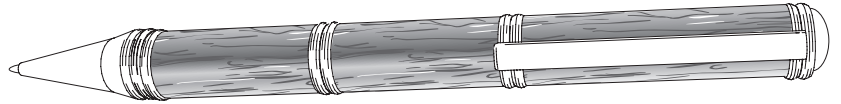


# Segmented Twist Pen Kit

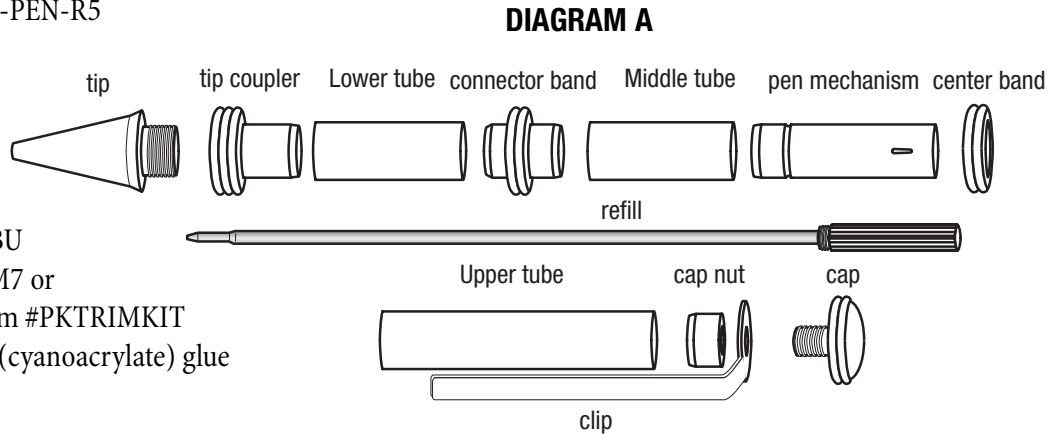


## KIT FEATURES:

- Heavy 24kt. gold plating with epoxy coating.
- Designed to match segmented magnifier (#PKSEGMAG) and letter opener kits (#PKSEGLO2).
- Smooth twist operation
- Pen uses Cross® style refill #PK-PEN-R5
- Overall length 5-1/2"

## REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- 7mm Drill Bit #PK-7MM
- 4-pc Bushing Set #PKSEGPENBU
- 7mm Barrel Trimmer #PKTRIM7 or Universal Barrel Trimmer System #PKTRIMKIT
- 2-part epoxy glue or insta cure (cyanoacrylate) glue



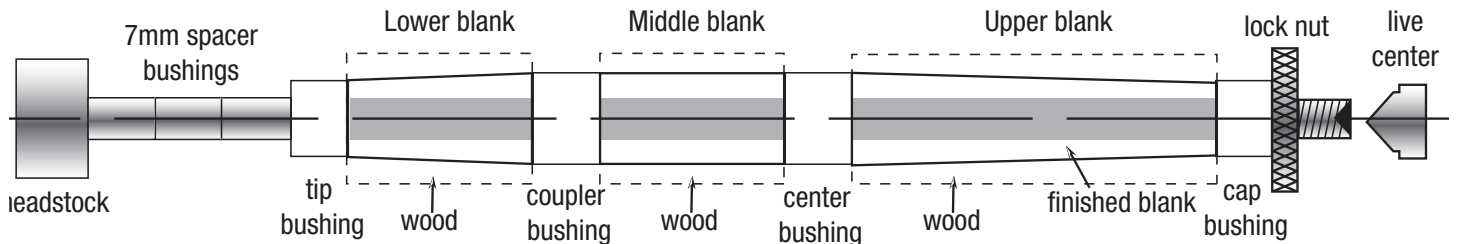
## PREPARING THE BLANK:

- Cut 5/8" square blank to the size of the brass tubes (3 each). Add 1/16" for squaring off.
- Drill a 7mm hole through each blank.
- Glue each tube and insert into the proper blank with a twisting motion to spread the glue evenly inside.
- When glue dries, trim each blank. Take the wood down to the brass tube.

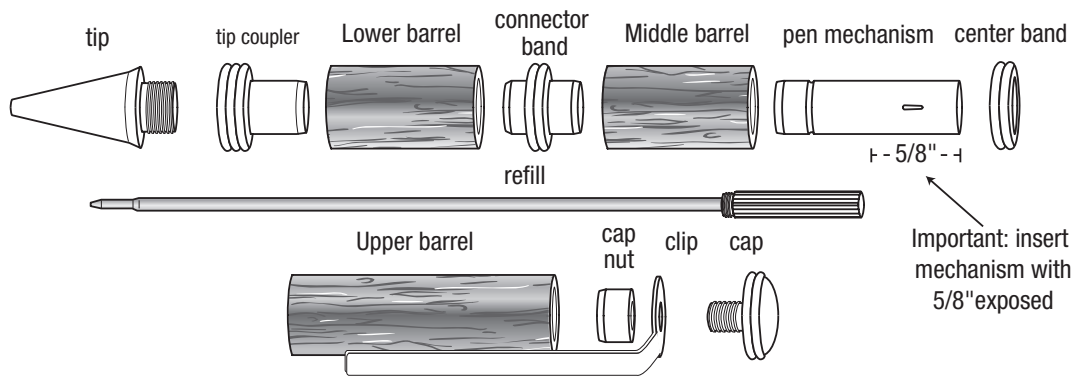
## TURNING THE BLANKS:

- Note: Tip and cap bushings are the same (short); coupler and center bushing are the same (long)
- Place three spacer bushings on the mandrel. Place the tip bushing (short) over, follow with the lower blank.
  - Insert the coupler bushing (long). Follow with the middle blank.
  - Insert the center bushing(long), follow with the upper blank. Insert the cap bushing (short) on last.
  - Thread the lock nut hand tight over the mandrel. Do not overtighten, it could damage the mandrel. Bring the tail stock snug to the mandrel, lock it into place. Tighten the lock nut for turning.
  - Turn the wood down; sand it to the bushing diameter.
  - Finish the wood with your choice of polish.

**DIAGRAM B - Turning the blanks**



**DIAGRAM C - Assembly**



**ASSEMBLY:**

- Note: Lower and middle barrels are the same size; the upper barrel is longer.
- Line up pen parts according to Diagram 'C'.
  - Press the tip coupler into the lower barrel.
  - Press the connecting band into the opposite end of the barrel.
  - Press this assembly into the middle blank.
  - Screw on the tip into the tip coupler.
  - Press the pen mechanism into the opposite end of the middle blank past the indentation line until only 5/8" of chrome is showing above.
  - Thread the refill into the pen mechanism.
  - Check for refill tip extension. Push mechanism farther in if necessary.
  - Insert the center band over the exposed chrome.
  - Press cap nut into upper blank. Align the hole in the clip with the threads in the cap. Thread assembly into the cap nut.
  - Engage both ends of the pen. The pen operates by twisting the ends to extend or retract the refill tip.

**DIAGRAM D - Bushings**

