

The Great Outdoors Twist Pen Kit

Kit Features:

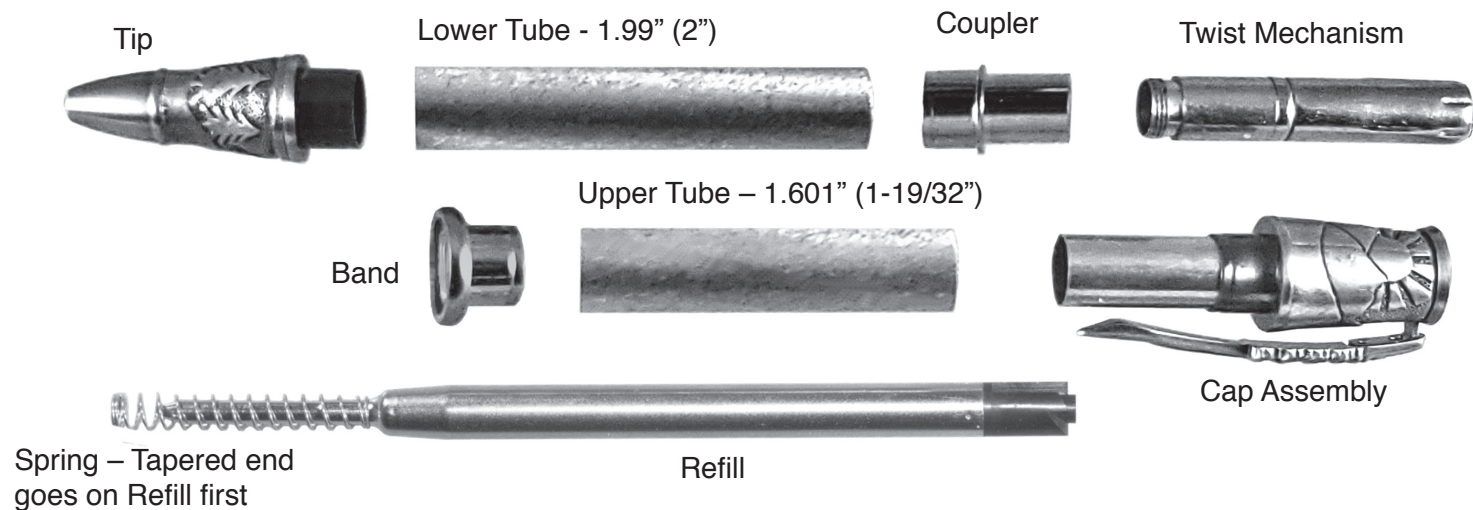
- Nature Reflecting Design Elements
- Easy to Turn With Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-7/16"
- Uses Refill: #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" - #PKEXEC-38 for Plastic, #PK-38BP for Wood
- Bushing Set(3 pc): #PKGREATBU
- Barrel Trimming: #PKTRIM38 or 3/8" sleeve from PK-TRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 3-13/16"L



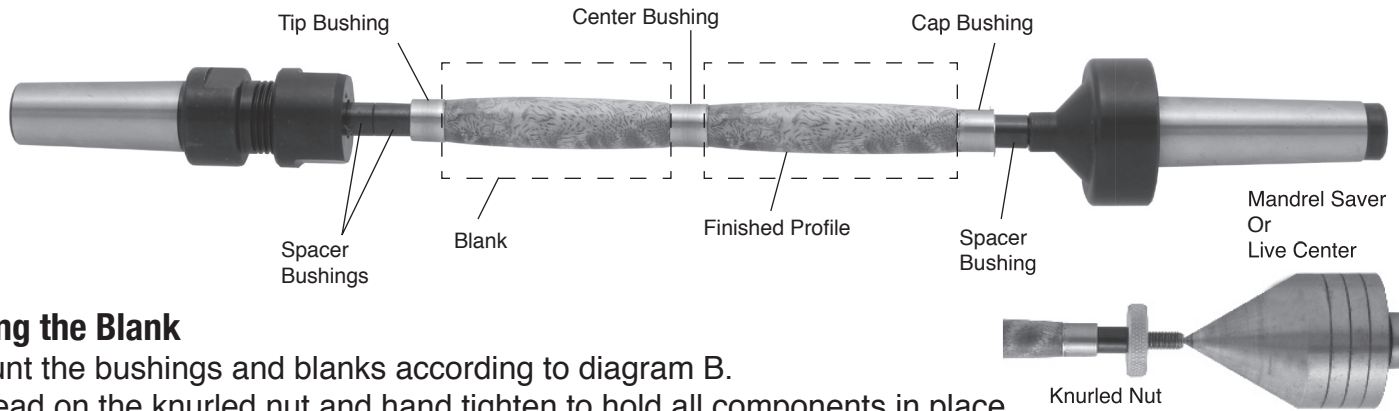
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blanks to the length of the tubes, adding 1/16" for squaring off. Tip: Making a mark on matching ends helps when mounting cut blanks onto Mandrel.
- Drill 3/8" hole lengthwise through the blanks.
- Spread glue over tubes, insert the tubes into the blanks with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blanks.
- 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 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 tubes 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 BLANK



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

- Press Tip into narrow end of Lower Barrel.
- Press Coupler into opposite, open end of Lower Barrel.
- Slide Spring – Tapered end first – on to Refill shaft.
- Insert Refill into Coupler.
- Thread Mechanism into Coupler over the back of Refill.
- Press Band into narrow end of Upper Barrel.
- Press Cap Assembly into opposite, open end of Upper Barrel.
- Slide Upper Barrel over back of Mechanism until Coupler is entirely covered by the Band.
- Twist Barrels to activate mechanism and extend and retract Refill.
- To change Refill, unthread Coupler from Mechanism. Remember to switch Spring to new Refill.

Diagram C / Bushings #PKGREATBU

