

FILIGREE TWIST PEN KIT

Kit Features:

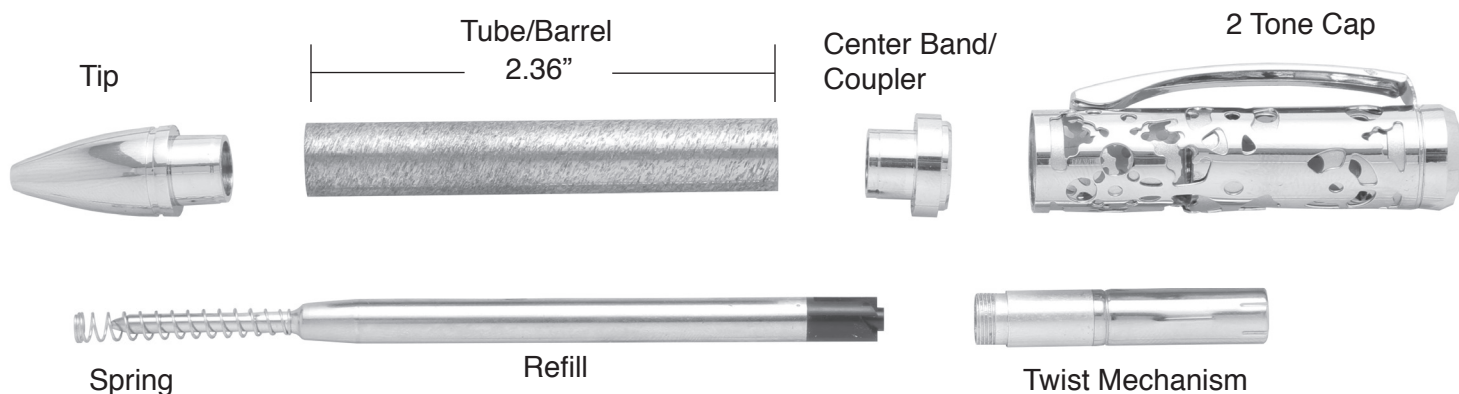
- Stylish, Steampunk 2 tone Design
- Easy to Turn With Straight Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-7/16"
- Uses Parker Style Refill #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: #PKEXEC-38
- Bushing Set(2 pc): #PKFILBU
- Barrel Trimming set: #PKTRIM38 or 3/8" sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4"x3/4"x2-1/2"L

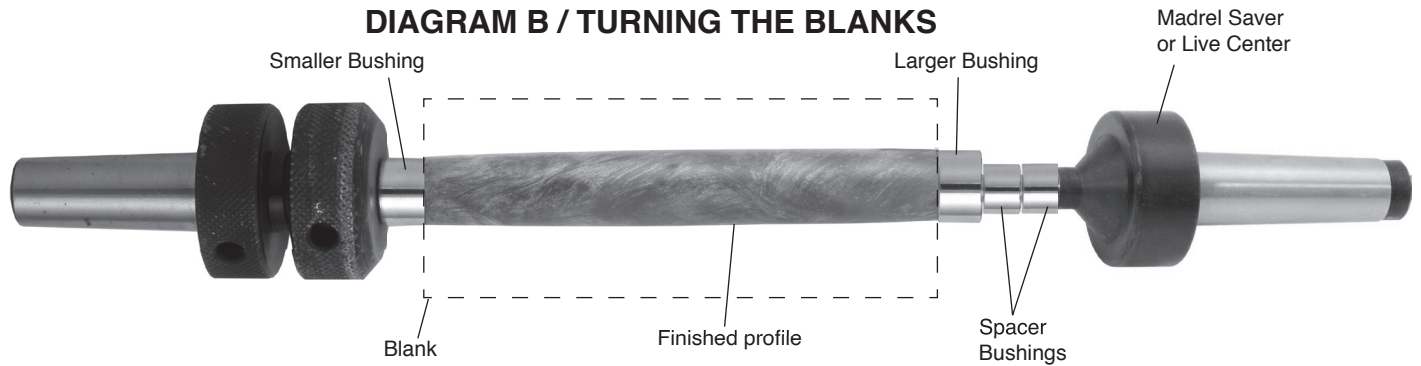


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 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 #PKTRIM38 barrel trimmer, or a pen blank squaring jig with a 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 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 Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- 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 sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

Assembly

- Arrange Parts according to Diagram A
- Press Tip into narrower end of Barrel
- Press Centerband/Coupler into wider end of Barrel
- Make sure Refill shaft is inserted into spring correctly – tapered end of Spring should grip shaft.
- Insert Refill into Barrel through Centerband
- Thread Mechanism over refill and into Centerband
- Insert back end of mechanism into Filigree Cap until Cap is fully seated on Centerband.
- Twist cap to extend and retract refill.
- To change refill, unscrew mechanism. Remember to switch the spring to the new refill.

Diagram C / Bushings #PKFILBU