

# Nautical Pen Kit

## Kit Features:

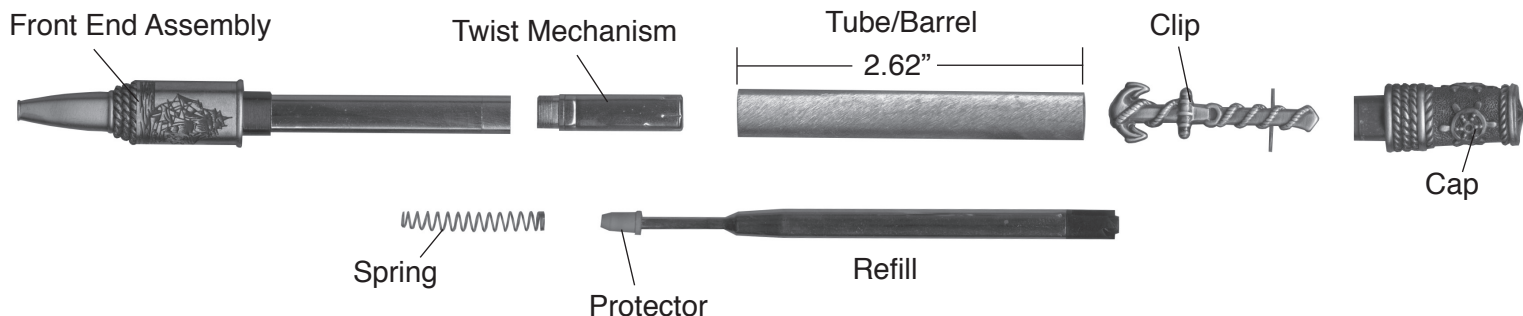
- Easy to turn with straight tube
- Minimum parts - easy to assemble
- Intricately cast and etched designs
- Available in multiple finishes
- Uses Parker® Style Refill
- Overall Length: 5-3/8"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(2 pc): #PKMAJSQBU
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3" L

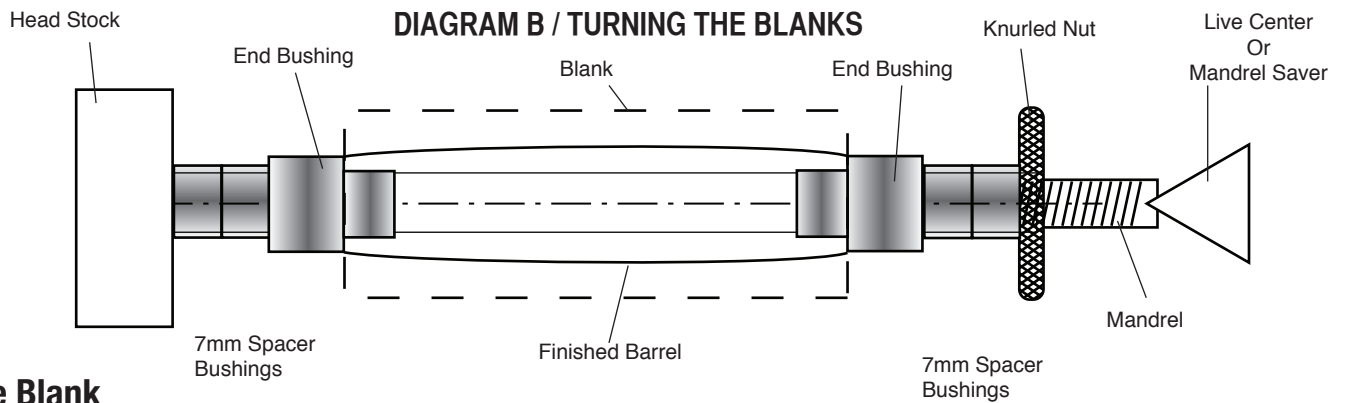


## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8 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 3/8" 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.



### 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
- Slide the clip washer over the cap connector.
- Press this assembly into either end of the barrel.
- Remove the protector off the refill. Slide the spring over the tip and drop into the opening at the front end. Screw the mechanism into the front end assembly.
- Press the barrel assembly over the twist mechanism until it closes the gap at the tip.
- The pen operates by twisting the ends to advance or retract the refill.
- Replace the refill by unscrewing the barrel assembly, removing it to expose the refill.

### Diagram C / Bushings #PKMAJSQBU

