

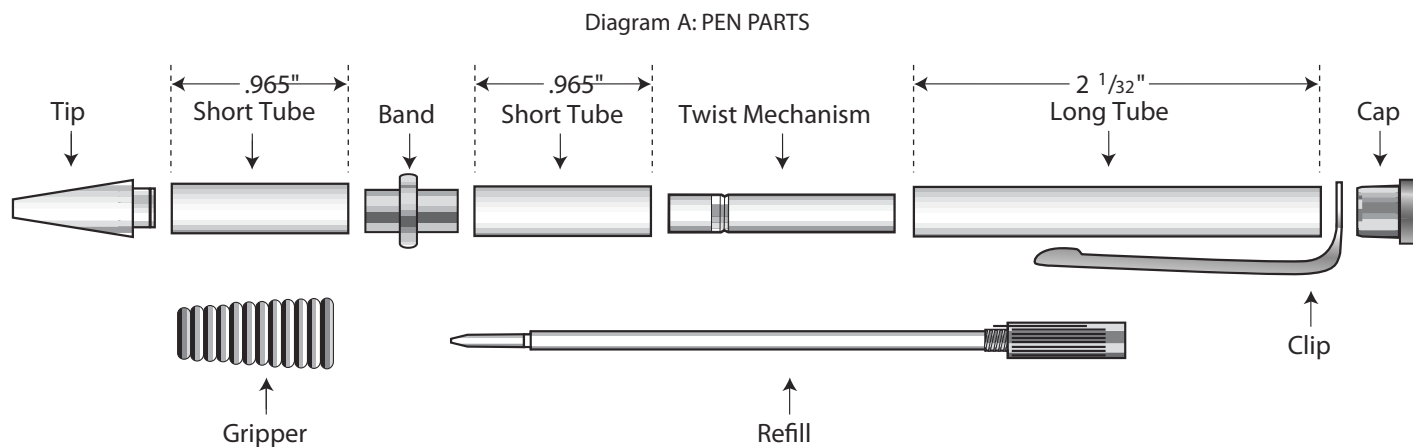
# #PKLONGPEN Longwood Pen Kit

## Kit Features:

- Heavy 24 kt gold plating with epoxy coating.
- Smooth twist operation.
- Made to match as a set with the Longwood Pencil components.
- Contemporary clip design
- Designed to show maximum wood exposure.
- Uses Cross™ style refill with locking twist mechanism.
- Overall length: 5 1/8"

## Required Accessories:

- 7mm long mandrel (#PKM-AL or appropriate).
- 3 piece bushing set #PKLONGBU
- 7 mm drill bit #PK-7MM
- 7mm barrel trimmer #PKTRIM
- 2 part epoxy glue or insta-cure (cyanoacrylate) #PKGLUE1 or PKGLUE2



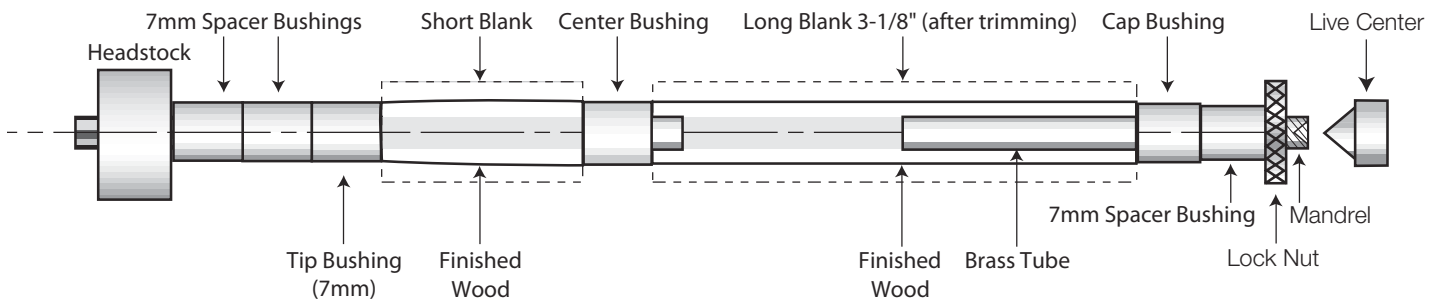
## Notes:

- If you are using the rubber gripper supplied, skip all references to placing the wood on the first short tube.
- Use pre-drilled blanks to avoid drilling through a 3 3/16" long blank.

