

Tank Twist Pen Kit

Kit Features:

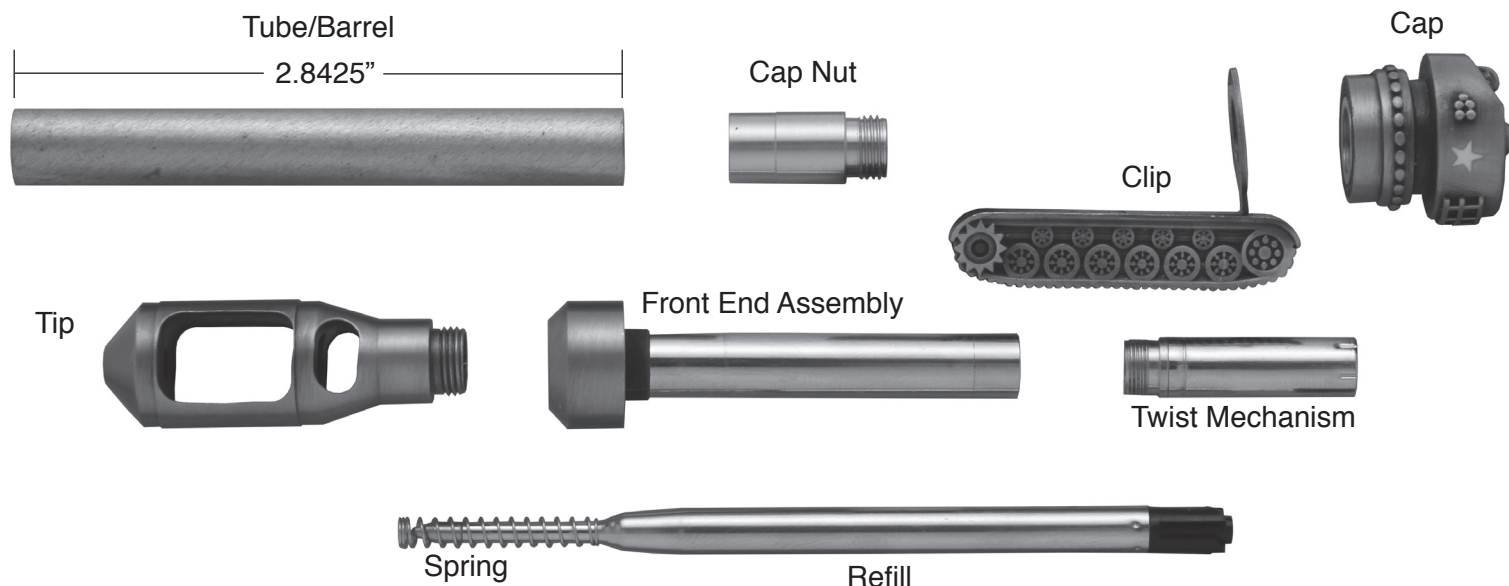
- Attractive Intricate Tank Theme
- Easy to Turn With Single, Straight Tube
- Minimal Parts-easy to assemble
- Available in multiple finishes
- Overall Length: 5-9/16"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit:#PKEXEC-38
- Bushing Set(2 pc): #PKTANKBU
- Barrel Trimming set: #PKTRIM38 or pen blank squaring jig with a 3/8" Sleeve
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4"x3/4"x2-15/16"



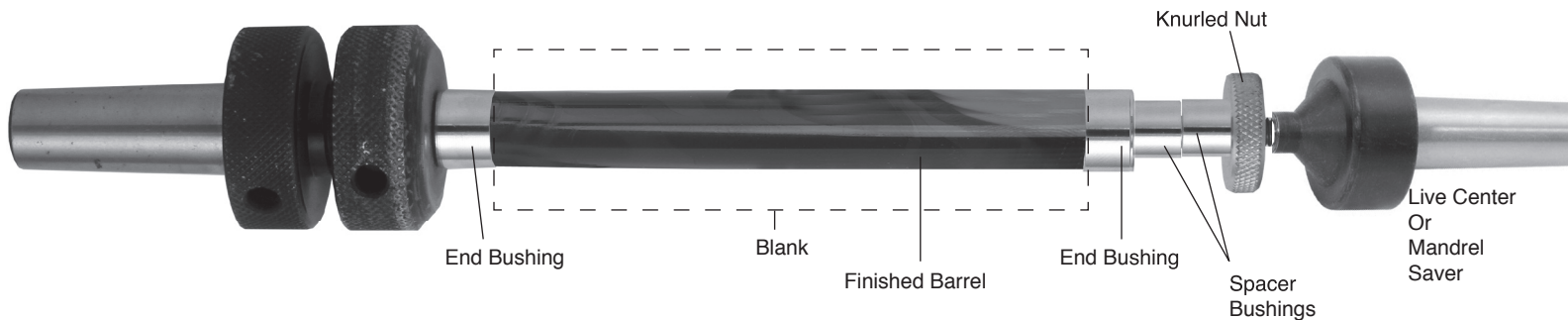
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut one blank to the length of the tube, adding 1/16" for squaring off (approx 2-15/16").
- Drill 3/8" hole lengthwise through the blank.
- Spread glue over the 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 3/8" barrel trimmer, or a pen blank squaring jig with a 3/8" 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 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

- Arrange parts according to Diagram A. Note that Front End Assembly is not a press fit. It is held in place by the mechanism being held by the cap nut.
- Place Clip onto Cap Nut and thread Cap onto Cap Nut.
- Press Cap Nut/Clip Assembly into the upper end of barrel.
- Thread Mechanism onto upper end of Front End Assembly.
- Insert refill – flat side first into open end of Front End Assembly and place Spring onto Refill shaft.
- Thread tip over Refill onto Front End Assembly.
- Check mechanism by hand by twisting it. Refill should extend and retract.
- By hand, push Front End Assembly, Mechanism side first, into open end of Barrel until IT is fully seated in pen. To operate, twist tip.
- To Replace Refill, unscrew tip and remove old refill, remember to switch spring to new refill before replacing in pen.

Diagram C / Bushings #PKTANKBU

