

# PRINCESS PEN #PKRPENX

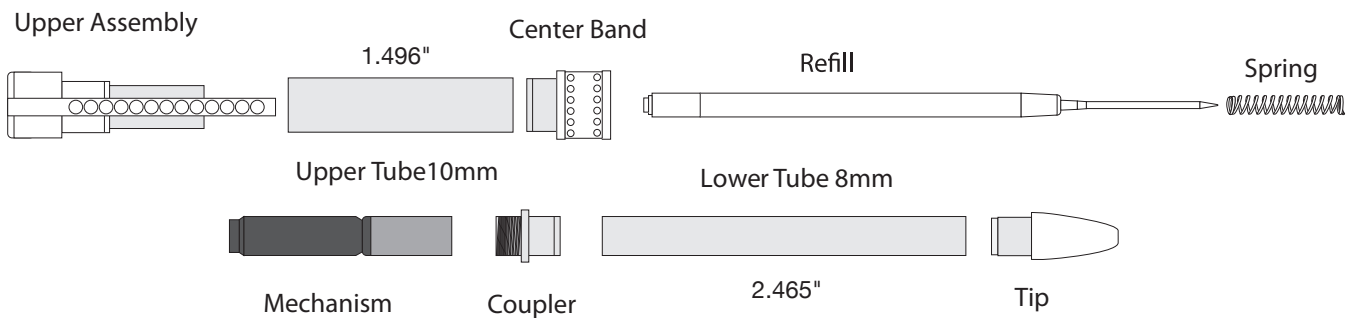
## KIT FEATURES

- An elegant pen design for the ladies
- 50 faceted Swarovski Crystals mounted over the cup and band of the pen
- Components are Plated in Gold or Chrome and guarantee for life.
- Pen uses "Parker®" type ball point refill
- Overall length: 5 1/2"
- Articulating Spring Clip

## REQUIRED ACCESSORIES

- 7mm, Long Pen Mandrel
- 3 Pcs Bushing Set #PKRPENBU
- 8mm Drill Bit, #PKPARK-8MM (for lower tube)
- 8mm Barrel Trimmer, from # PKTRIM Kit
- 10mm Drill Bit #PK10-10 (for upper tube)
- 10mm Barrel Trimmer from PKTRIM Kit
- 2-part Epoxy Glue or Insta-Cure (Cyano Acrylate)

## DIAGRAM A / Parts List



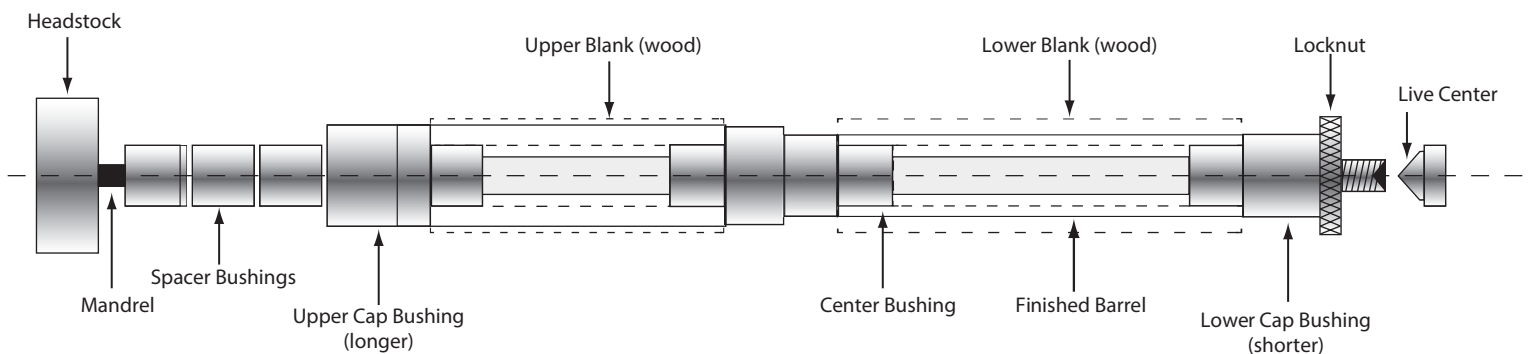
## PREPARING THE BLANKS

- Cut 5/8" to 3/4" square blank to the length of the brass tube (add 1/16" for squaring off).
- Lower Blank: Drill an 8mm center hole, lengthwise through the blank.
- Upper Blank: Drill an 10mm center hole, lengthwise through the blank.
- Spread the glue over the tube. Insert the tube into the blank with a twist motion to spread the glue evenly inside.

