Southwest Mesa Kit

Kit Features:
• Easy to turn with straight tubes
• Minimum parts - easy to assemble
• Available in multiple finishes
• Uses Parker® style refills
• Overall Length: 5-5/8”

Required Accessories:
• 7mm Pen Mandrel
• Drill Bit: 3/8” #PKEXEC-38
• Bushing set(2 pc): #PKCHPENBU
• Barrel Trimming set: #PKTRIM38
• Live Tailstock Center
• 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
• Pen Blank: Minimum Size - 3-1/2” x 3/8”

Preparing the Blank:
• Cut 1 blank to the length of the tube and add 1/16” for squaring off.
• Drill a 3/8” hole lengthwise through the blank.
• Spread glue over the tube, insert 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. 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.

NOTE: When assembling, do not press directly on the threads
**Assembly**

- Layout parts according to diagram A
- Affix the spring over the refill end.
- Drop refill into the opening at the front end assembly.
- Screw the twist mechanism over the refill and into the front end assembly.
- Attach the clip over the connector thread and screw the cap over tight.
- Press this assembly into either end of the barrel (avoid pressing & damaging the stone on end of cap)
- Insert the front end assembly into the opening at the barrel to close the gap.
- The pen operates by twisting the ends to advance or retract the refill.
- To replace the refill, unscrew front end assembly from the tip end.

**Diagram C / Bushings #PKCHPENBU**

- Diameter: Ø 0.445”
- Diameter: Ø 0.345”
- Diameter: SAME
- Holes through: 0.248”