into the opening at the coupler. Screw the mechanism over the mechanism coupler.
- Slide the sleeve coupler, wide end first over the housing sleeve and screw this flush over the threads at the end.
- Insert this assembly into the opening of the cartridge. Press to the rim.
- Insert the front end assembly into the opening at the cartridge, push in to close the space to the wood/bullet.
- The pen operates by twisting the ends to advance or retract the refill.

Diagram D / Bushings #PK50CALPBU