Center the tube lengthwise inside the blank.

- When the glue dries, square the ends of the blank. Use the proper Barrel Trimmer or belt /disc sander to trim

## DIAGRAM B / Turning the Blank



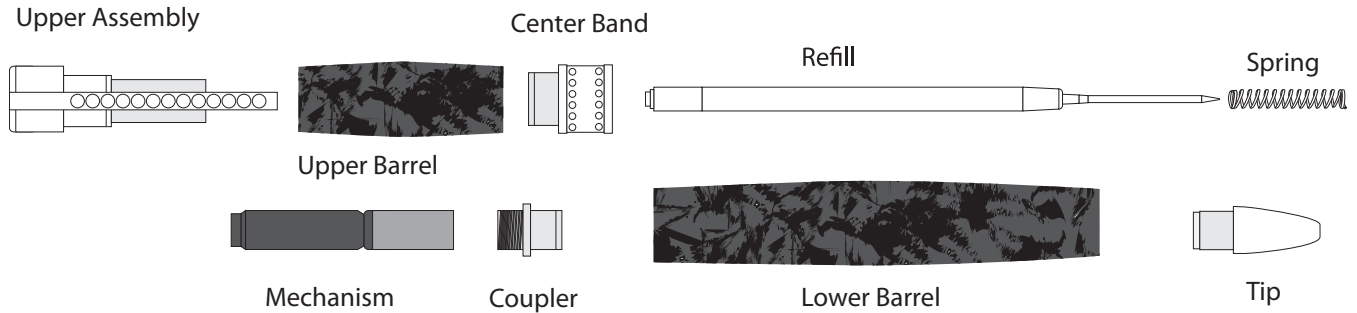
## TURNING THE BLANKS

- Place 7mm spacer bushing onto the mandrel. Next place the longer cap bushing, wider dia. first, on the mandrel. Next, slide on the upper blank, then place the center bushing (wide dia. first) on the mandrel. Slide the lower blank and follow with the shorter bushing. Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (do not overtighten, it could damage the mandrel).

Slide spacer bushing to close the space to the threads and tighten the lock nut.

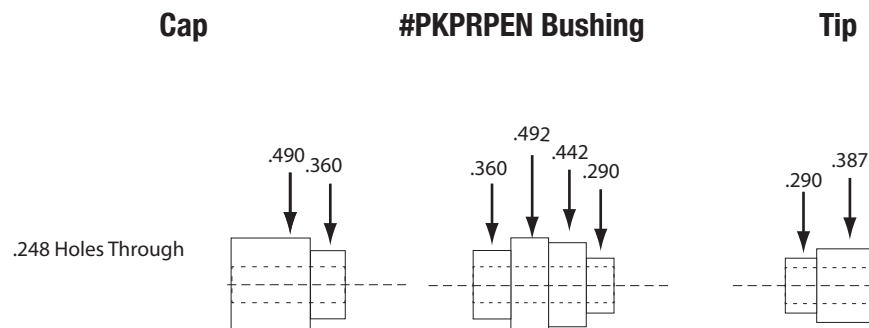
- Using the lathe chisel, turn the blank down flush with the bushing. Finish the blank with gradual higher grits of sand paper and your choice of polish.

## DIAGRAM C / Assembly Diagram



## ASSEMBLY

- Line up finished parts according to Diagram C.
- Press the upper assembly, narrow end first into the opening of the upper barrel.
- Press the center band, narrow diameter in first into the opposite end of the barrel.
- Press the tip narrow end in first, into the Lower Barrel.
- Press the coupler, narrow end in first into the opposite end of the lower barrel.
- Insert the spring over the refill. Drop into the opening at the lower barrel.
- Insert the pen mechanism, threaded end in first. Screw over the refill end.
- Engage and push the entire twist mechanism into the upper barrel.
- The pen operates by twisting the two ends to extend or retract the refill.
- To replace the refill: Pull the ends apart and change the refill. Push back together.



Philadelphia, PA 19115