

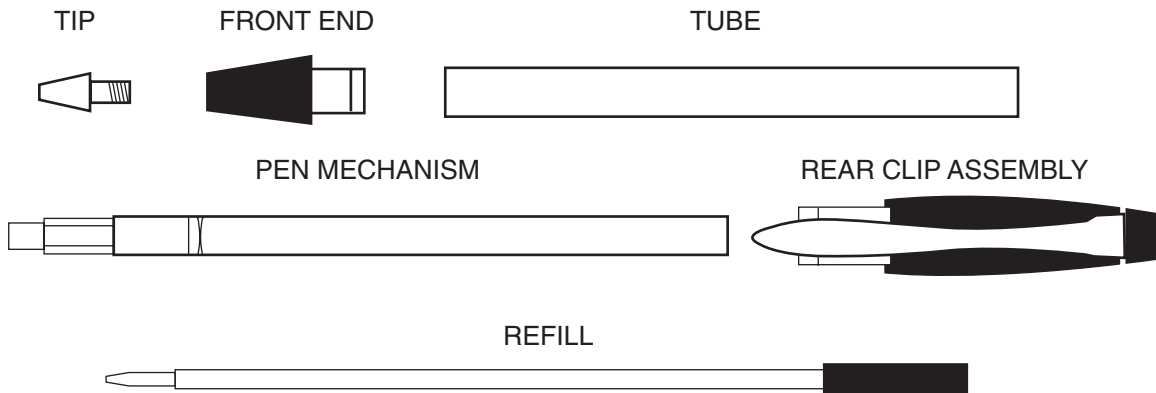


**FEATURES:**

- 24kt gold-plated parts with black resin accents
- Contemporary designed components
- High tech twist mechanism
- Uses Cross® style ball point refills
- Overall length 5-1/4"

**REQUIRED ACCESSORIES:**

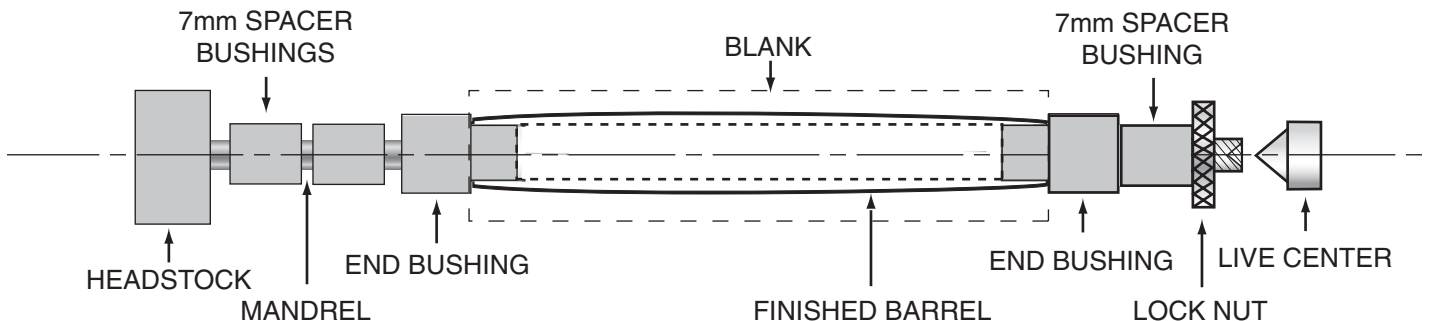
- 7mm pen mandrel
- 2-pc bushing set #PKCEOBU
- Drill bit #PK-U368
- Universal pen blank squaring jig #PKSQUARE or belt/disc sander
- 2-part epoxy glue or insta-cure (cyanoacrylate) glue



**DIAGRAM A - PEN PARTS**

**PREPARING THE BLANK:**

- Cut 3/4" to 5/8" square blank to the length of the brass tube (add 1/16" for squaring off).
- Use a #PK-U368 bit to drill a center hole lengthwise through the blank.
- Spread glue over tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When glue dries square the ends of the blank. Use a universal pen blank squaring jig or a belt/disc sander to square the ends of the blank. Take the wood down, flush with the brass tube.

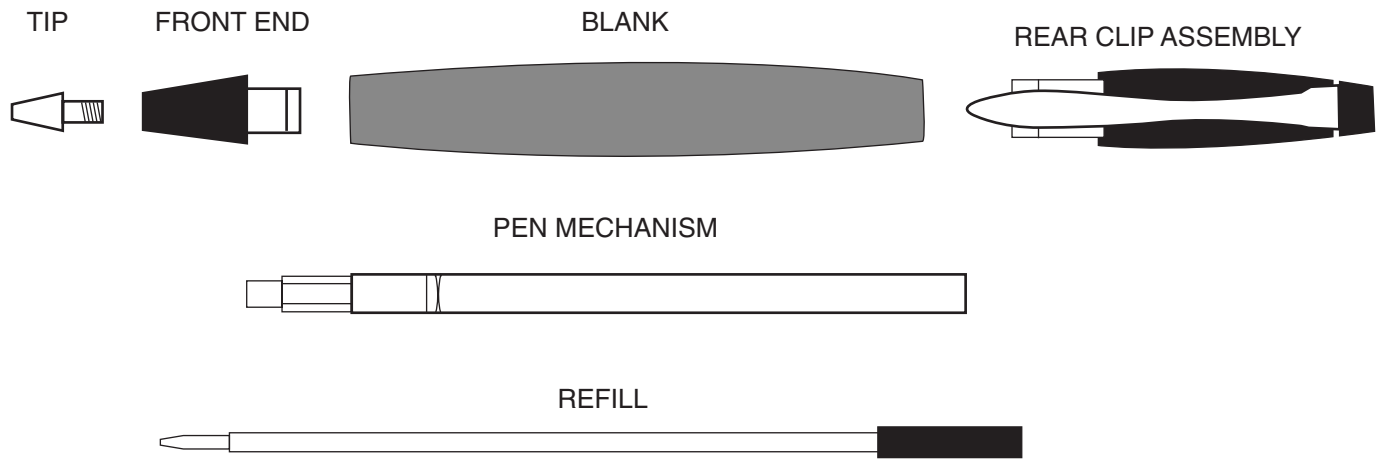


**DIAGRAM B - MOUNTING ON THE LATHE**

## TURNING THE BLANK:

Place spacer bushings on the mandrel. Insert an end bushing wide end in first and follow with the wood blank. Place the other end bushing on the mandrel, narrow end in first. Place another spacer bushing to close up the space up to the threads. Thread on the knurled nut hand tight. Bring the tailstock over to engage with the mandrel shaft. Lock in place. Tighten the lock nut ( Do not over-tighten, it could damage the mandrel).

Turn the wood down flush with the bushing (you may create a slight profile) using lathe chisels and gradual higher grits of abrasives. Finish the wood with your choice of polish and wax.



**DIAGRAM C - PEN ASSEMBLY**

## ASSEMBLY TIPS:

Line up finished parts according to Diagram C.

To press parts in, use a pen press or a vise with covered jaws. Press slowly to avoid damage to the parts.

## PEN ASSEMBLY:

Press the front end, recessed end in first into the barrel.

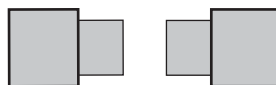
Insert the twist mechanism, narrow end in first into the opposite end of the barrel.

Thread in the tip through the front end into the mechanism tightly.

Insert the pen refill, narrow end first, into the opposite end. Thread to the end.

Slip the cap assembly over the refill top end and push in all the way.

The pen operates by twisting the cap assembly to extend or retract the refill tip.



**BUSHING # PKCEOBU**



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