

THE GATSBY PEN KIT

KIT FEATURES

- Smooth twist mechanism
- Parker™ style refills - PKPARK-R5
- Overall length: 5-1/4"

REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 2-pc bushing set #PKGABU
- Drill bit – 27/64" #PK2764
- Barrel trimming sleeve #PKGABTS
- Universal trimming kit #PKTRIMKIT
- 2-part epoxy glue or insta-cure glue (cyanoacrylate).

PREPARING THE BLANK:

- Prepare a master blank of at least 5/8" square. Cut to the length of the brass tube (add 1/16" for trimming)
 - Drill a 27/64" center hole through the blank.
- NOTE: Sand the tube with 220 grit abrasive for better adhesion.
- Glue the tube in the blank. Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Center the tube inside the blank.
 - Square the ends of the blank using a 7mm barrel trimmer with the adapter sleeve (#PKGABTS). Mount the sleeve over the shank. Trim the blank down flush with the brass tube.

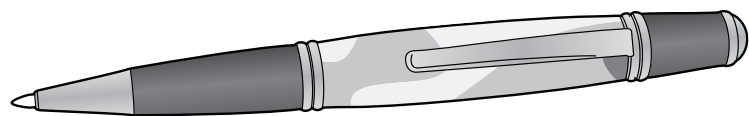
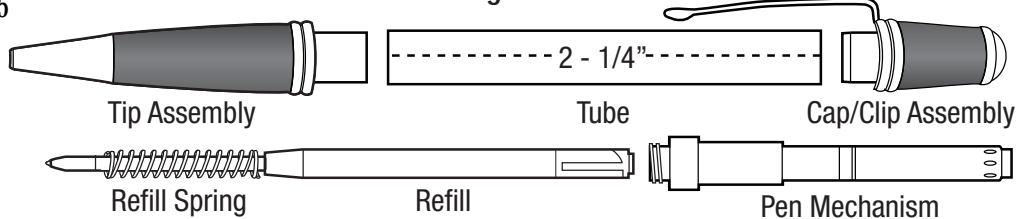


Diagram A - Parts list



TURNING THE BLANK:

- Mount 7mm spacer bushings on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing, narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the lock-nut hand tight. Bring the tailstock in snug to the mandrel and tighten the lock-nut for turning. Do not over-tighten the lock nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

DIAGRAM B • Turning the blank



ASSEMBLY:

NOTE: Line up finished parts according to diagram 'C'.

- To avoid damage to components when assembling, use vise with covered jaws or PSI #PENPRESS3.
- Press clip assembly into the barrel.
- Thread the mechanism down (without the refill) into the large opening of the tip assembly.
- Insert the upper cap/clip assembly over the mechanism, place the entire pen into the pen press. Press in to close the gap to the center band.
- Unscrew the upper barrel assembly, insert the refill with screw mounted into the lower end. Screw back the upper end to engage and close the gap.
- The pen is now ready to operate; twist clockwise to open.

Diagram C - Assembly

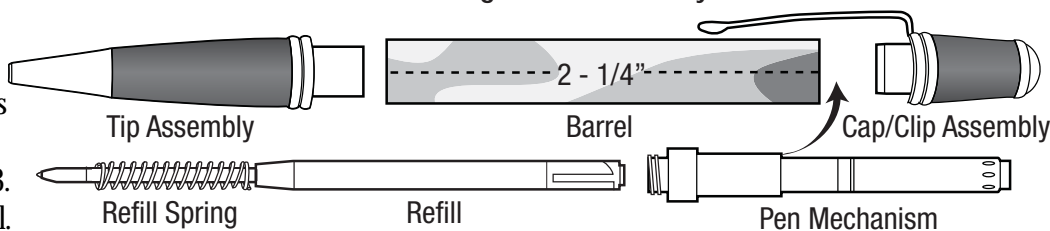


DIAGRAM D • PKGAPENBU

