

Mini “Bullet” Twist Pen Kit—Instructions

KIT FEATURES:

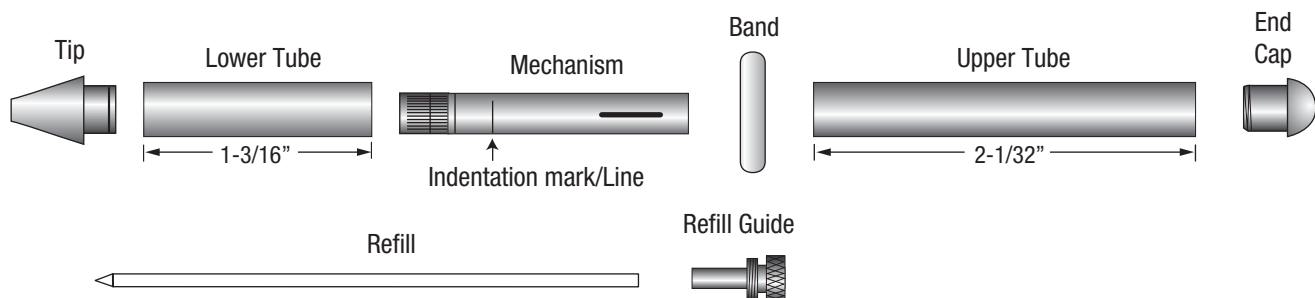
- Heavy 24kt Gold or Chrome Plating with epoxy coating
- Pen mechanism with locking device
- Compact mini twist pen is purse size
- Uses “Mini” style refills—#PKMINI-R5
- Overall length is 4”



REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- 7mm Drill Bit—#PK-7MM
- 7mm Barrel Trimmer—#PKTRIMKIT
- 3-piece Bushing Set—#PKBULPENBU
- 2 part epoxy glue or insta-cure (cyanoacrylate) glue

DIAGRAM A • Parts



PREPARING THE BLANKS FOR TURNING

- Cut 3/4” square blanks to the size of the brass tubes (add 1/16” for squaring off).
- Drill a 7mm center hole lengthwise through each blank.
- Spread glue over the tubes and insert each tube into blank with a twisting motion spreading glue evenly inside the blank.
- Center each tube lengthwise in the blank.
- When glue dries, square the ends of the blanks using a 7mm barrel trimmer (#PKTRIMKIT, 3/4” head). Trim the wood down flush to the brass tubes.

TURNING THE BLANKS

- Place 7mm spacer bushings onto the mandrel. Place the tip bushing (smaller) on next, follow with the lower blank and then the center bushing. Follow with the upper blank. Place the cap bushing (larger) on last. Add spacer bushings up to the thread.
- Thread on the locknut, hand tight. Bring the tailstock snug with the mandrel (do not over tighten, it could damage the mandrel). Lock in place. Tighten the locknut to prevent the blanks from spinning.
- Turn the wood down. Create a rounded profile from each end to the center, using sharp, lathe chisels and gradually higher, finer grits of abrasives.
- Sand the blanks flush with the bushings. Finish the barrels with your choice of polish and wax.

DIAGRAM B • Turning The Blanks

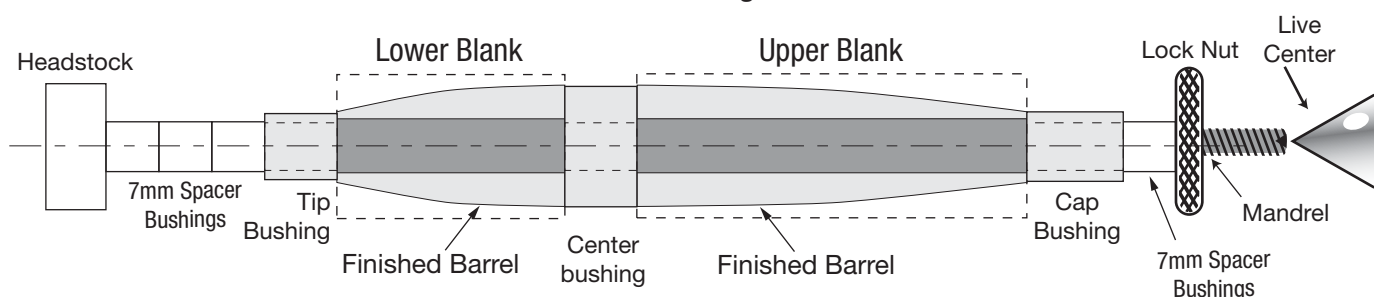
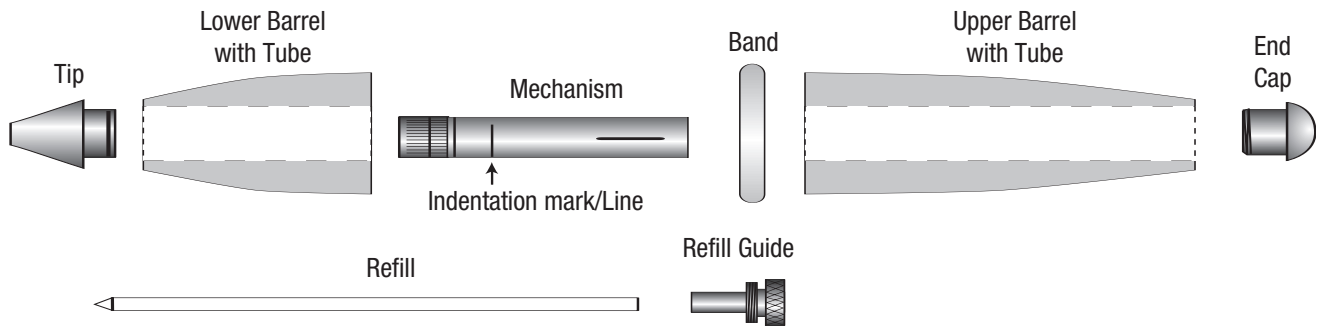


DIAGRAM C • Assembly



ASSEMBLY

- Press the tip into the lower barrel.
- Press the pen mechanism, brass end in first, into the opposite end of the barrel to the indentation line on the mechanism (see **DIAGRAM C**).
- Insert the refill into the refill guide.
- Hold the lower assembly of the pen and turn the mechanism counter clockwise to advance the inside thread upward. Insert the refill assembly and thread inside, using the knurled end. 3/32” brass will show on the outside.
- Place the band over the exposed mechanism.
- Press the end cap into the small diameter opening of the upper barrel.
- Engage both parts of the pen together.
- The pen operates by twisting the end of the pen to extend or retract the refill tip.

BUSHING SET

DIAGRAM D • PKBULPENBU

