

#PKEZPEN Instructions

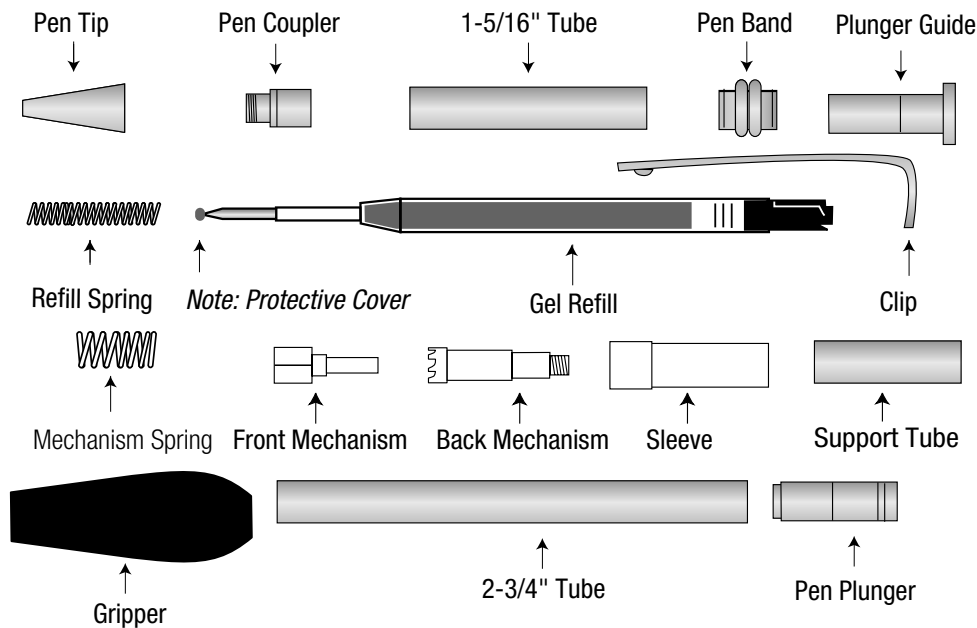
24kt Gold-plated E-Z Grip Pen Kit

FEATURES:

- Heavy 24kt gold-plating with epoxy coating
- E-Z soft grip makes writing comfortable
- Well balanced design, with stylish contoured components
- Pen mechanism engages with a one-hand click
- Parker style black ink gel refill (other colors available)
- Overall length 5-1/2"

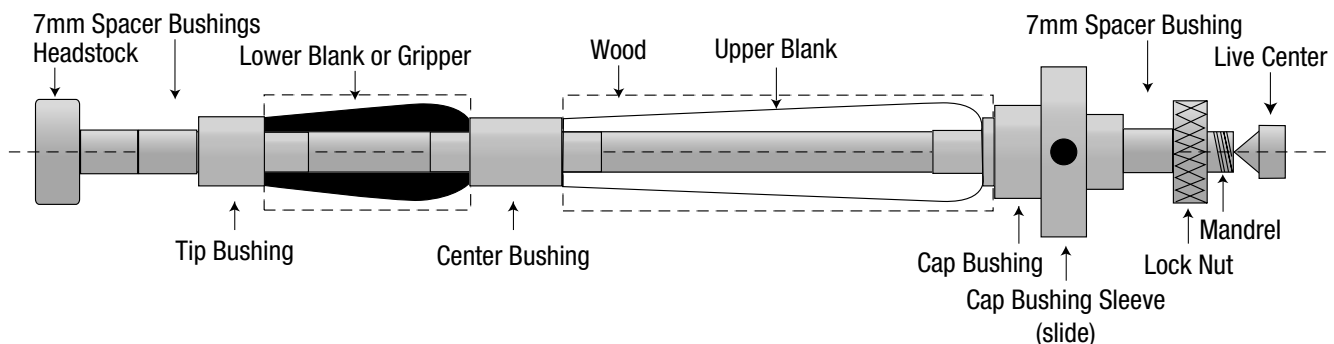
REQUIRED ACCESSORIES:

- Pen mandrel
- 8mm drill bit **#PKPARK-8MM**
- 8mm barrel trimmer **#PKTRIMKIT**
- 4-pc bushing set **#PKEZBU**
- 2-part epoxy glue or insta cure cyanoacrylate

DIAGRAM A - Pen Parts**PREPARING THE BLANK FOR TURNING**

Note: You may make these pens using the rubber gripper or all wood construction. When making all wood construction use all 3 bushings. When making with gripper, do not use the tip bushing. Instructions below pertain to using the gripper. The all wood option is detailed in **DIAGRAM B**.

