

The Contour Twist Pen Kit

Kit Features

- Comfortable. Ergonomic Tip
- Stylish, Modern Design
- Easy to Turn with a Single Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-9/16"

Required Accessories

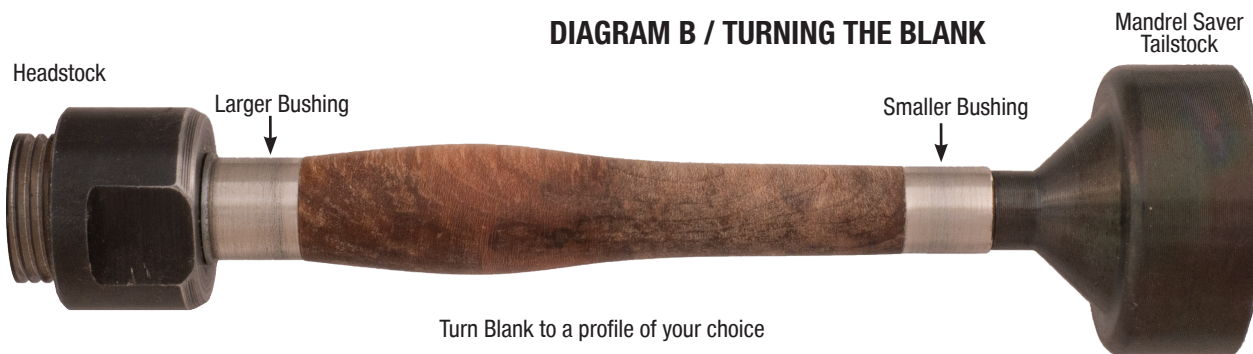
- 7mm Pen Mandrel
- Drill Bit: #PK-38BP for Wood, #PKEXEC-38 for Plastic
- Bushing Set(2pc): #PKCTRBU
- Barrel Trimming:PKTRIM38 or #PKSQUARE Sanding Jig with 3/8" sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 3"L



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 3/8" 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 inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 3/8" Barrel Trimmer or a pen blank squaring jig with 3/8" sleeve on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with the assembly and the operation of the mechanism. Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANK



Turning the Blank:

- Mount the bushings and blanks according to diagram B.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To use Knurled Nut setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- 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 Tailstock and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- Using sharp tools, turn the blank down close to the bushing diameters. Turn the barrel straight or to a profile of your choice.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish instructions.

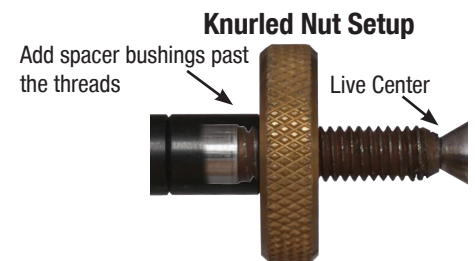


Diagram C / Bushing #PKCTRBU

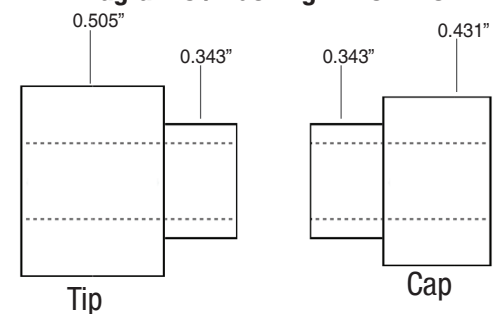
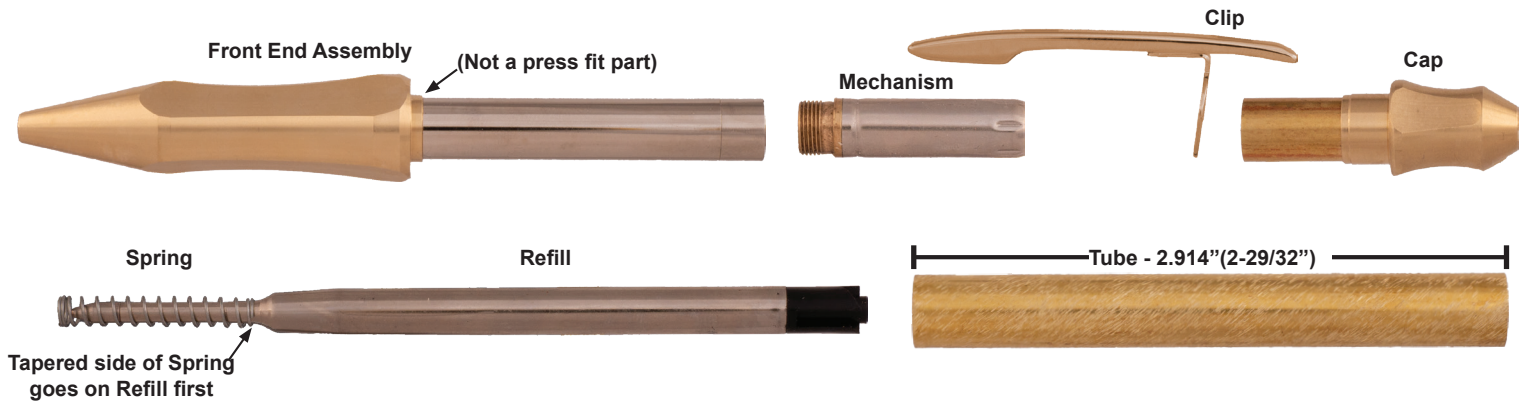


Diagram D / Parts Layout

**Assembly:**

Note that Front End Assembly is not a pressed part and should spin freely in the Barrel. It is held in place by the cap gripping the mechanism.

- Slide Clip onto the Cap.
- Press Cap into the smaller diameter end of the Barrel
- Slide Spring -tapered side first- onto the Refill shaft.
- Insert Refill into the back of the Front End Assembly.
- Thread Mechanism into the back of the Front End Assembly, over the Refill.
- Slide Front End Assembly into the larger, open end of the Barrel until the back of the tip is fully against Barrel and there is no gap. Mechanism will be pushed into the Cap and be held in place.
- To extend and retract Refill, twist the Tip clockwise and counter-clockwise.
- To change Refill, unthread the Front End Assembly from the Mechanism -remember to switch Spring to new Refill.