

Phoenix Rising Twist Pen Kit

Kit Features:

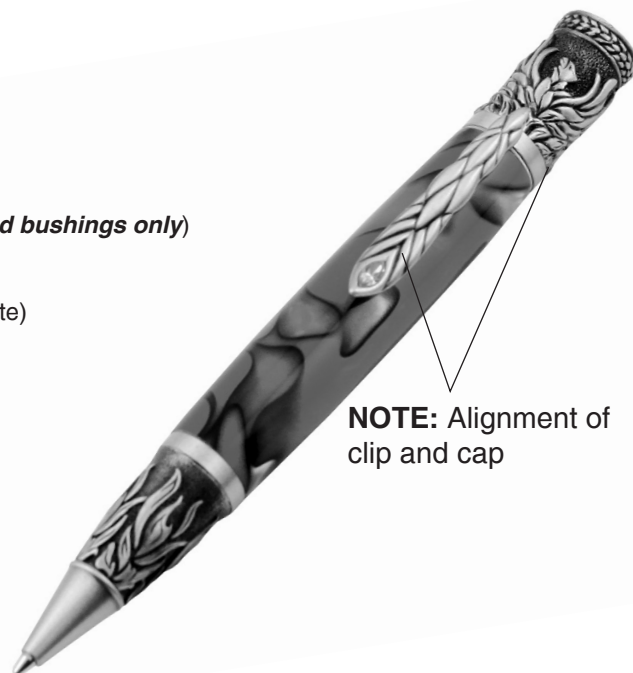
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refill
- Overall Length: 5-1/2"

Required Accessories:

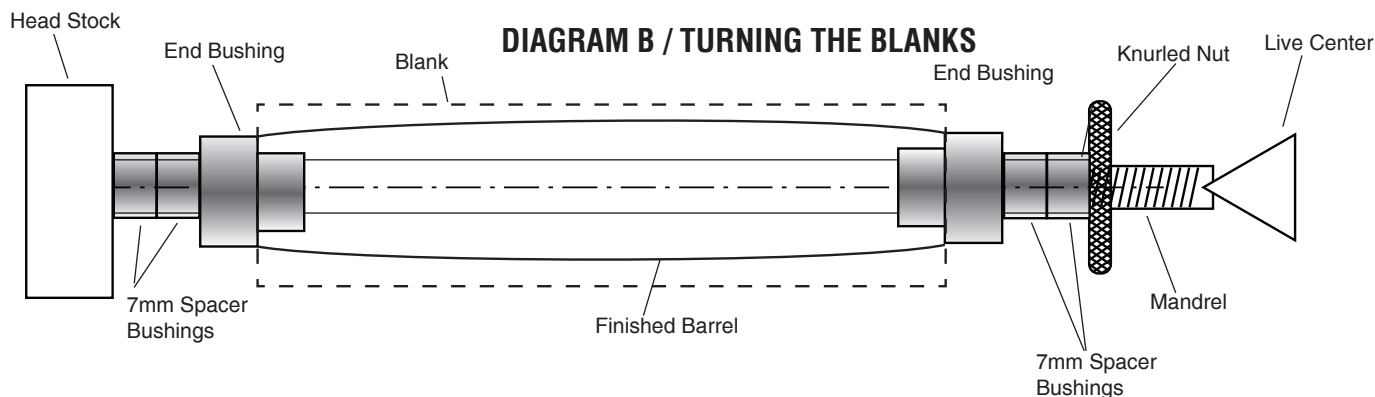
- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(3/pc): #PKVICBU (*use end bushings only*)
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or CA (Cyanoacrylate)
- Pen Blank: Minimum Size - 3/4" x 3"L

Preparing the Blank:

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



NOTE: Alignment of clip and cap



Turning the Blank

- Mount the bushings and blanks according to diagram B.
- Thread on the knurled nut and hand tighten to hold 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 over-tighten, 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 manufacturer's instructions.

Diagram C / Bushings #PKVICBU Ends Only

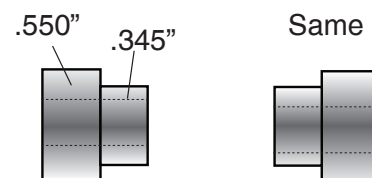
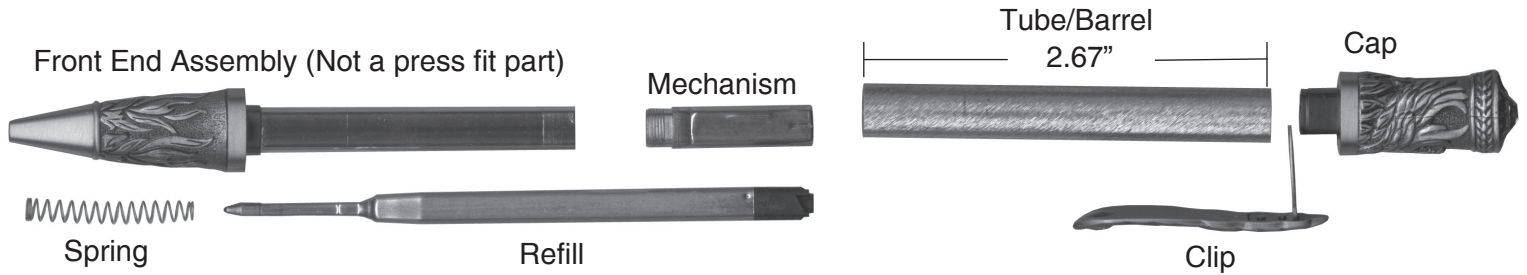


DIAGRAM D / PARTS LAYOUT

**Assembly:**

- Note that Front End Assembly does not press fit in the tube. It must be able to twist inside the tube.
- Press Cap through clip—making sure to align clip with the cap design—into either end of the Barrel.
- Slide Spring –tapered side first– onto the Refill shaft. The tapered end should grip the shaft; spring should not fall off.
- Insert Refill and Spring into the back, open end of the Front End Assembly.
- Thread Mechanism over the back of the Refill into the Front End Assembly
- Push—by hand, do not press—the Front End Assembly into the open end of the Barrel until the attached Mechanism is fully seated into the Cap Assembly inside the Barrel and the gap between the Barrel and Front End is closed.
- To extend and retract Refill, twist Front End clockwise and counter-clockwise.
- To Change Refill: Unscrew Front End Assembly from the Mechanism and replace with new Refill. Remember to switch Spring to new Refill.