

The Curvado Twist Pen Kit

Kit Features:

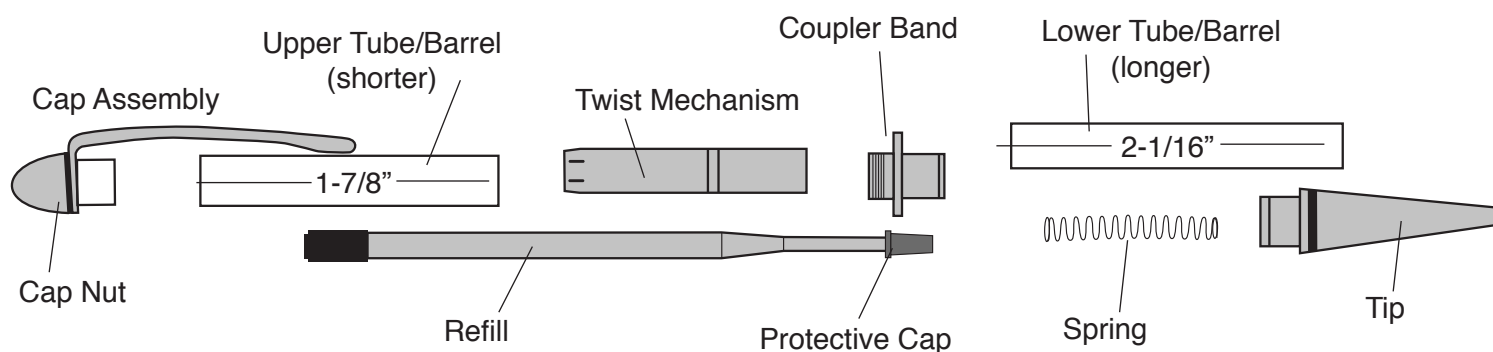
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refill
- Recessed band, Euro style
- Wide diameter for comfortable grip & custom profiles
- Overall Length: 5-5/8"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit 8mm #PKPARK-8mm
- PKSPENBU Bushing set (3 pc)
- PKTRIMKIT Barrel Trimming set (use 8mm)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 4-1/2"

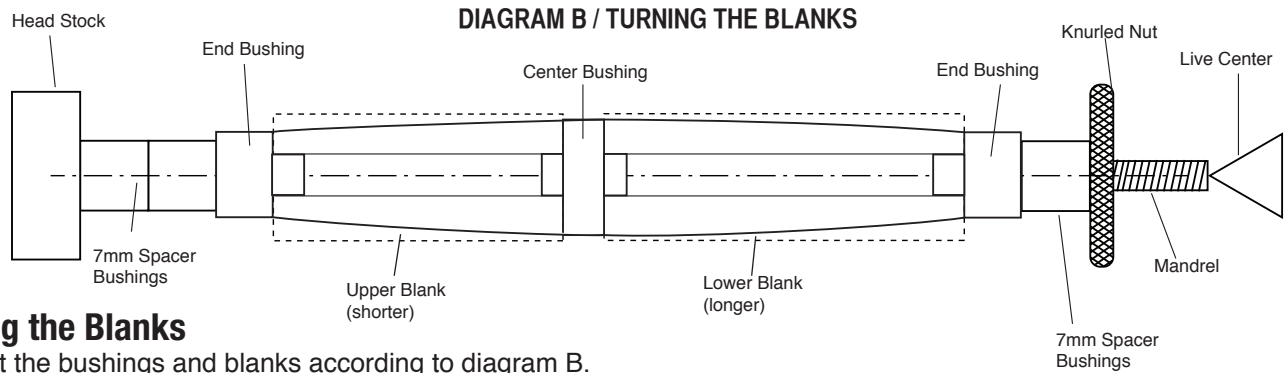


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 8mm holes lengthwise through the blanks.
- Spread glue over the tube(s), insert into the blank 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. Use the 8mm barrel trimmer shaft from the barrel trimmer set. 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 the barrel trimmer to clean the inside of the tube.



Turning the Blanks

- 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.
 - Since the bottom of the barrels are exposed - sand and finish the exposed areas.
 - Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.
- Refer to polish instructions.

Assembly

- Layout parts according to diagram A
- Press the clip assembly into the narrow end of the upper barrel (shorter).
- Press the coupler band into the wide end of the lower barrel.
- Press the tip into the opposite end of the lower barrel.
- Remove the protective cap from the tip of the refill. Place the spring on the refill and drop it into the opening of the barrel.
- Screw the mechanism over the coupler band.
- Engage the two halves of the pen.
- If the clip is loose tighten the cap nut.
- The pen operates by twisting the ends to advance or retract the refill tip.

Diagram C / Bushings #PKSPENBU

