

The Royal Pen Kit

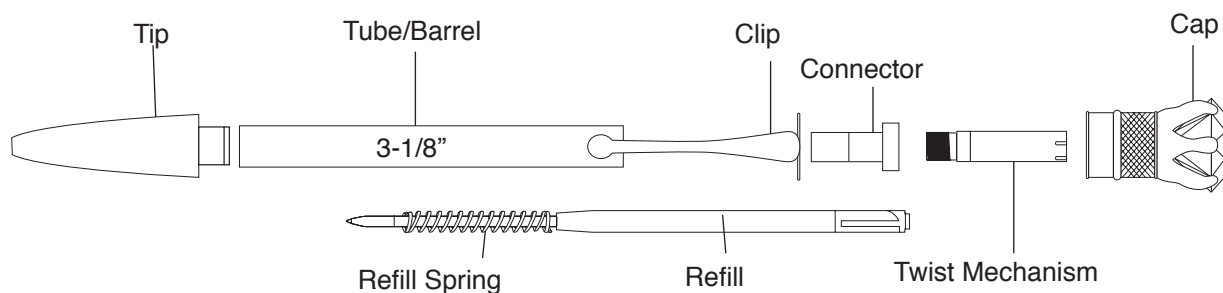
Kit Features:

- Easy to turn with a single tube.
- Minimum parts - easy to assemble
- Available in 24k gold plating
- Uses Parker® Style refills
- Overall length 5"
- 11/32" brass tube
- Gem Stone in Cap

Required Accessories:

- 7mm, Pen Mandrel
- 11/32" Drill Bit, #PK-1132
- 2 pc Bushing set #PKNICK-BU.
- Disk/belt sander or universal pen blank squaring jig.
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 5/8" x 3/1/2"

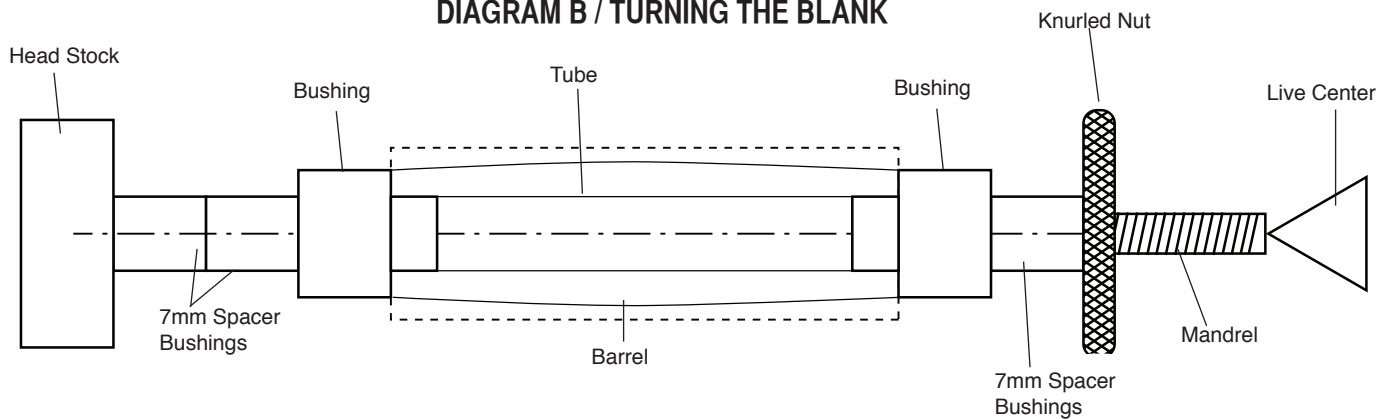
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut the blank to the length of the tube add 1/16" for squaring off.
- Drill a 11/32" 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 blanks. Use 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 brass tube or leave excess glue inside the tube since this may interfere with operation of the mechanism and assembly.

DIAGRAM B / TURNING THE BLANK

**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

NOTE: If the components are too loose to press. Use a small amount of glue inside the barrel

- Layout parts according to diagram A
- Insert the tip into either end of the barrel, press in.
- Insert the connector into the clip, press into the opposite end of the barrel.
- Place the spring over the refill end, drop the refill into the opening at the at the top.
- Screw the mechanism over the refill.
- Push the cap over the mechanism.
- The pen is now ready to use by twisting the cap.

Diagram C / Bushings #PKNICK-BU