

PSI Magnum Twist Pen Kit

PKCP7000 • PKCP7010 • PKCP7020

Kit Features:

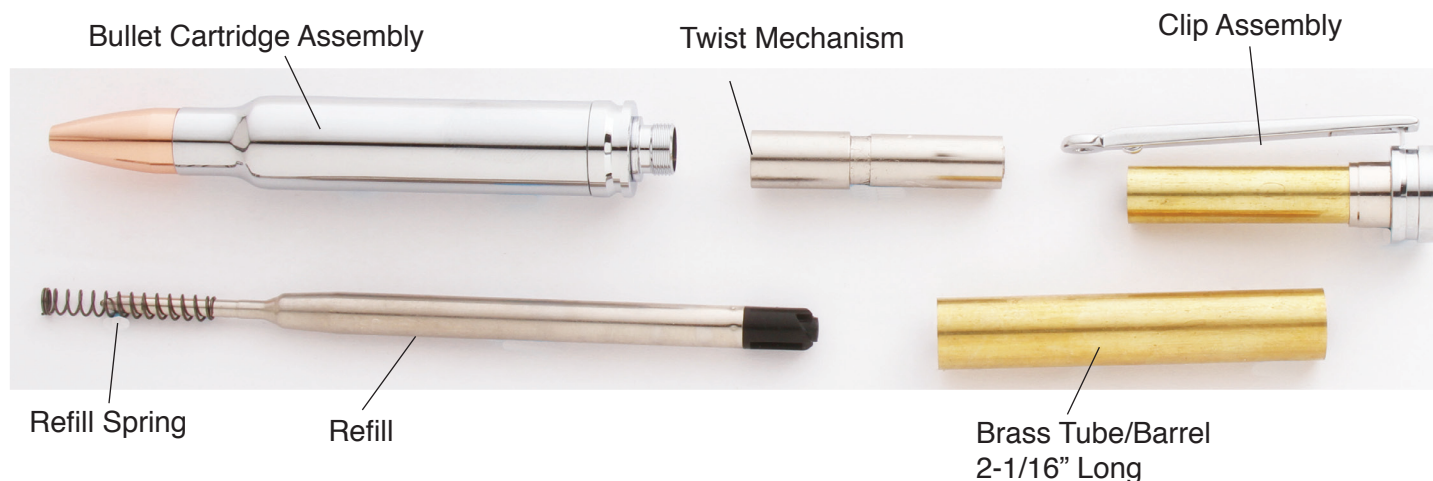
- Magnum Center Fire Shell casing
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refill
- Overall Size: 5-1/2" Long
- 10mm Tube

Required Accessories:

- 7mm, Pen Mandrel
- Drill Bit 10mm #PK10-10
- PK7000BU Bushing set(2 pc)
- 10mm Barrel Trimming set Use 10mm
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 5/8 x 2-14" L

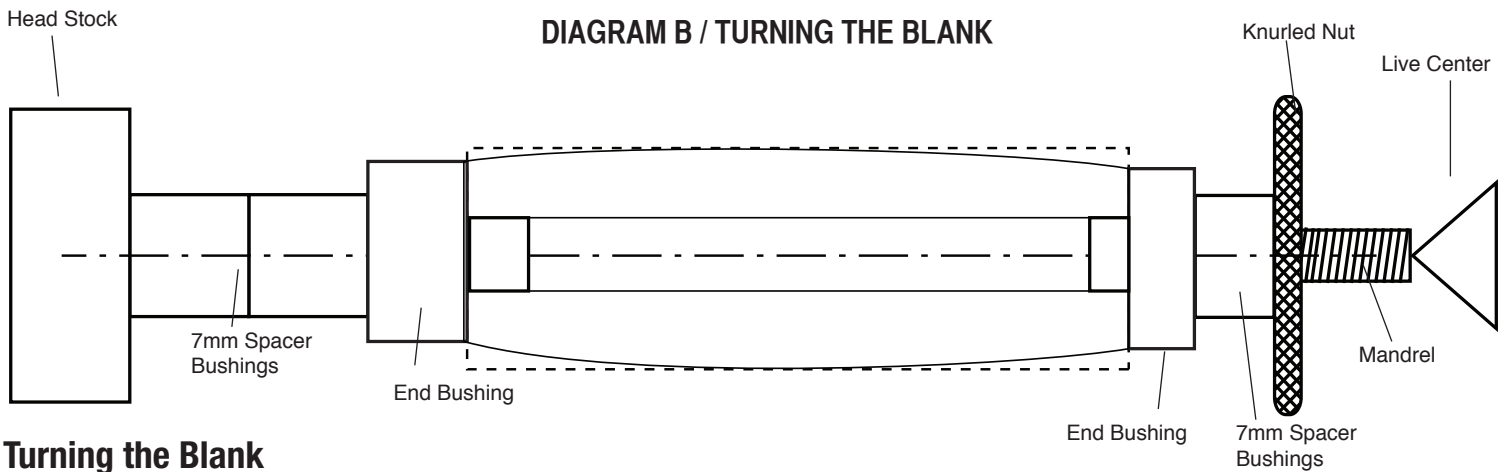


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut min 5/8" sq blank to length of tube(s) and add 1/16" for squaring off.
- Drill a 10 mm 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 tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 10mm barrel trimmer shaft, 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. Use a barrel trimmer to clean the inside of the tube.



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.

NOTE: Please do not press the front end of this kit with the tip removed. If you do so the parts will not assemble properly and you will void our warranty

Assembly

- Layout parts according to diagram A
- Insert clip assembly into barrel, press in.
- Insert refill and spring into cartridge assembly. Screw mechanism over.
- Insert clip and cartridge assembly over the mechanism. Push in to engage.
- The Pen operates by twisting both ends to extract or retract the pen refill.

Diagram C / Bushings #PK7000BU

