

Icon Pen Kit

Kit Features:

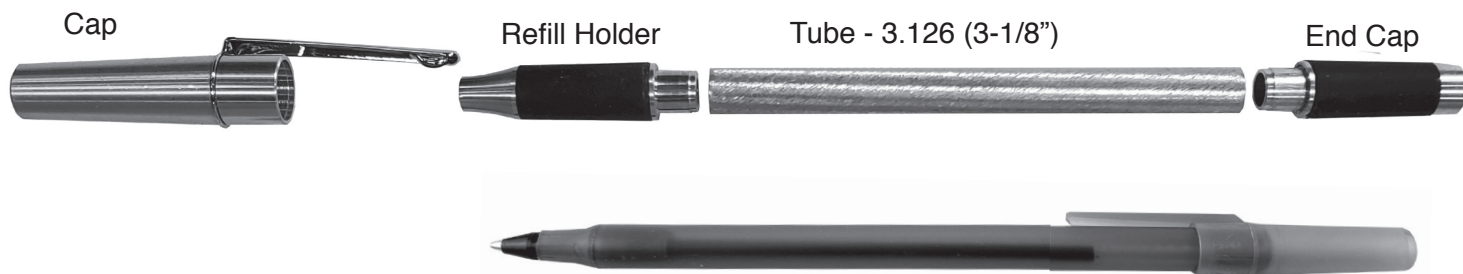
- Designed to accept BIC® Refills
- Rubber Grip Provides Comfortable Writing
- Change Ink Colors Instantly
- Easy to Turn With Straight Tube
- Minimal Parts--easy to assemble
- Available in multiple finishes
- (1) Bic® pen* with refill included
- Overall Length: 5-5/8"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: #PK-7MMSG for Plastic, #PK-7MM for Wood
- Bushing Set(3 pc): PKM-BUSH3 (Uses only two when turning)
- Barrel Trimming set: #PKTRIM7 or Squaring Jig on Disc Sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 3-3/16"L



DIAGRAM A / PARTS LAYOUT



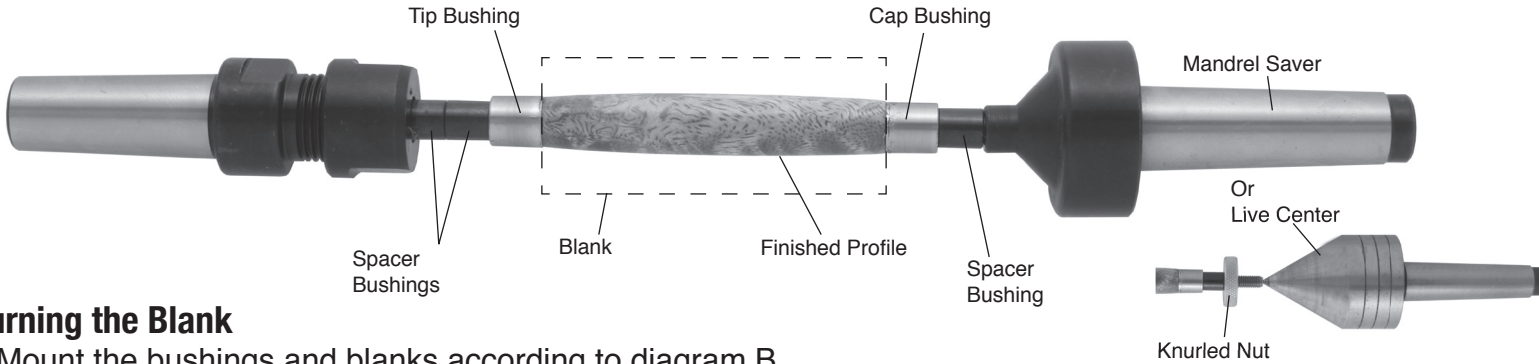
* Authentic Bic® pen supplied by an authorized Bic® distributor

Bic® pen* included to supply refill

Preparing the Blank:

- Cut blank to the to the length of the tube, adding 1/16" for squaring off.
- Drill 7mm 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 7mm barrel trimmer, or a pen blank squaring jig 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 assembly. Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANKS



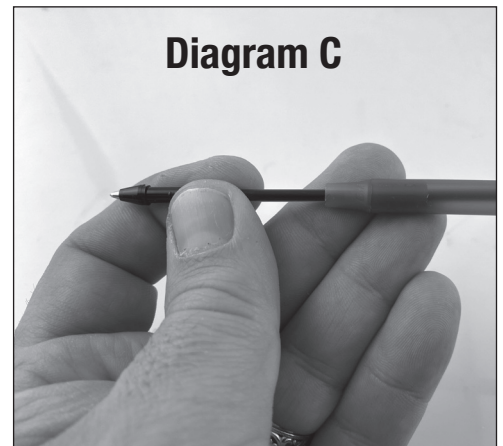
Turning the Blank

- 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

- Press Refill Holder into either end of finished Barrel.
- Press End Cap into remaining side of Barrel.
- Remove Refill from pen as shown in diagram c.
- Insert Refill, ink side first into the Refill Holder.
- Pen Cap posts over the End Post when writing, and over the Refill tip when pen is not in use.
- To change refill, simply pull the old one out of the Tip Holder and slide in a replacement.

NOTE: Bic® pens are available at most stores. Stationary, drug and food.



Remove the refill from a Bic® pen

Diagram D / Bushings #PKM-BUSH3

(only 2 are needed to turn barrel)

