

Longwood 30 Cal Twist Pen Kit

PKCP3800 • PKCP3810 • PKCP3820 • PKCP3830

Kit Features:

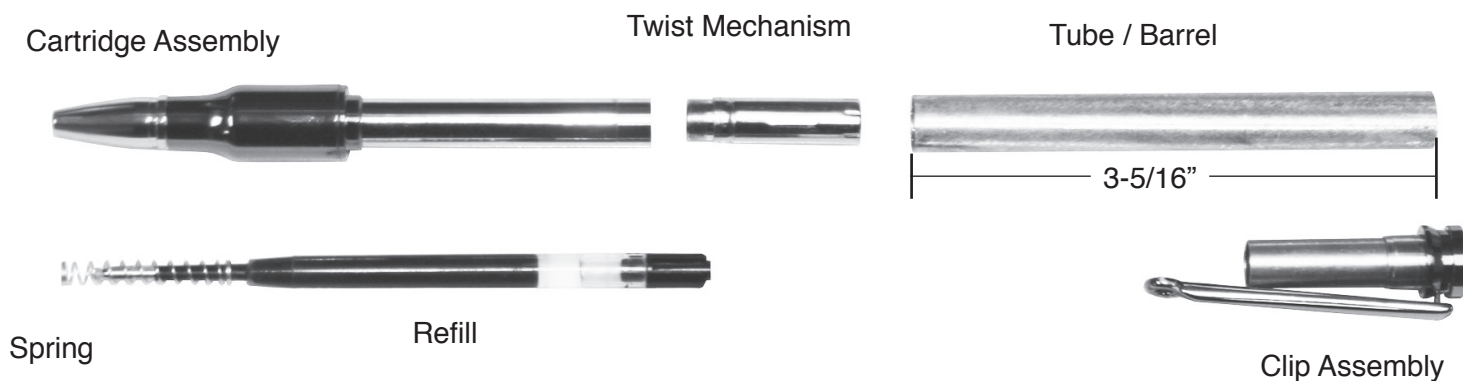
- Easy to turn with a straight or profiled barrel
- Minimum parts - easy to assemble
- Pre-Sanded tubes for stonger gluing
- Available in multiple finishes
- Uses Parker® Style Refill
- Overall Size: 5-1/2"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-3/8
- Bushing set(2 pc) #PKCP3000BU
- Barrel Trimming set #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 5/8" x 3-1/2"



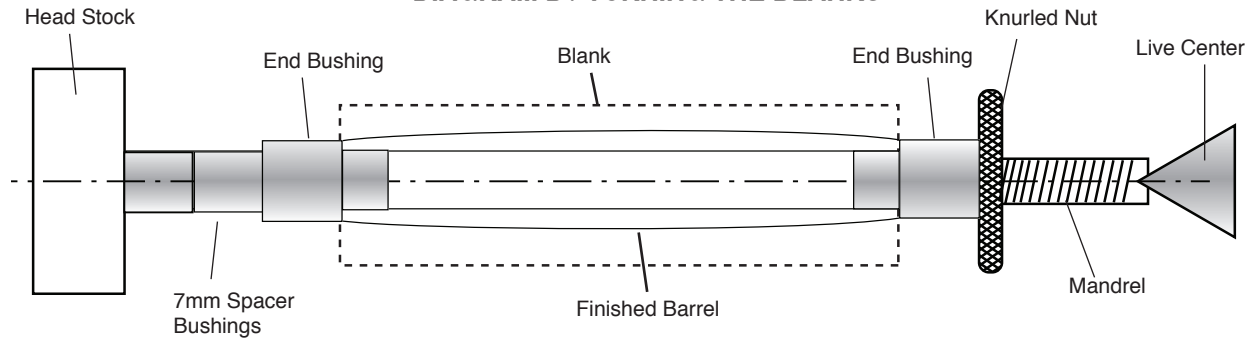
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert 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 blank. You can use a 3/8" 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).

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)
- 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
- Affix the spring over the refill, insert into the opening at the cartridge assembly.
- Thread on the mechanism over the exposed end of the refill. Test the twist motion.
- Insert and press the clip assembly into either end of the barrel.
- Slide the Clip assembly over the mechanism and over the shoulder of the cartridge.
- The pen is ready to use by twisting the ends to retract or advance the refill's tip.

Diagram C / Bushings #PKCP3000BU