

Honeycomb Twist Pen Kit

Kit Features:

- Honeycomb Textured Design
- Easy to Turn on pen mandrel
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-5/8"

Required Accessories:

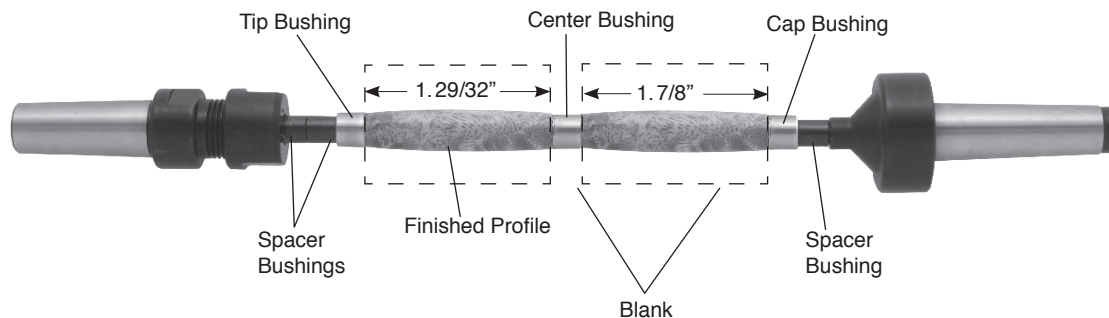
- 7mm Pen Mandrel
- Drill Bit: # PK-38BP for Wood, #PKEXEC-38 for Plastic
- Bushing Set(3pc): #PKHCBU
- Barrel Trimming: # PKTRIM38 or 3/8" sleeve from PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate Glue)
- Pen Blank Minimum Size: 5/8" x 5/8" x 4"L



Preparing the Blank:

- Cut blanks to the length of the tube, adding 1/16" for squaring off. Note that Upper Tube is slightly shorter.
- Drill 3/8" hole lengthwise through the blanks.
- 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 barrel trimmer, or a pen blank squaring jig with a 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 A / TURNING THE BLANKS



Turning the Blank

- Mount the bushings and blanks according to diagram B. Remember that Upper Tube is slightly shorter.
- 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 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.

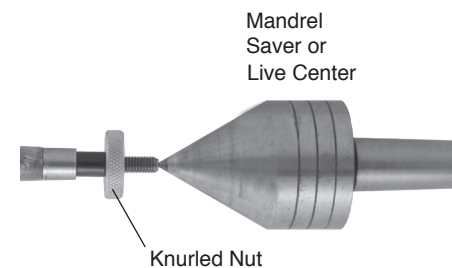


DIAGRAM B / BUSHINGS #PKHCBU

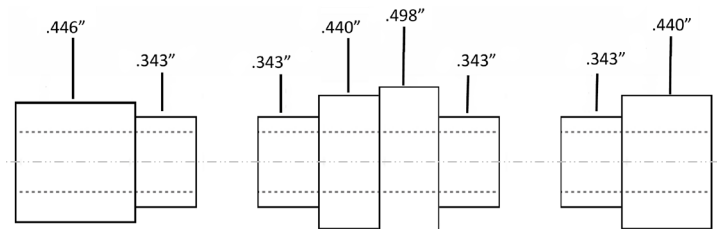
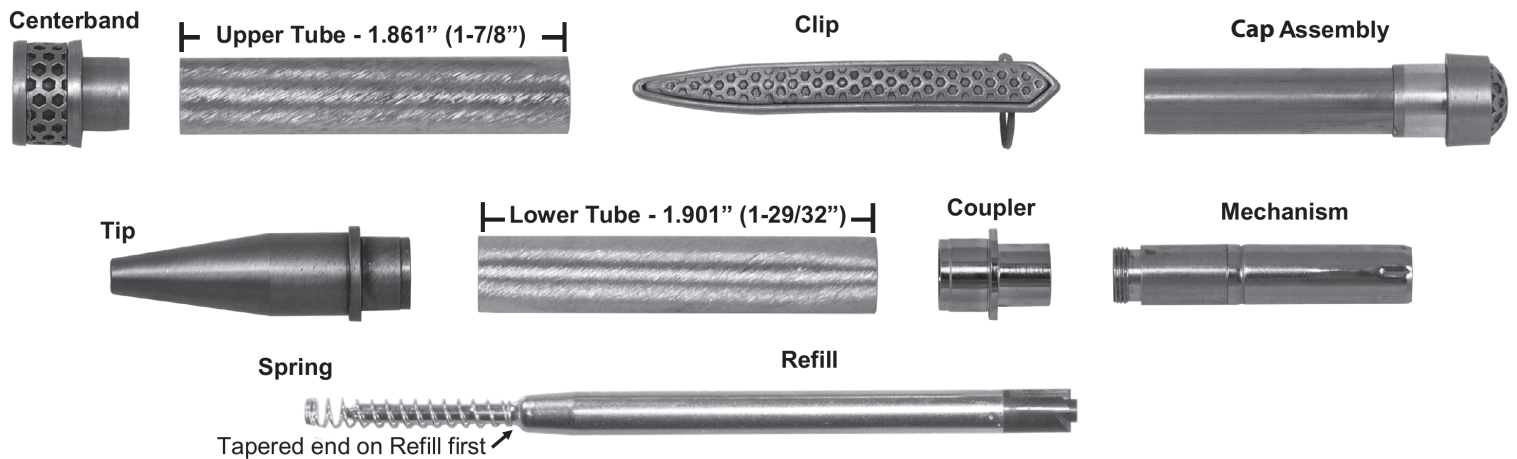


DIAGRAM C / PARTS LAYOUT



Assembly

- Press Cap Assembly, through Clip, into smaller diameter side of Upper Barrel.
- Press Center-band into opposite, open end of Upper Barrel.
- Press Tip into larger diameter side of Lower Barrel.
- Press Coupler into opposite, open end of Lower Barrel.
- Slide Spring - tapered end first – onto Refill shaft.
- Insert Refill, through Coupler, into Lower Barrel.
- Thread Mechanism into Coupler over back end of Refill.
- Slide Upper Barrel over Mechanism.
- Twist the pen barrels to extend and retract Refill.
- To change Refill: unthread rear barrel & mechanism from coupler.
Remember to switch Spring to new Refill.

