

Spider Twist Pen Kit

Kit Features:

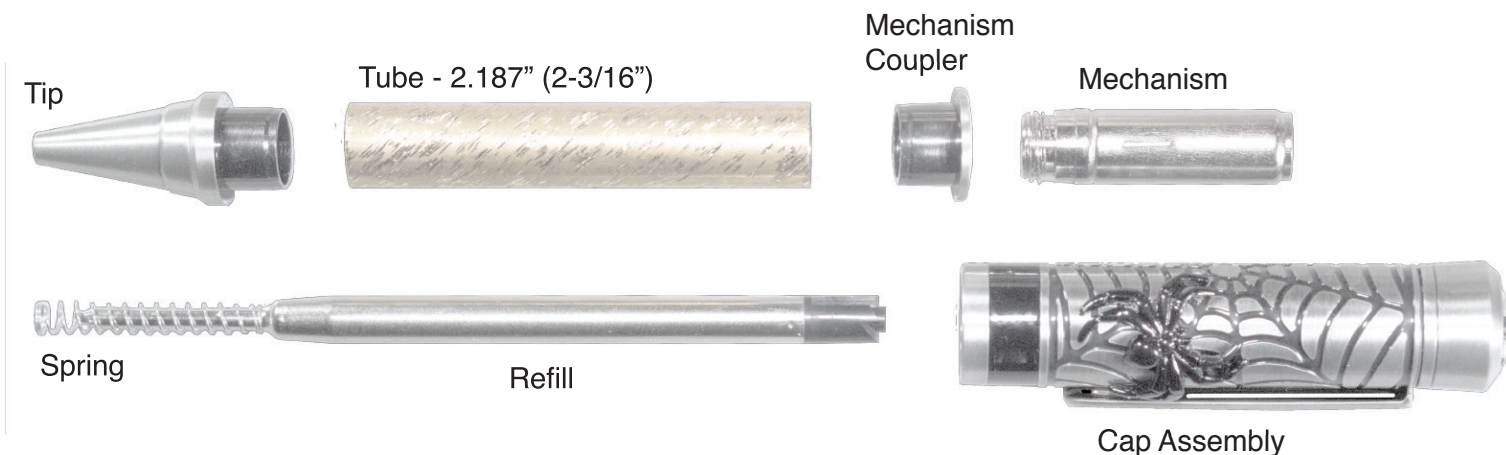
- Classic and Spooky Design Elements
- New Mechanism Setup to increase Reliability
- Easy to Turn With Straight Tube
- Minimal Parts - easy to assemble
- Available in multiple finishes
- Overall Length: 5-5/8"
- USES REFILL: #PKPARK-R5

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 10.5mm #PK-105MMSG for Plastic, #PK105MM for Wood
- Bushing Set(2pc): PKSPDRBU
- Barrel Trimming set: 7mm trim shaft with #PKMAJJRBTS 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 2-1/4"L

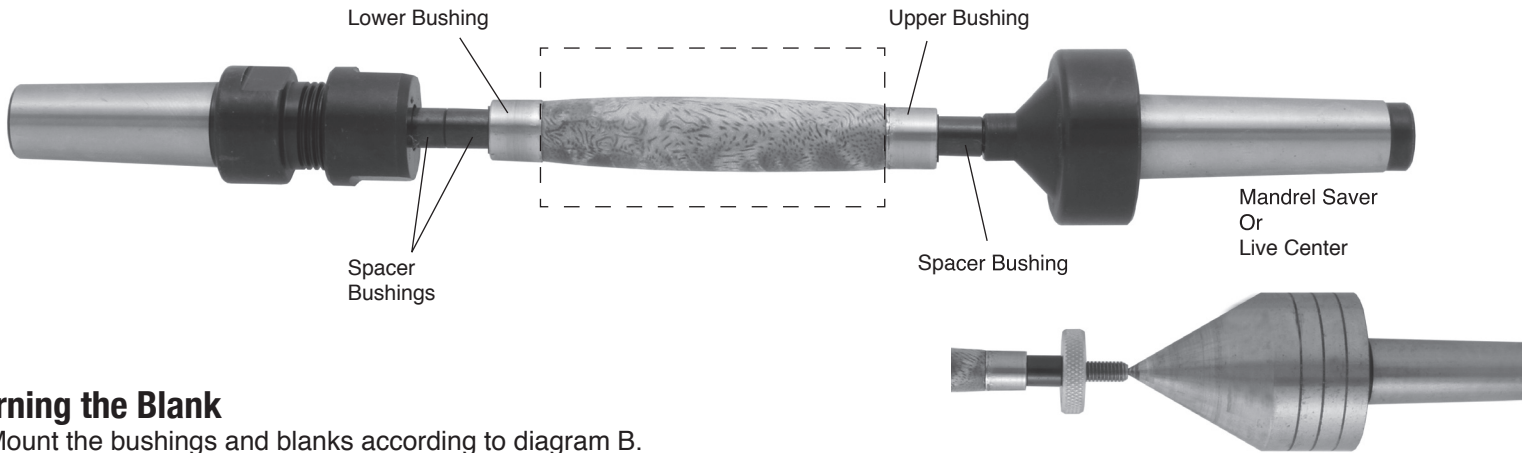


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 10.5mm hole lengthwise through the blank.
- Spread glue over tube, insert the tube into 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, making sure the trimmed ends are 90° to the tube. Use a 10.5mm barrel trimmer sleeve with a 7mm Trimmer, or a pen blank 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 file or curved scraper to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANKS**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 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.

Assembly

- Press Tip in to either end of the Barrel
- Press Mechanism Coupler into remaining end of Barrel
- Slide Spring, tapered side first, onto Refill shaft. Spring should not be loose on the Refill shaft.
- Insert Refill, Shaft Side first, through the Mechanism Coupler.
- Thread Mechanism into Mechanism Coupler over the back of the Refill.
- Slide Cap Assembly over the back of the Mechanism until gap is closed.
- To operate, twist Cap back and forth to extend and retract Refill.
- To replace refill, unscrew mechanism from Mechanism Coupler - remember to switch Spring when replacing refill.

Diagram C / Bushings #PKSPDRBU