

Model ##PKMONT-MIN Mini Designer Pen Kit

Kit Features:

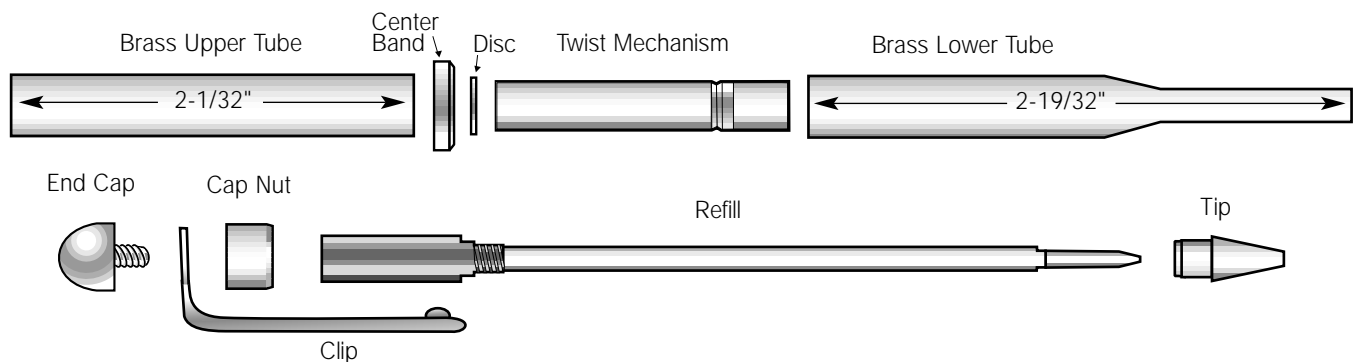
- Heavy 24 kt. gold plating with epoxy coating.
- Designed as a slim, lightweight Mont Blanc® style.
- Overall length, 5-3/8".
- Uses Cross® type ball point refill.

Required Accessories:

- Stepped drill bit #PKMONT-SD2 or 2 drill bits: 7mm and 3/16" diameter.
- Drive point bushings set #PKMONT-BU2 (3 pc. set).
- 3/8" or 1/2" drill chuck.
- 2 part epoxy glue or inst-cure (cyanoacrolate glue).
- Narrow 1/16" or less kerf parting tool.

Note: Drawings not to scale

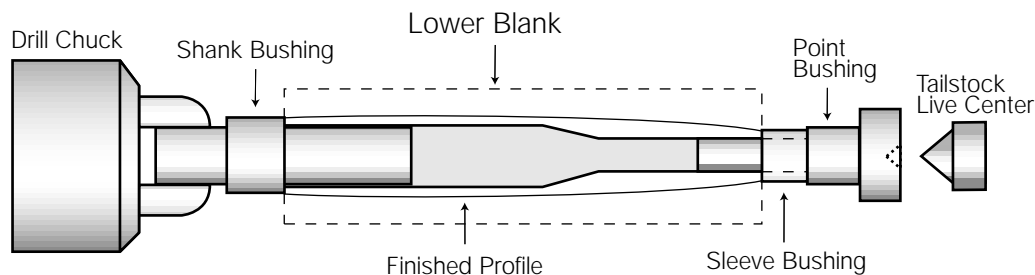
Diagram A / Parts Layout



Preparing the blanks:

- Cut 5/8" square blanks to the length of the brass tubes (add 1/16" for squaring off).
- Drill a 7mm hole lengthwise through the center of the upper blank.
- Drill a stepped hole with bit #PKMONT-SP2, or two holes- a 3/16" through hole and a 7mm hole approx. 1-5/8" deep.
- Spread glue over tubes. Insert into proper blanks with a twisting motion to spread the glue evenly inside. Center each tube lengthwise in the blanks.
- When the glue dries, square ends of blanks. You may use a 7mm barrel trimmer and a belt/disc sander. Take the wood down flush to the brass tube.

