

# "CLASSIC" FILIGREE PEN KITS

## REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- 8mm Drill Bit #PKPARK-8MM
- 4pc bushing set #PKPARFL-BU
- 8mm Barrel Trimmer #PKTRIMKIT (set)
- 2 part epoxy glue or insta-cure (cyanoacrylate)

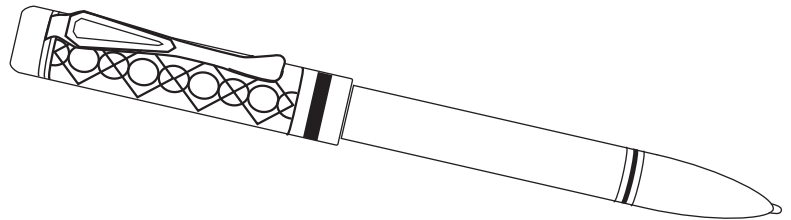
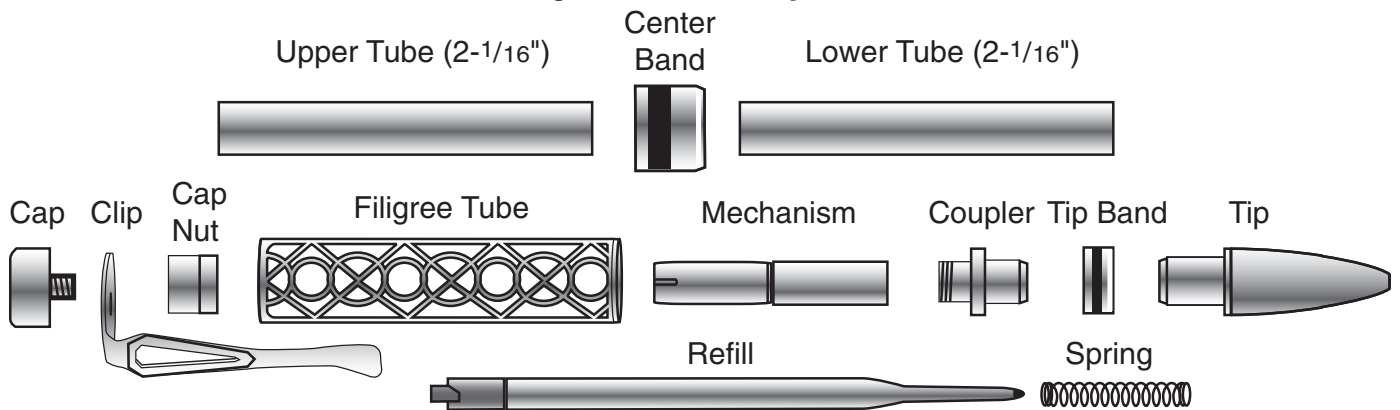


Diagram 'A' - Parts Layout



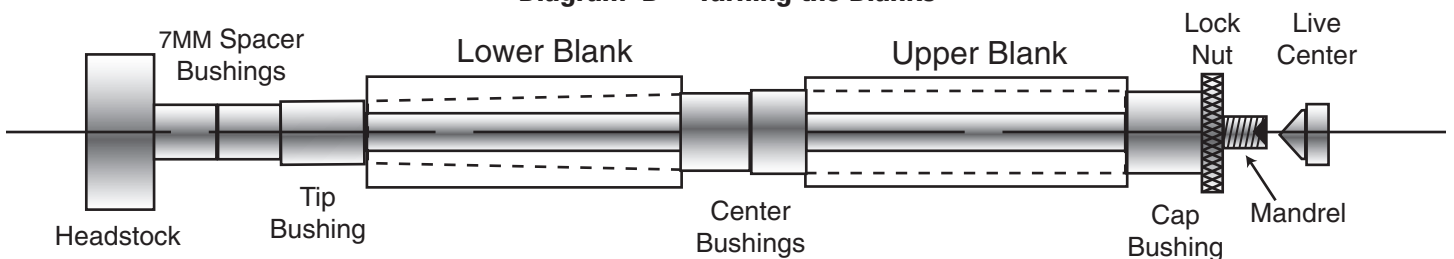
## PREPARING THE BLANKS:

1. Cut 5/8" square or larger blanks to the length of the brass tubes (add 1/16" for squaring off).
2. Drill an 8mm-centered hole, lengthwise through each blank.
3. Spread glue over the tubes; insert into the blanks with a twisting motion to spread the glue evenly inside. Center the tubes lengthwise inside the blanks
4. When glue dries; square the ends of the blanks using an 8mm barrel trimmer to take the wood down flush with the brass tube.

