

MOON TWIST PEN KIT

Kit Features:

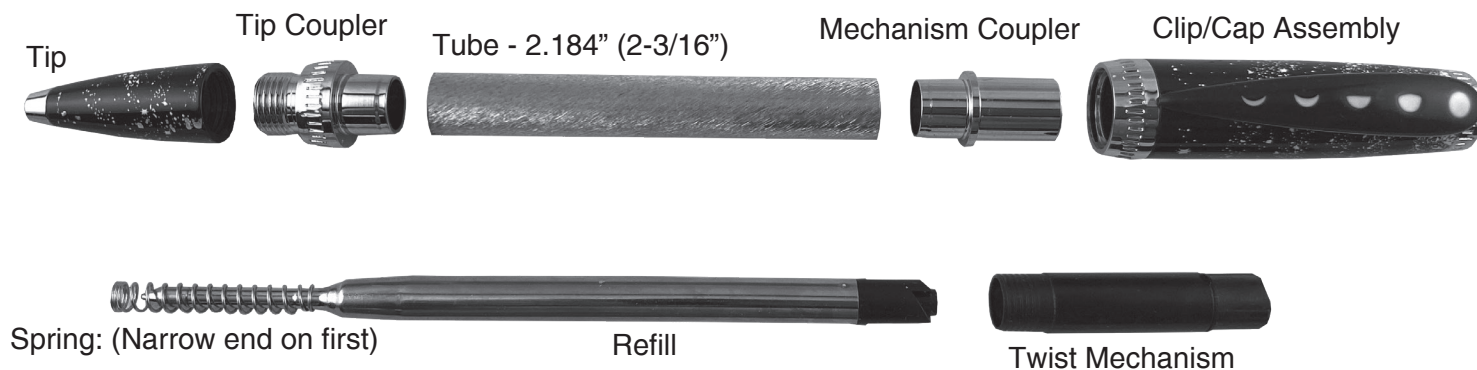
- Phases of the Moon displayed on Clip
- Cap features a “floating” Full Moon design
- Reliable Schmidt Twist Mechanism
- Easy to Turn single tube design
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-3/16”
- Uses Parker® ballpoint refill: #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit:8mm #PK-8MMSG for plastic, #PKPARK-8MM for wood
- Bushing Set(2pc): #PKMOONBU
- Barrel Trimming set: PKTRIM8 or 8mm 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 2-1/4”L

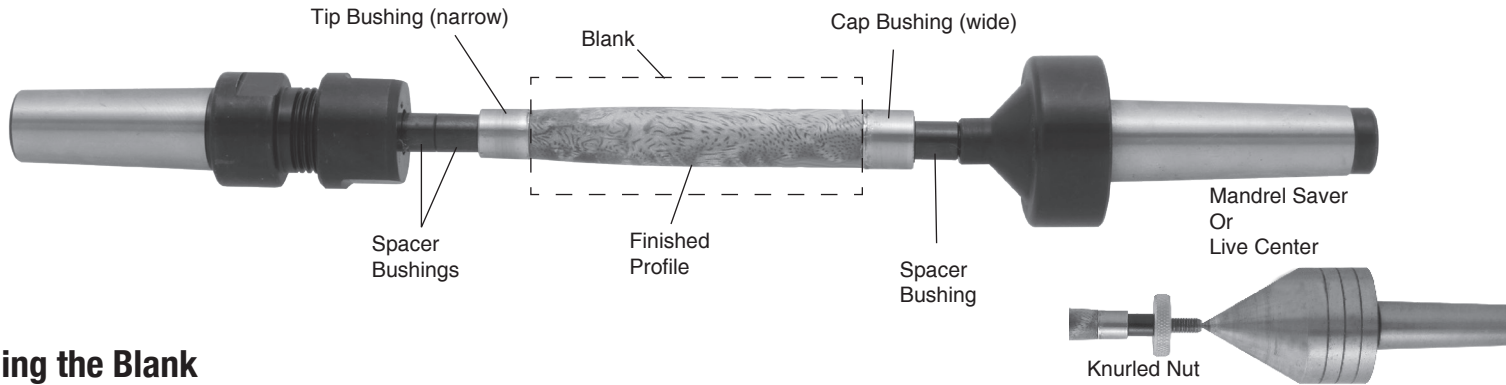


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16” for squaring off.
- Drill 8mm 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 an 8mm barrel trimmer, or a pen blank squaring jig with an 8mm 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 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

- Thread Tip Coupler on to tip.
- Press tip coupler assembly into narrow diameter end of barrel.
- Press Mechanism Coupler into wider diameter end of Barrel.
- Thread twist Mechanism into Mechanism Coupler.
- Insert Refill, back end first, through tip coupler.
- Unthread tip, Insert Refill, back end first, through Tip Coupler.
- Slide Spring, tapered end first, onto Refill shaft. Spring should grip shaft so that it doesn't get lost.
- Thread Tip back onto Tip Coupler.
- Insert Mechanism into Cap. Should go in by hand, avoid using press to insert mechanism.
- To extend and retract Refill, twist Cap Assembly.
- To change Refill, Unscrew tip. Remember to switch Spring to new Refill.

Diagram C / Bushings #PKMOONBU