

Southwest Twist Pen Kit

PKSWPAP • PKSWPAB

Kit Features:

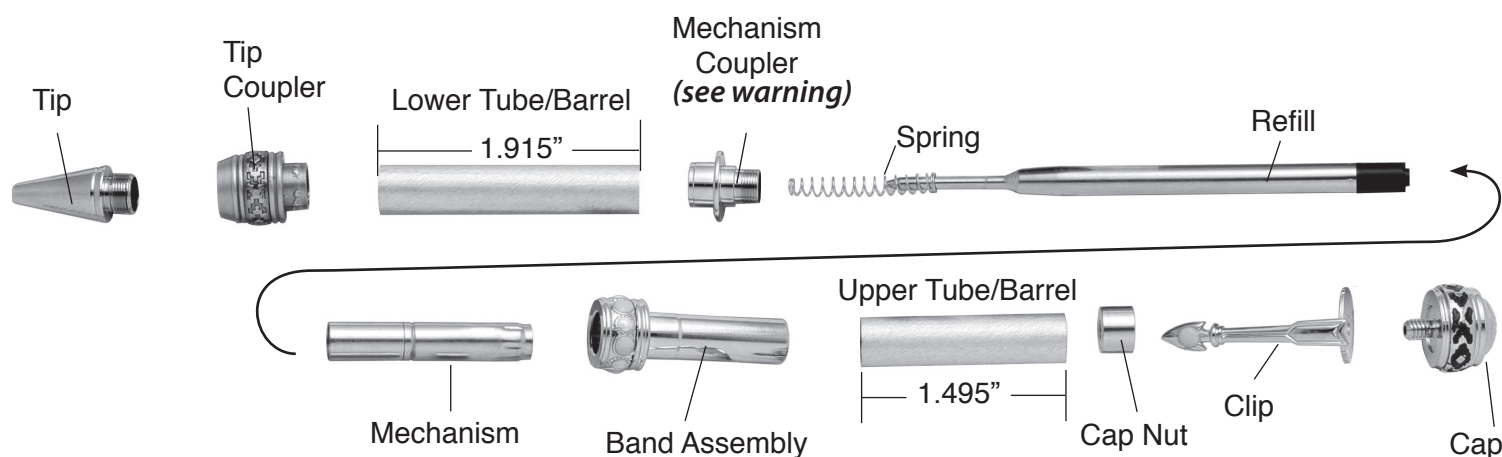
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Attractive decorative Southwest Components
- Uses Parker® Style refill

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(3 pc): #PKSWPBU
- Barrel Trimming set: PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-3/4"



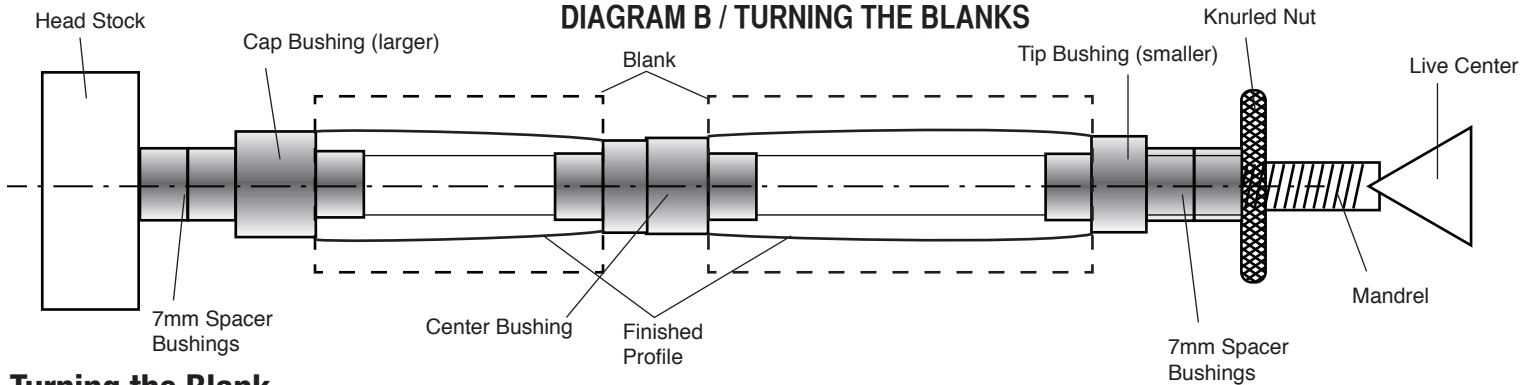
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 3/8" holes lengthwise through the blanks.
- Spread glue over the tube(s), insert 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 a 3/8" barrel trimmer, or 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 tube since this may interfere with 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 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 each 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

- Layout parts according to diagram A
- Press the tip coupler into either end of the lower barrel (longer)
- Press the mechanism coupler into the opposite end of the barrel

WARNING: DO NOT PRESS MECHANISM COUPLER WITHOUT PROTECTING THE THREADED END. USE EITHER METHOD BELOW

A. Cut a 1/2" pen blank w/ a 8mm hole through. Affix over the shoulder and press in. Or...

B. Affix the upper barrel over the threads. Press in over the shoulder.

- Screw the tip into the tip coupler.
- Affix the spring, wide diameter first over the refill tip. Insert this into the opening in the mechanism coupler. Screw the mechanism over the mechanism coupler.
- Press the band assembly into the smaller diameter of the upper barrel.
- Press the cap nut, recessed end in first into the opposite end of the barrel.
- Place the clip over the screw on the cap. Screw into the cap nut. Tighten.
- Engage both ends of the pen.
- The pen operates by twisting the ends to advance or retract the refill tip.

Diagram C / Bushings #PKSWPBU