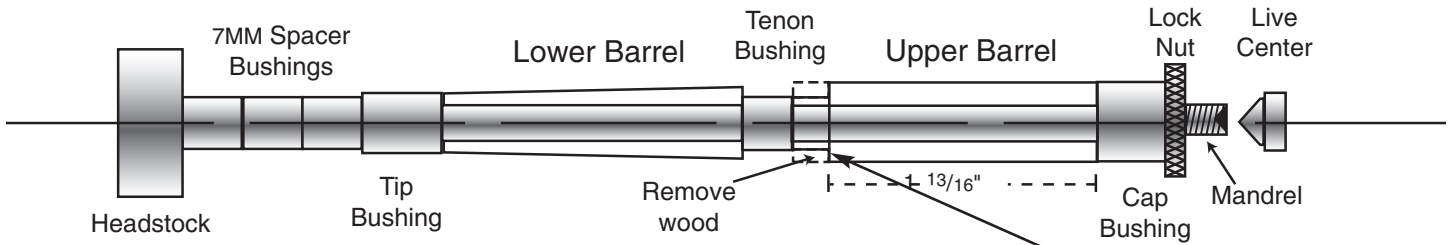
## TURNING THE BLANKS:

5. Place spacer bushings onto the mandrel. Place the tip bushing, followed with the lower blank. Place the center bushing, small diameter in first. Follow with the upper blank. Place the cap bushing over.
6. Insert the lock nut hand tight. Bring the tailstock into the mandrel. Lock in place. Tighten the lock nut (do not over tighten, it could damage the mandrel).
7. Turn the wood down to the diameter of the bushings using lathe chisels and abrasives. Form a slight taper on the lower blank. Form a straight line between the bushings on the upper barrel.
8. Test to be sure the filigree tube fits snug over the barrel. Finish the barrels.

Diagram 'B' - Turning the Blanks

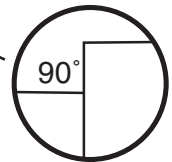


**DIAGRAM 'C' CUTTING THE TENON**



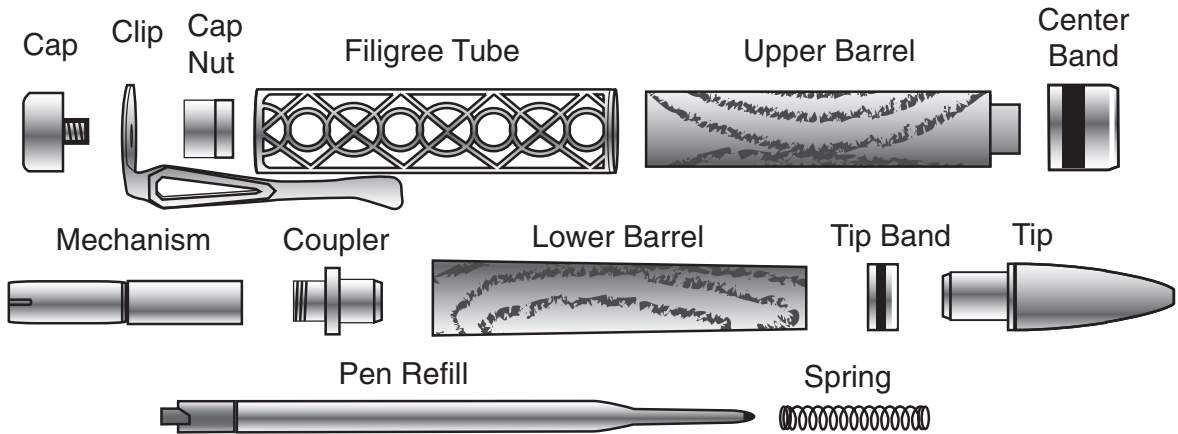
**CUTTING THE TENON:**

9. Unlock the set-up and remove the center bushing. Replace with the tenon bushing (narrow end in first). Remount the upper barrel, reset for turning. Pencil mark 1-13/16" from the cap bushing. Turn the wood down to the diameter of the tenon bushing. Keep a sharp 90° edge on both corners.



Keep corner sharp!

**DIAGRAM 'D' ASSEMBLY**



**ASSEMBLY:**

10. Line up finished parts according to diagram 'D'. For best results use the PSI #PENPRESS2 to assemble the parts.
11. Insert the tip band over the narrow end of the tip. Press assembly into the narrow end of the lower barrel.
12. Press the coupler, recessed end in first into the opposite end of the lower barrel.
13. Insert refill with spring mounted into the coupler end of the barrel.
14. Thread the mechanism over the refill end. Check the extension.
15. Squeeze a drop of glue over the tenon end of upper barrel. Slide center band over, square end first. Let dry.
16. Slide the filigree tube through the opposite end of the barrel.
17. Press in the cap nut, recessed end first into the barrel.
18. Insert the clip into the threads of the end cap. Thread into the barrel over the filigree tube.
19. Engage and push barrels together. Pen operates by twisting the barrel to extend or retract the writing tip.

**BUSHING SET #PKPARFL-BU**

