

Mayan Twist Pen Kit

Kit Features:

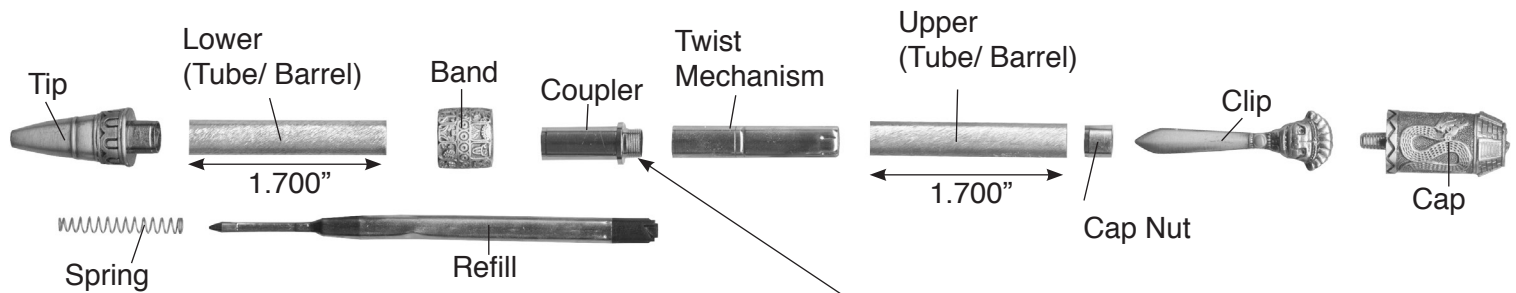
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® style refill
- Overall Length: 6"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit:#PKPARK-8MM
- Bushing set(3 pc): #PKMAYBU
- Barrel Trimming set: #PKTRIM8
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-3/4"



DIAGRAM A / PARTS LAYOUT

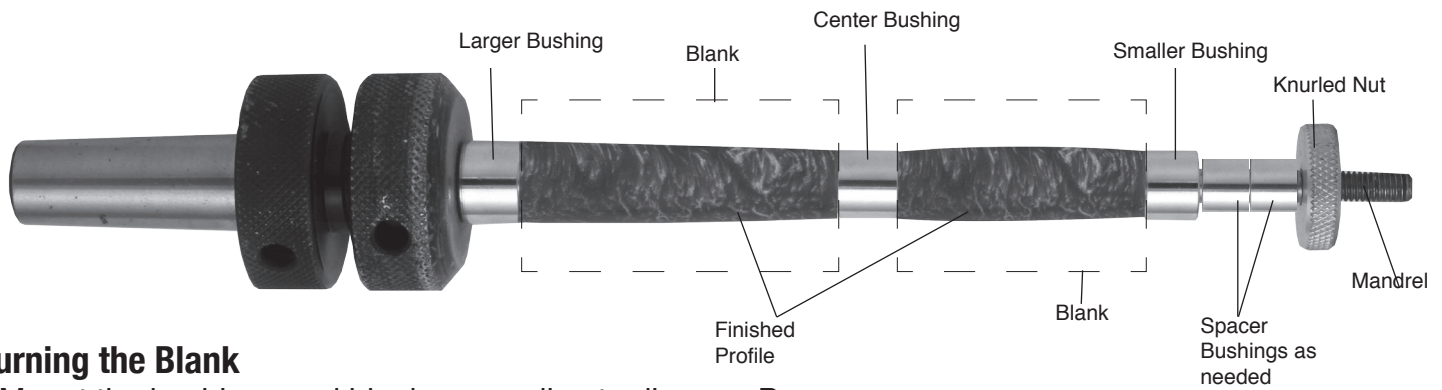


NOTE: When assembling, do not press directly on the threads

Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill 8 mm holes lengthwise through the blanks.
- Spread glue over the tubes, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. 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). 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 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 either end of the lower barrel.
- Slide the coupler into the recessed side of the band. Press this assembly into the opposite end of the lower barrel.

WARNING: It is not advised to press directly over the threads, instead use a pen blank. Cut a section 3/4" long. Drill a 8mm hole through. Affix this blank over the threads and press the coupler in.

- Affix the spring over the refill's end, insert into the opening at the coupler. Screw the mechanism over the coupler and refill.

For best alignment of clip, cap & blank assemble as follows

1. Thread the cap through the clip washer and screw the cap nut onto the thread until tight.
 2. Align the clip & cap in position over the barrel. Press assembly into barrel.
- Insert and slide the upper assembly over the exposed mechanism. Press together to close the gap.
 - The pen operates by twisting both ends to advance or retract refill. To replace refill, twist upper barrel (do not pull) until it unthreads from the mechanism to expose the top of the refill.

Diagram C / Bushings #PKMAYBU