

Serpent Pen Kit

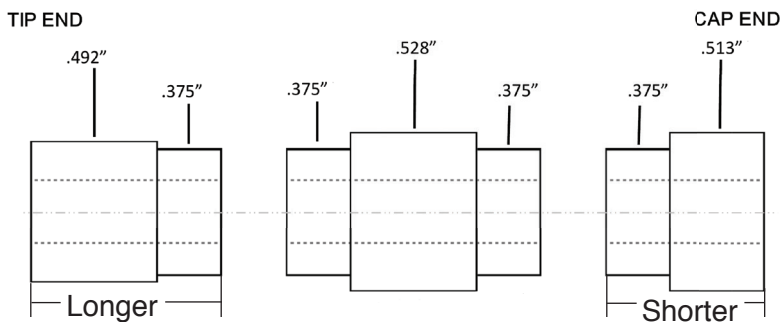
Kit Features:

- Coiled serpent adorns cap and clip
- Striking Serpent Head Cap Insignia
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-21/32"
- USES REFILL: Parker Style #PK-PARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 10.5mm #PK105MM for wood, #PK-105MMSG for plastic
- Bushing Set(3 pc): #PKSERBU
- Barrel Trimming set: #PKTRIM34 with 10.5mm sleeve from #PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 4"L

Diagram A / Bushings #PKSERBU

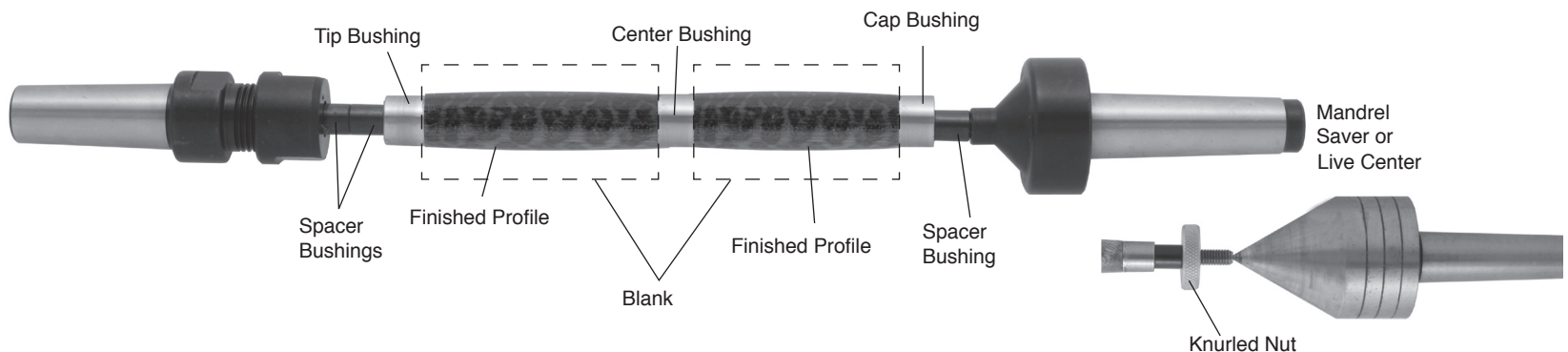


Refer to next page for parts list & assembly instructions

Preparing the Blank:

- Cut 2 blanks to the length of the tubes, adding 1/16" for squaring off.
- Drill 10.5mm hole lengthwise through the blanks.
- Spread glue over tubes, insert the tubes into the blanks with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 7mm Barrel Trimmer or Squaring Jig with a 10.5mm sleeve on a disc sander. Take the excess material down flush to the ends of the tubes. **Do not trim past the end of the tube since this may interfere with the operation of the mechanism and assembly.** Use a barrel trimmer to clean the inside of the tube.

