

Mini Breast Cancer Pen Kit

PKBCM24 · PKBCMCH · PKBCM24

Kit Features:

- Easy to turn
- Minimum parts - easy to assemble
- Available in multiple finishes
- Mini pen design supporting breast cancer research
- Faceted Swarovski crystals on the clip, cap and band
- Overall Length: 4-1/2"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s): 7mm #PK-7MM
- PKBCMBU Bushing set (3 pc)
- PKTRIM7 Barrel Trimming set
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 5/8" x 4"

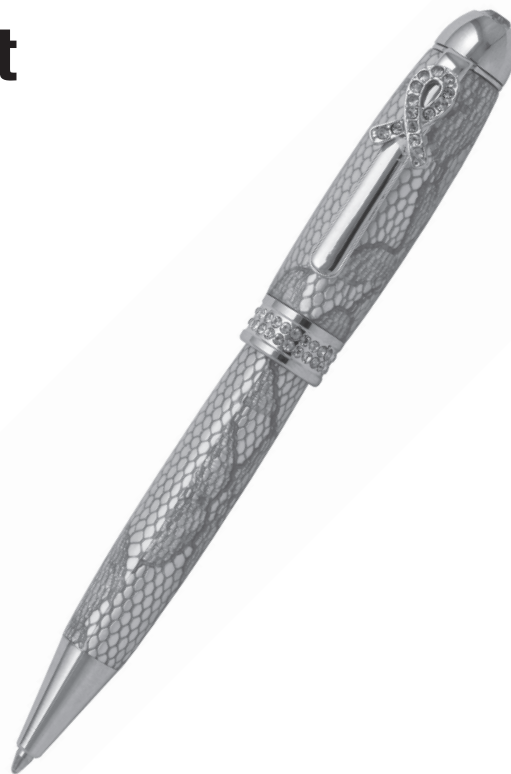
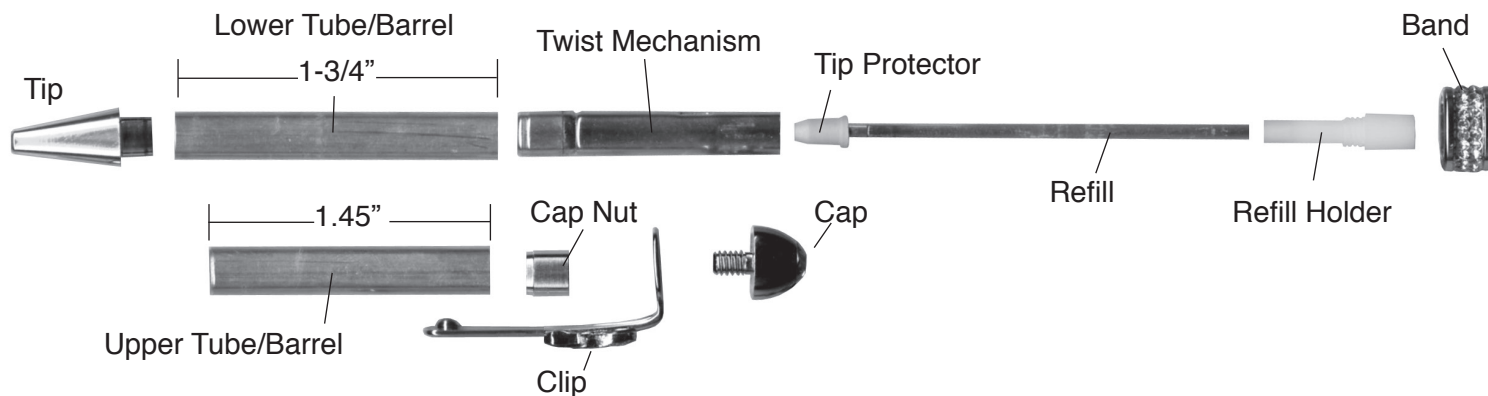
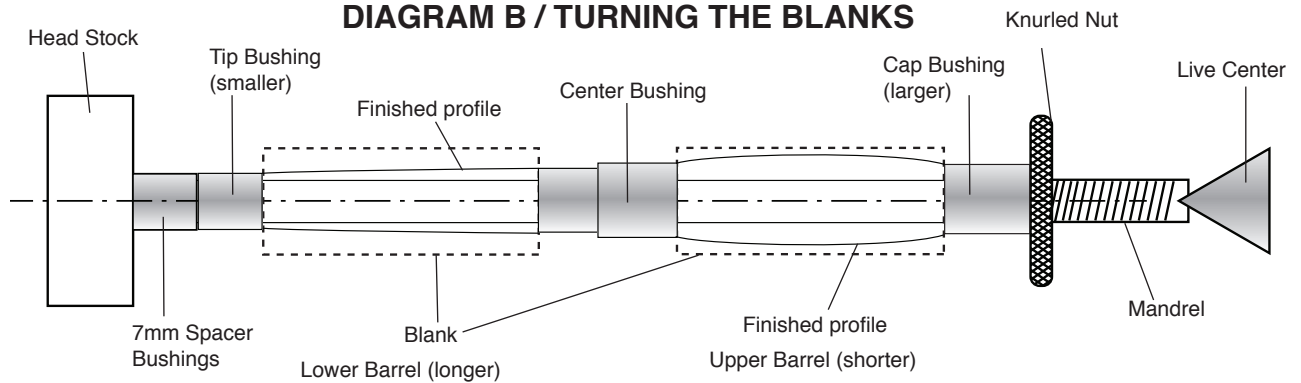


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 7mm 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. 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).

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 to a profile of your choice.
- 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 the narrow end of the lower (longer) barrel.
- Press the twist mechanism, brass end in first into the opposite opening at the barrel. Stop when only 3/4" of the chrome is out of the barrel. Check the refill exposure and adjust if necessary.
- Press the cap nut, recessed end in first into the opening at the narrow end of the upper barrel.
- Assemble the cap into the clip. Screw into the inner cap nut.
- Insert the refill holder over the refill end to bottom. Remove the tip protector.
- Twist the mechanism counter clockwise, up. Insert the refill assembly into the mechanism opening, screw in.
- Assemble the band, recessed side in first over the chrome end of the twist mechanism Engage both ends of the pen together.
- The pen operates by twisting the halves to extract or retract the refill tip.

Diagram C / Bushings #PKBCMBU