

# The Falcon Ballpoint Twist Pen Kit

## Features:

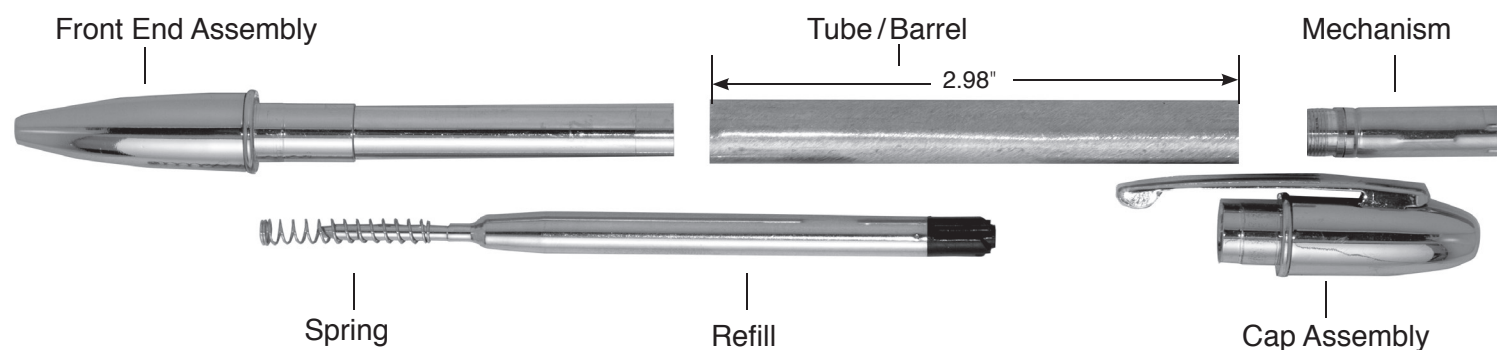
- Primary features:
- Easy to turn single tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker style refill
- Overall Length: 5 1/2"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s) 3/8" #PKEXEC-38
- Bushing set (2pc): #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 1/4"

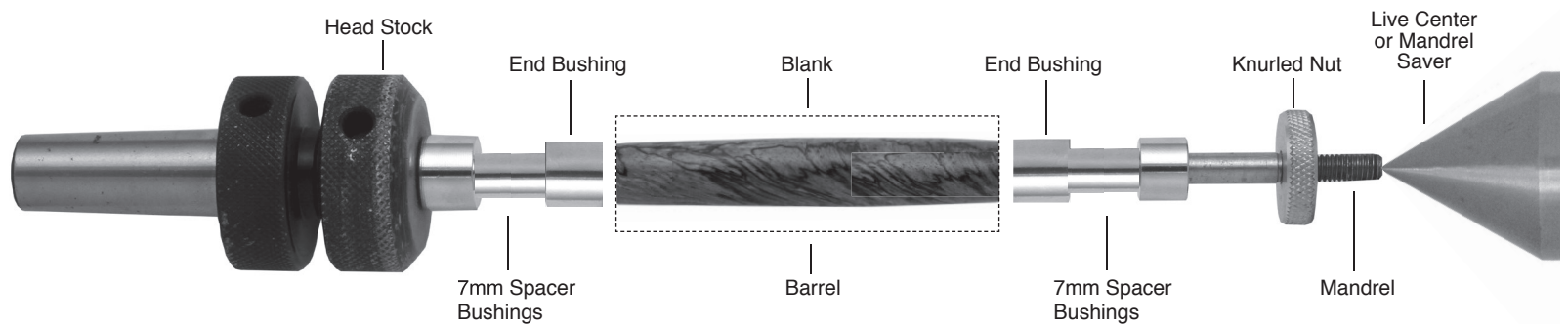


DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill 3/8" holes lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. 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).
- Use a barrel trimmer to clean the inside of the tube.

**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**

Note: Layout finished parts according parts to diagram "A"

- Press the clip assembly into either end of the barrel.
- Afix the spring over the refill. Drop this assembly into the opening of the front end assembly.
- Screw on the mechanism over the refill end.
- Press the tube/cap assembly over the front end assembly to the shoulder of the pen tip.
- The pen is ready to use by twisting the ends to advance or retract the refill when done writing. (or using)
- To replace the refill. Twist the cap assembly off to expose the refill (do not pull apart).

**Diagram C / Bushings #PKCP3000BU**