

SCULPTURED TWIST PEN KIT

KIT FEATURES:

- Smooth Twist Operation
- Sculptured cast design pops from black enamel inlay
- Uses Parker© type ball point refill
- Overall length 5-3/8"

REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- Live Center
- 3pc. Pen Bushing Set #PKSC-BU
- 8mm Drill Bit: #PKPARK-8MM
- 8mm Barrel Trimmer #PK-TRIM8, PKTRIMKIT, or pen blank squaring jig with 8mm sleeve
- 2 Part Epoxy Glue or Thick Insta-Cure (cyanoacrylate)
- Pen Blank Minimum Size: 5/8"x5/8"x4-3/8"



Comes in these styles (sold separately):



PKSC-PEN
CLASSIC



PKSC-PEN3
LATTICE



PKSC-PEN4
FLORAL

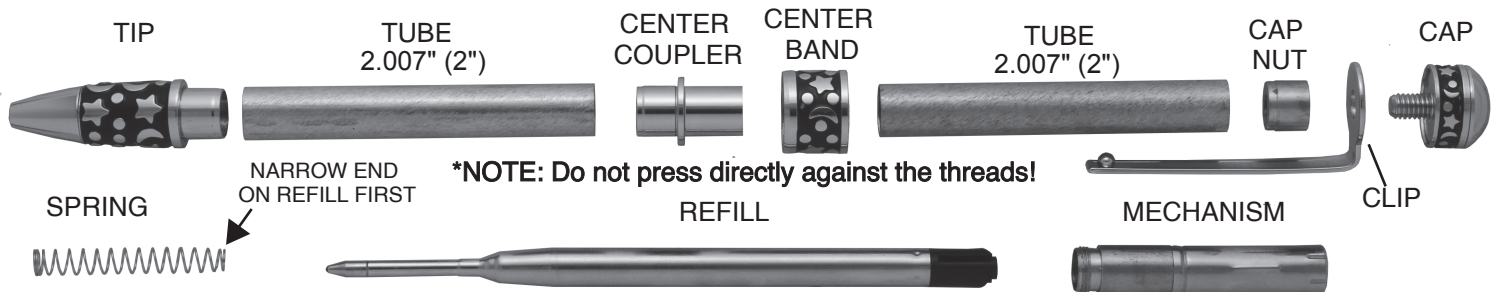


PKSC-PEN5
MIDNIGHT



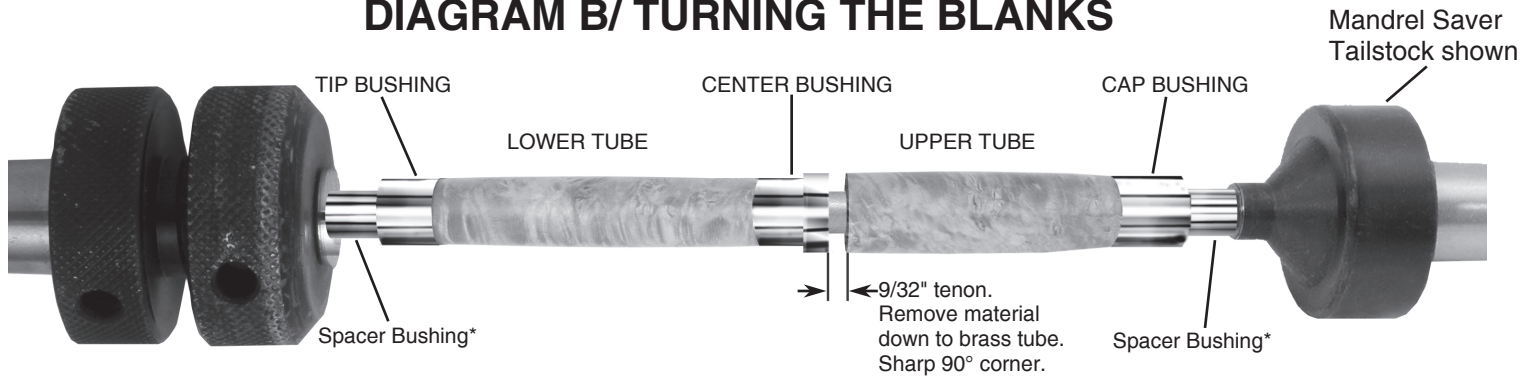
PKSC-PEN6 & PKSC-PEN6C
ARBOR

DIAGRAM A / PARTS LAYOUT



PREPARING THE BLANK:

- Cut blank into two pieces to the length of the brass tubes, adding 1/16" for squaring off (approx 2-1/8" per blank).
- Drill 8MM hole lengthwise through each blank.
- Spread glue over the tube, insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 8MM barrel trimmer, or a pen blank squaring jig with an 8MM sleeve on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with the operation of the mechanism and assembly.
- Use a barrel trimmer to clean the inside of the tube

DIAGRAM B/ TURNING THE BLANKS

*Optional

TURNING THE BLANK:

- Mount the bushings and blank according to diagram B.
- If using Live Center and threaded nut: Add spacer bushings until they cross the threaded area. Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple. Lock Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over-tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure. You may want to add spacer bushings for extra working space.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel straight or to a profile of your choice.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish instructions.

ASSEMBLY

- Put a small amount of the glue of your choice inside the centerband. Slide the centerband, flat side first, onto Tenon area of the upper barrel. Clean any excess glue from inside centerband. Allow glue to cure.
- Press the cap nut into opposite end of upper barrel.
- Screw cap into cap nut through hole in clip.
- Press Center Coupler into either end of lower barrel.
NOTE: To avoid damage, do not press directly over threads. Rather cut a section of a pen blank to 1/2" long. Drill a 8mm hole through the section, affix over thread and press.
- Press Tip into opposite end of lower barrel.
- Slide narrower end of Spring onto Refill tip until it fits snug. Drop refill, point first, into lower barrel. Thread Mechanism firmly into Center Coupler, over refill.
- Slide upper Barrel by hand over mechanism until the Center Coupler is fully inside Centerband.
- Operate mechanism by twisting upper barrel.
- To replace refill, unscrew upper and lower barrel and replace. Thread upper barrel lower barrel, do not push together as it could drive mechanism too far into upper barrel.

DIAGRAM C / BUSHINGS: #PKSCBU