

American Pride Filigree Twist Kit

Kit Features:

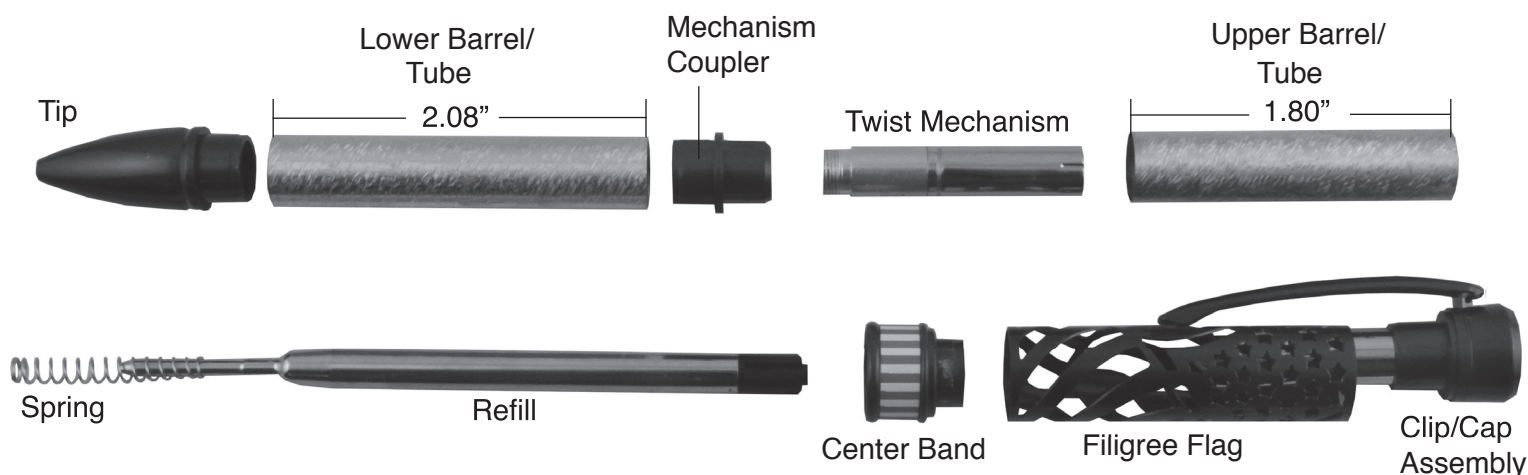
- Unique Filigree Flag pattern over a turned upper tube
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Overall Length: 5-7/8"
- Uses Parker® style refills
- Tube Size: 10.5mm

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s): #PK105MM (Brad Point for Wood) #PK105MMSG (Standard Grind for Acrylics)
- Bushing set (3 pc): #PKAPFILBU
- Barrel Trimming set: #PKTRIM7 Sleeve: #PKMAJJRSET
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 4-1/2" Total

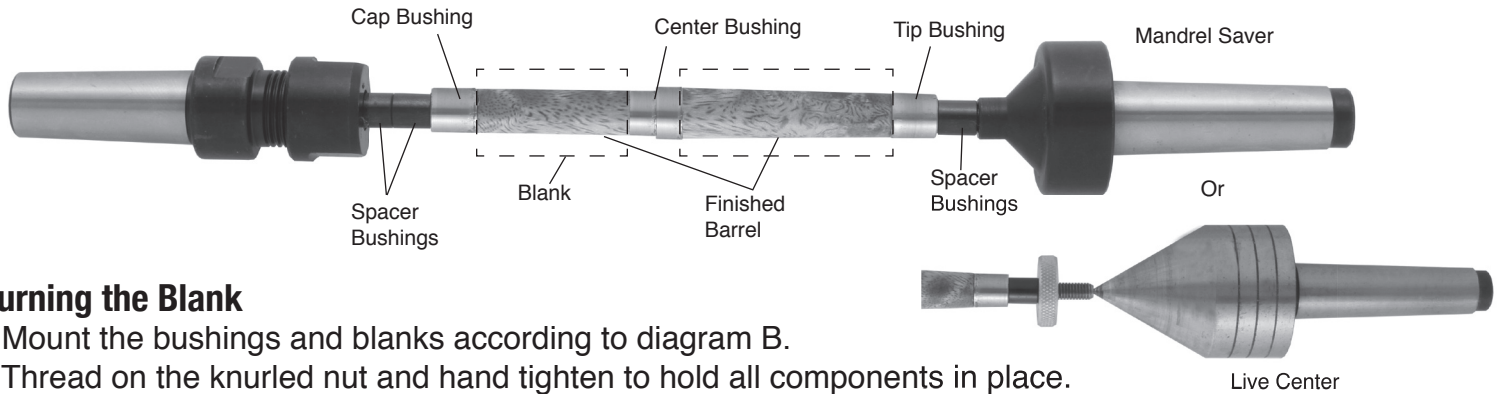


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 10.5mm holes lengthwise through the blanks.
- Spread glue over the tube(s), insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 7mm barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly). Clean the inside of the tube.

DIAGRAM B / TURNING THE BLANKS**Turning the Blank**

- Mount the bushings and blanks according to diagram B.
 - 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 in place.
 - Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
 - Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice).
 - When turning the upper blank, do not turn over the bushing O.D. Check that the filigree screen can slide snug over the finished barrel (If too loose, see note in assembly).
 - Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
 - Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.
- Refer to polish instructions.

Assembly

- Layout parts according to diagram A
- Press the tip into either end of the lower barrel.
- Press the coupler, recessed end in first into the opposite end of the barrel.
- Mount the spring, narrow end in first, over the refill. Insert this assembly into the opening at the lower end of the pen. Screw the mechanism over the refill.
- Press the clip assembly into either end of the upper barrel.
- Slide Filigree over the Upper Barrel. If you wish to make sure that filigree does not move, place a small drop of glue on the inside edge of the upper portion of the filigree. The best spot for this would be the section that will be under clip.
- Align the centerband to your preference and press into the open end of upper barrel.
- Push both pen sections together until they meet. If the fit is tight you may carefully use pen press to fully close pen gap.
- To extend and retract the refill, twist the upper barrel.
- To change refill, unscrew the lower section from the upper barrel and switch out refill. Remember to move spring to new refill. Screw the two sections back together.

Diagram C / Bushings #PKAPFILBU