

# Crystal Tube Pen Kit

PKCTPEN1 • PKCTPEN2 • PKCTPEN3 • PKCTPEN4 • PKCTPEN5

## Kit Features:

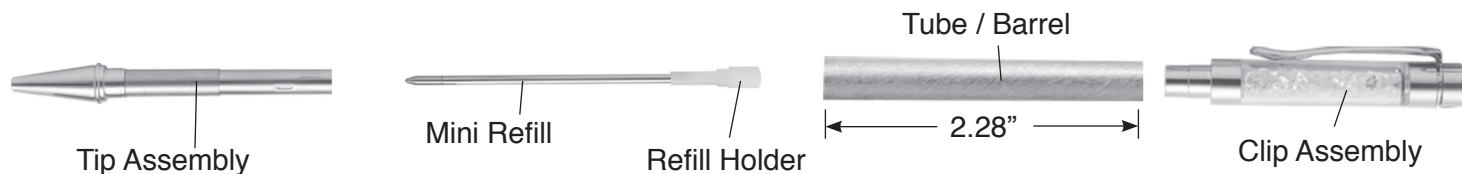
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Attractive Crystals in clip assembly
- Uses Mini Refill
- Overall Size: 5-3/8"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 8mm #PKPARK-8MM
- Bushing set(2 pc) #PKCTPENBU
- Barrel Trimming set #PKTRIM8 or #PKTRIMKIT (use 8mm shaft)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 5/8" x 2-3/4"

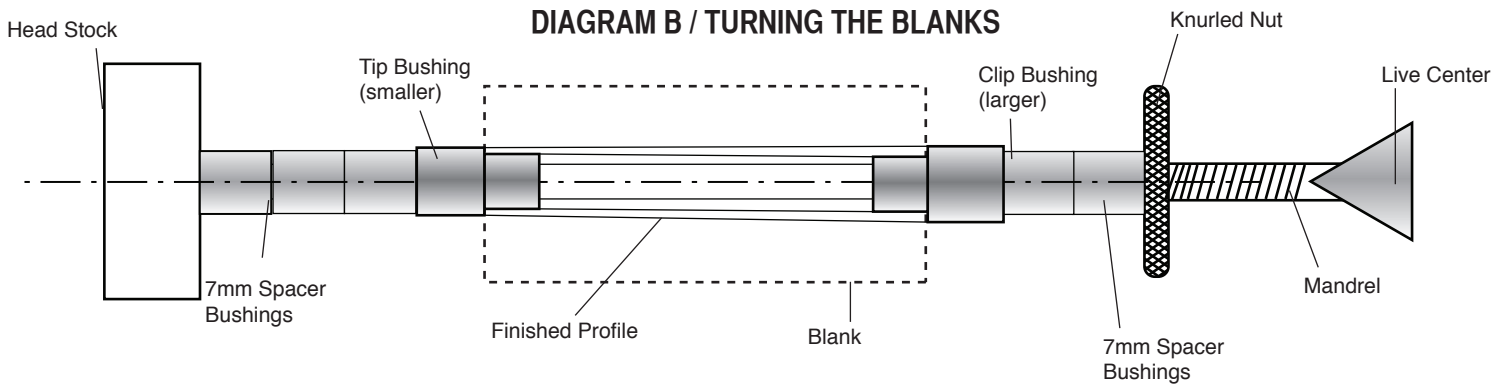


## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut one blank to the length of the tube and add 1/16" for squaring off.
- Drill an 8mm 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 8mm 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).



### 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
- Press the barrel, narrow end over the tip assembly towards the tip.
- Push the clip assembly into the barrel opening. Turn counter clockwise to raise the threads in the mechanism. Remove the clip assembly, then insert the refill with the holder and screw clockwise into bottom.
- Place the upper assembly over to engage both ends. Push in to close the gap.
- The pen is ready to use by twisting both ends to extract or retract the refill tip.
- To replace the refill, turn the upper end counter clockwise and remove. Turn the refill holder out and replace the refill.

### Diagram C / Bushings #PKCTPENBU

