

Wild Card Pen Kit

Kit Features:

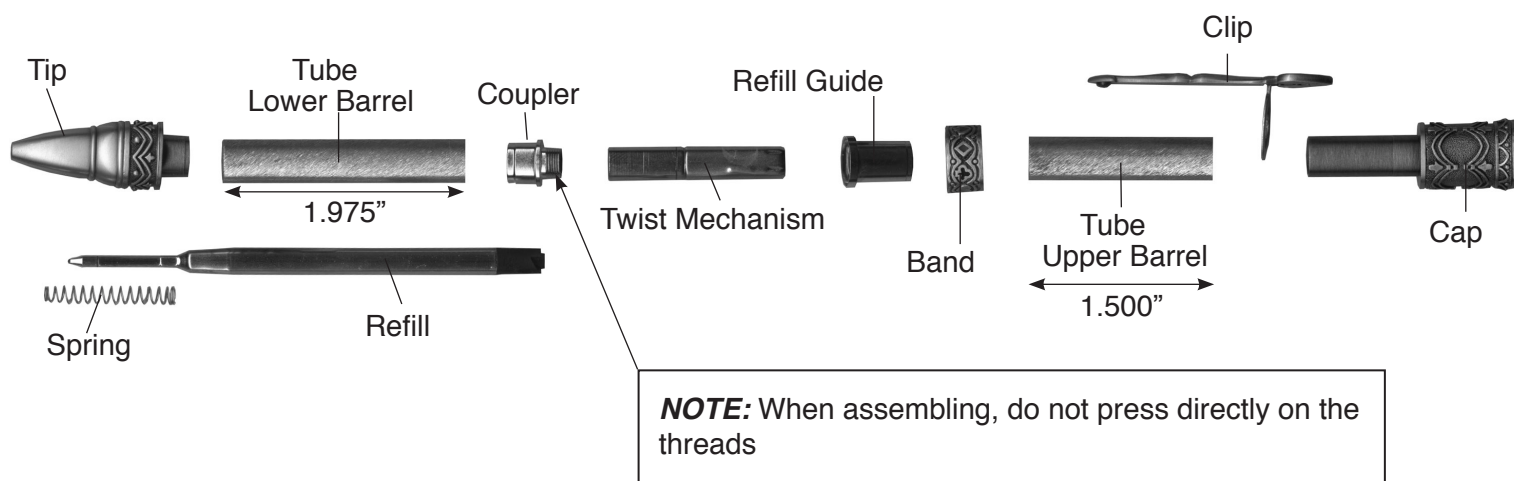
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® style refill
- Overall Length: 5-3/4"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(3 pc): #PKVICBU
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3-3/4" x 3/4"



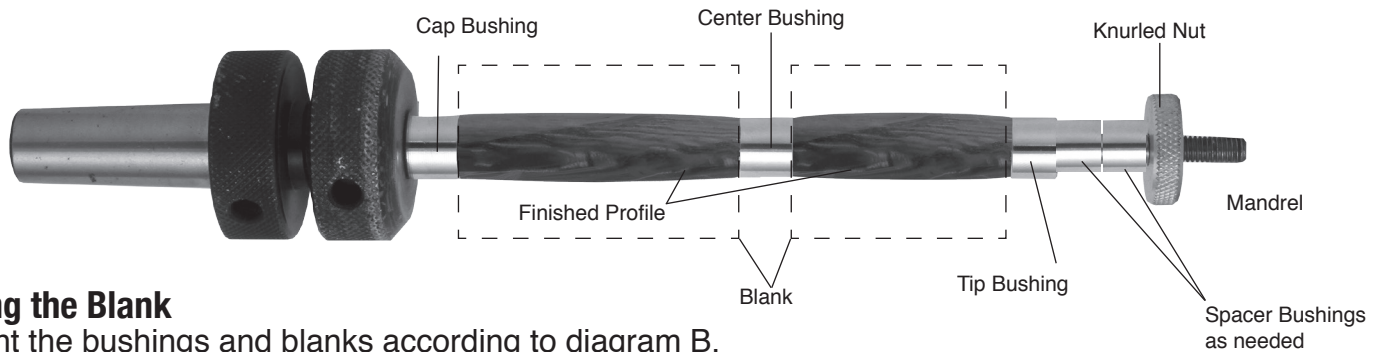
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill 3/8" holes lengthwise through the blanks.
- Spread glue over the tubes, insert into the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. 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

- Layout parts according to diagram A
 - Press the tip into either end of the longer barrel.
 - Press the coupler into the opposite end of the barrel.
- WARNING:** It is not advised to press directly over the threads, instead use a pen blank. Cut a section 3/4" long. Drill a 8mm hole through. Affix this blank over the threads and press the coupler in.
- Affix the spring over the tip of the refill, drop into the opening at the coupler. Screw the mechanism over.
 - Insert the refill guide into the recessed end of the band. Press this assembly into either end of the (shorter) upper barrel.
 - Slide the clip hole over the extension of the cap. Align with figure and pen barrel as necessary. Press this assembly into the opposite end of the upper barrel.
 - Press cap over mechanism to close the gap.
 - The pen operates by twisting the ends to advance or retract the refill end.
 - To change the refill, twist the upper barrel until it unscrews from the mechanism exposing the refill. (do not pull apart)

Diagram C / Bushings #PKVICBU