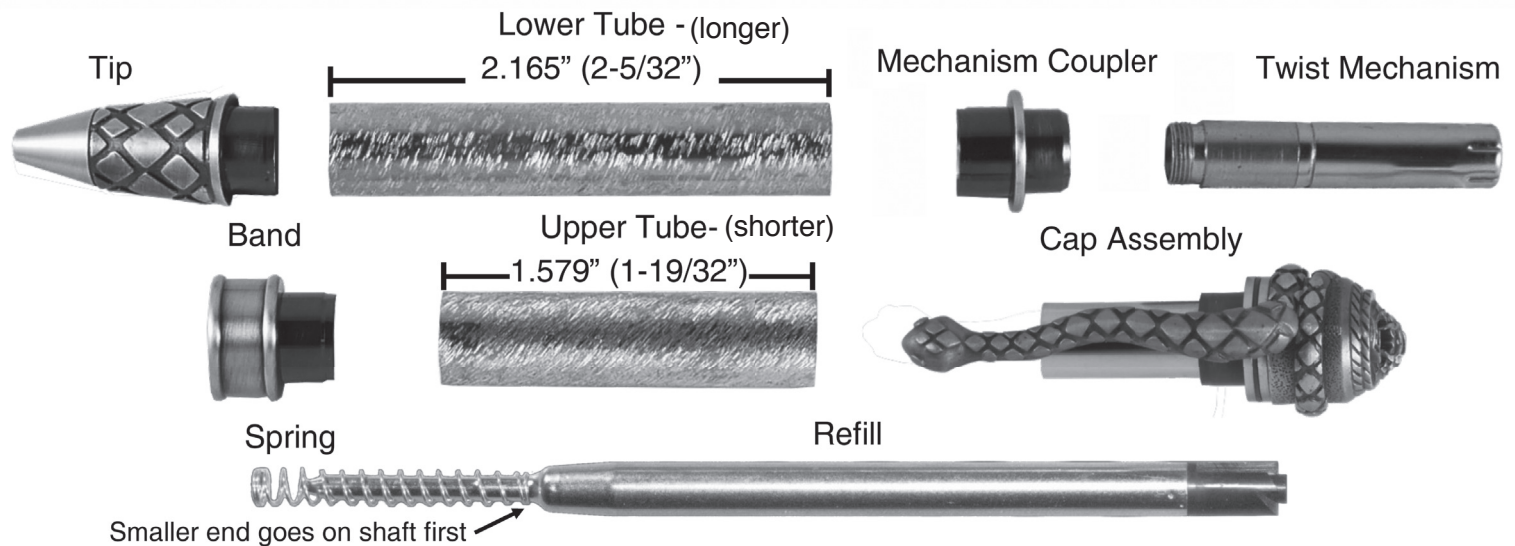
DIAGRAM B / TURNING THE BLANKS



Turning the Blank

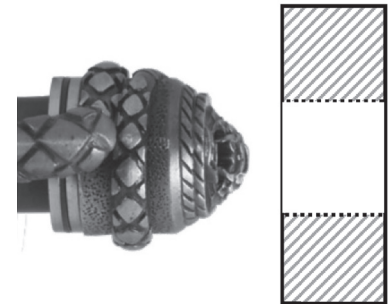
- Mount the bushings diagram A and blanks according to diagram B. Note that Tip bushing is longer and narrower than cap bushing.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple. Lock Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- 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 sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

DIAGRAM C / PARTS LAYOUT

**Assembly - Refer to parts DIAGRAM C**

- Before pressing, drill a 10.5mm hole into a piece of scrap wood (Diagram D) to use for pressing cap without damage. **It must be 10.5mm!**
- Press Tip into smaller diameter end of Lower Barrel. (longer tube)
- Press Mechanism Coupler into opposite (wider) end of Lower Barrel.
- Slide Spring - smaller end first - onto the Refill shaft – it should grip and not fall off on its own.
- Slide refill through opening in Mechanism Coupler.
- Thread Mechanism over the back of Refill and into Mechanism Coupler.
- Press Band into larger diameter end of Upper Barrel.
- Place scrap piece described in first assembly step over the serpent head design on top of Cap Assembly (Diagram D) and press into open (smaller diameter) end of Upper Barrel.
- Slide or press both parts together by hand until there is no gap.
- To extend and retract refill: twist the cap clockwise and counterclockwise.
- To change refill: unscrew Cap & Mechanism from Mechanism Coupler. Remove & replace refill. Remember to switch spring in proper orientation to new refill.

DIAGRAM D



Use scrap piece with 10.5mm hole to avoid cap damage during pressing.