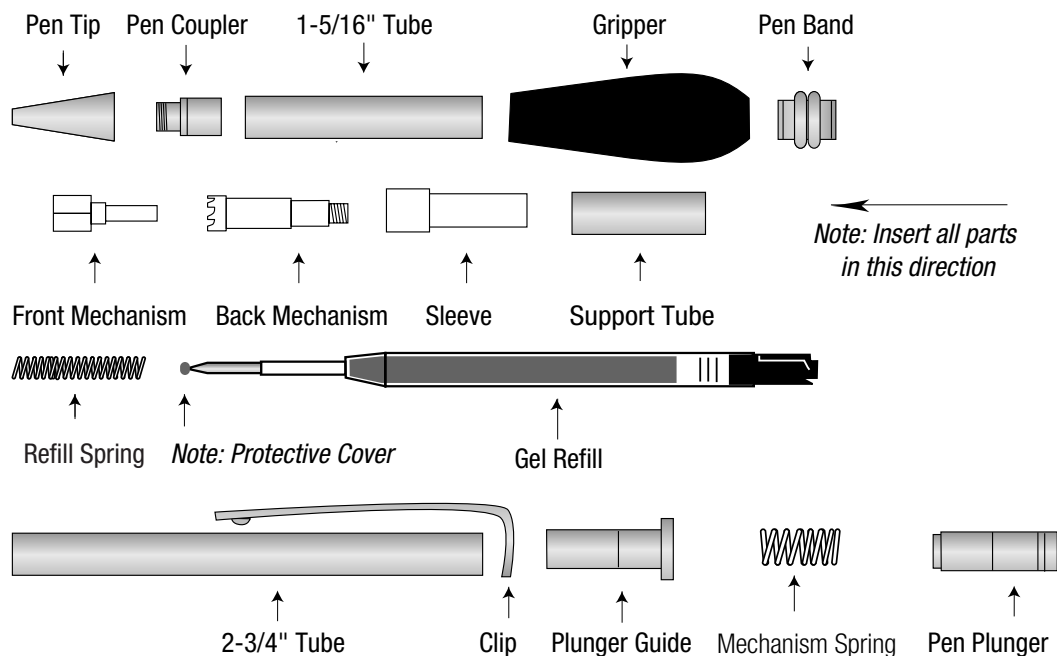
- Cut 3/4" to 1" square blank to the size of the back tube (add 1/16" for squaring off).
- Drill an 8mm center hole lengthwise through the blank.
- Spread glue over the tube and insert it into the blank with a twisting motion to spread the glue evenly inside the blank.
- Center the tube lengthwise in the blank.
- When the glue dries, square the ends of the blank. Use an 8mm barrel trimmer. Trim the wood, flush to the brass tube.

DIAGRAM B - Turning the Blank

TURNING THE UPPER BLANK

- Place 3-4 7mm spacer bushings onto the mandrel, and follow with the center bushing. Slide on the upper blank, follow with the combo/cap bushing narrow end in first. Fill the space to the threads with spacer bushings. Thread on the lock nut hand tight. Bring up the tail stock until it is snug to the mandrel shaft, lock in place, and do not over tighten (it could damage the mandrel). Tighten the lock nut to prevent the blank from spinning. Slide the sleeve snug against the blank lock with set screw.
- Turn the wood in a tapered profile from the center bushing to the cap bushing. Unscrew the set screw and slide the sleeve away from the blank, tighten. Using a skew or other flat cutting tool round the corner of the blank at the end.
- Sand and finish the barrel with your choice of polish and wax.

DIAGRAM C - Pen Assembly

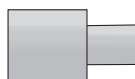


PEN ASSEMBLY

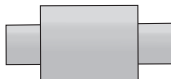
- Press the coupler, recessed end in first, into the exposed short tube.
- Slip the gripper, narrow end toward the coupler over the tube.
- Press the band into the opposite end.
- Slide the 3-piece mechanism (in the order illustrated in DIAGRAM C) into the narrow wood diameter opening of the long barrel. Follow with the support tube.
- Press the exposed end of the pen band into the long barrel, narrow wood in first (towards the support tube).
- Insert the plunger guide into the hole in the clip. Press this assembly into the opposite end of the barrel.
- Insert the pen gel refill top end in first through the coupler. Push in to connect. Drop the mechanism spring inside the plunger guide. Insert the pen plunger and screw into the threads of the back mechanism.
- Slide the refill spring over the refill tip. Thread on the pen tip.
- The pen is ready to operate by clicking the plunger to extract or retract the refill tip.

Bushings #PKEZBU

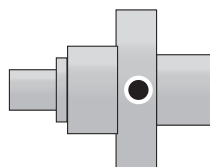
Tip Bushing



Center Bushing



Cap Bushing with Sleeve



Allen Wrench

