

Oxford Twist Pen Kit

Kit Features:

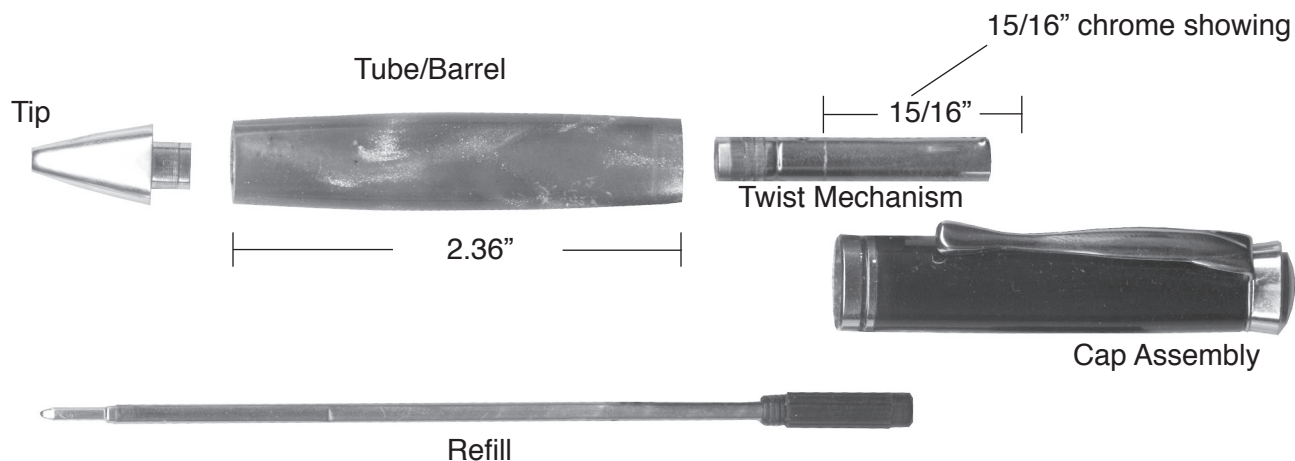
- Easy to turn with straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Overall Length: 5.500"
- Uses Cross™ style refill & mechanism

Required Accessories:

- 7mm Pen Mandrel
 - Drill Bit: #PK-7MM
 - Bushing set(2 pc): #PKJPENBU
 - Barrel Trimming set: #PKTRIM7
- (NOTE: USE BUSHINGS IN REVERSE (SEE DIA. C))
- Live Tailstock Center
 - 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
 - Pen Blank: Minimum Size - 5/8" x 2-1/2"



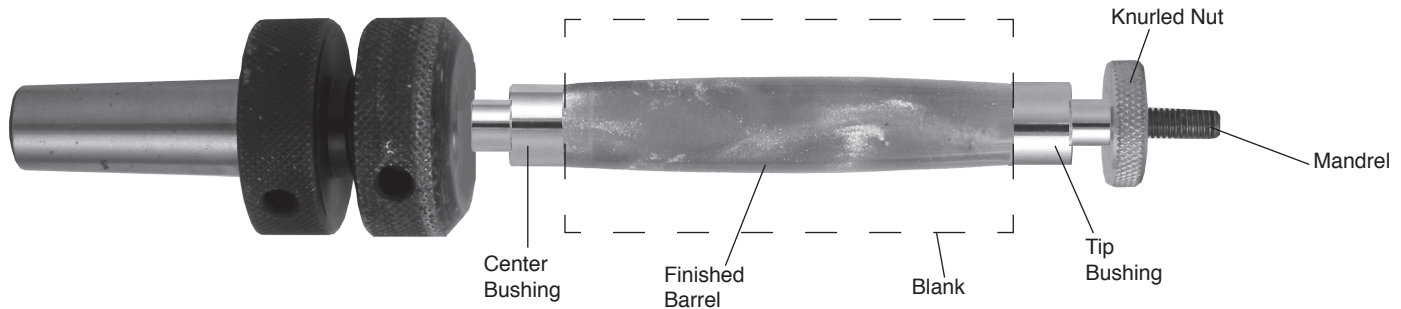
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 7mm hole lengthwise through the blank.
- Spread glue over the tube, insert 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 blank. Use a 7mm 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).

DIAGRAM B / TURNING THE BLANKS

**Turning the Blank**

- Mount the bushings and blanks according to diagram B (***bushings in reverse***).
- 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 the smaller diameter end of the barrel.
- Mark 15/16" from the chrome end of the mechanism. Press the mechanism, brass end in first into the opposite end of the barrel. Stop at the mark. See diagram "A"
- Insert the refill through the opening at the top of the mechanism. Screwing in to bottom.
- Affix the cap assembly over the mechanism to bottom.
- The pen operates by twisting the ends to advance or retract the refill end.

Diagram C / Bushings #PKJPENBU