## PREPARING THE BLANKS

- Use 5/8" square pen blanks (or pre-drilled super blanks to avoid the drilling process)
- Cut a blank 3-3/16" in length for the longer tube.
- Cut a blank to the length of the short tube (add 1/32" for squaring off)
- Drill a 7mm hole, lengthwise through each blank.
- Spread glue over both the tubes. Insert the tubes into the blanks with a twisting motion to spread the glue evenly inside. Center the shorter tube lengthwise in its blank.
- Push the longer tube into the long blank, just below the surface of the end to allow for trimming. There will be a section of this blank without a tube inside. Do not allow any glue to coat the inside of this blank where there is no tube.
- When the glue dries, use a barrel trimmer to square the ends of each blank, taking the wood down flush to the brass tube. Reduce the size of the long blank to 3 -1/8".

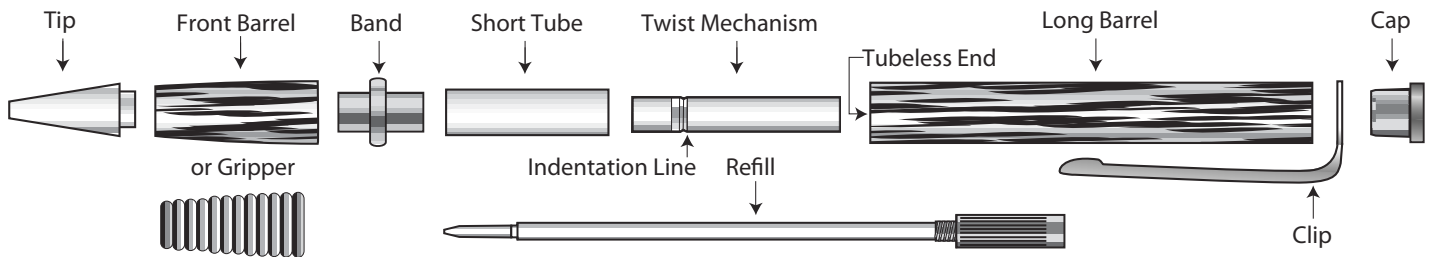
Diagram B: TURNING THE BLANKS



## TURNING THE BLANKS

- Place three 7mm spacer bushings onto the mandrel (the last one next to the blank being the tip bushing). Follow with the short blank. Insert the center bushing, wide end first. Follow with the long blank (tubeless end first) insert the extension of the center bushing inside the blank. Slide cap bushing on last. Use additional bushings to fill the space on the shaft up to the threads.
- Thread on the lock nut and hand tighten to hold all items tightly in place.
- Slide the tail stock live center snug against the mandrel shaft (Do not over tighten, it could damage the mandrel), lock in place.
- Turn the wood down flush to the bushing diameters with lathe chisels and gradual higher grits of sandpaper.
- Finish the wood on the lathe with friction polish, or use PSI clear hi-gloss project finish #HGPF, off the lathe for brilliant finish.

Diagram C: PEN ASSEMBLY



Notes: Line up finished parts according to diagram C.

## PEN ASSEMBLY

- Press the tip into the narrow end of the front wood barrel.
- Press the center band into the opposite end of the front wood barrel.
- Press the center band extension into the exposed short tube. Be careful not to damage the tube end.
- Press the pen mechanism, brass end first into the exposed tube. Push to the indentation line on the mechanism. Check with the refill inserted for the proper tip extension.
- Insert the cap into the clip. Press this assembly into the tube end of the long barrel.
- Engage both ends of the pen to close the gap.
- The pen operates by twisting the ends to extend or retract the refills tip.

BUSHINGS #PKLONGBU