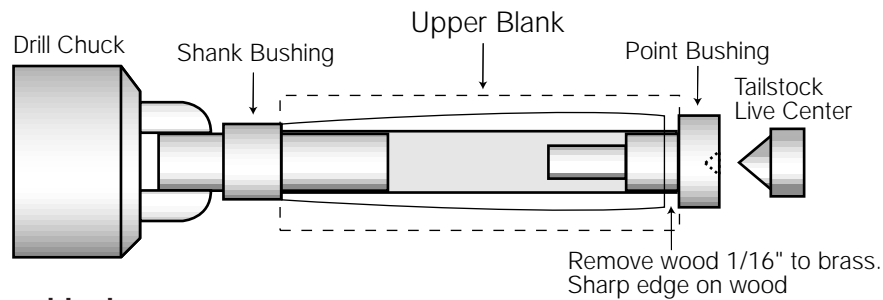
Diagram B / Turning the Lower Blank



Turning the lower blank:

- Place shank bushing into a drill chuck mounted on the Headstock.
- Tighten jaws.
- Slide lower blank over shank bushing.
- Slide sleeve on shank of point bushing.
- Slide shank of point bushing with sleeve into narrow end of brass tube.
- Bring tailstock live center snugly up against point bushing. **Do not overtighten.**
- Turn wood down to match the shank bushing and the sleeve on the point bushing with chisels and sandpaper. Taper the tip end of blank (follow diagram B for profile) to conform with tip. When completed, finish exterior of wood with varnish or wax.
- Remove finished blank

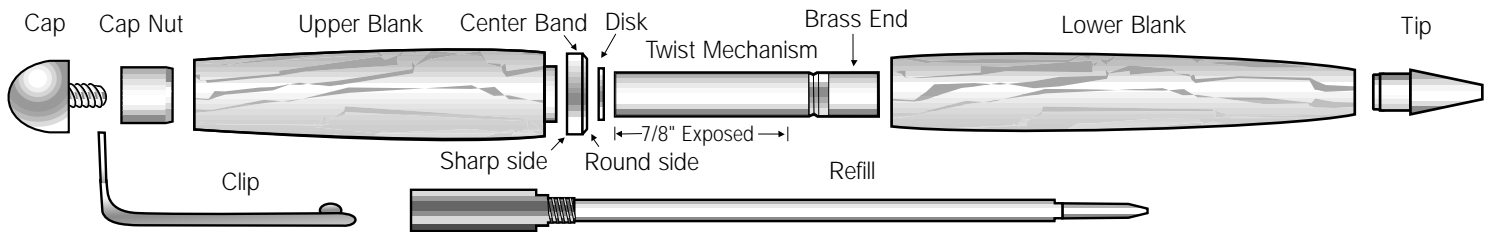
Diagram C / Turning the Upper Blank



Turning the upper blank:

- Slide upper wood blank over shank bushing. Insert point bushing into opposite end. Bring tailstock live center snugly up against point bushing. **Do not overtighten.**
- Turn wood down to the bushings with chisels and sandpaper. Taper the cap end of the blank (follow diagram C for profile) to conform with cap. When completed, finish exterior wood with varnish or wax.
- **Removing excess wood**- use a parting tool to remove 1/16" of the wood down to expose the brass tube. Keep edge of wood sharp.

Diagram D / Assembly



Lower end

- Line up finished parts according to diagram "D"
- To press parts, use a vise or a clamping instrument with wooden jaws, proceed slowly with caution, to avoid scratching gold plated parts.
- Press tip extension into lower blank.
- Scratch a line 7/8" from the edge of the chrome end of the twist mechanism (See diagram "D"). Press brass end into open end of the lower blank. Stop at the line marked. Do not press beyond the line, since it is very difficult to retrieve mechanism. Slide disc over chrome mechanism.
- Screw refill into twist mechanism.

Upper end

- Press cap nut (recessed end first) into cap end of upper blank.
- Put a drop of glue over the exposed brass tube. Slide center band (sharp side first) over glue. Press together and allow to dry.
- Insert cap thread into clip, and screw together into cap nut.
- Engage and slide both ends together. The pen is ready to operate by twisting the ends to extend or retract the ball point.

Bushings (#PKMONT-BU2)

