

Tec-7 Twist Pen Kit

Kit Features:

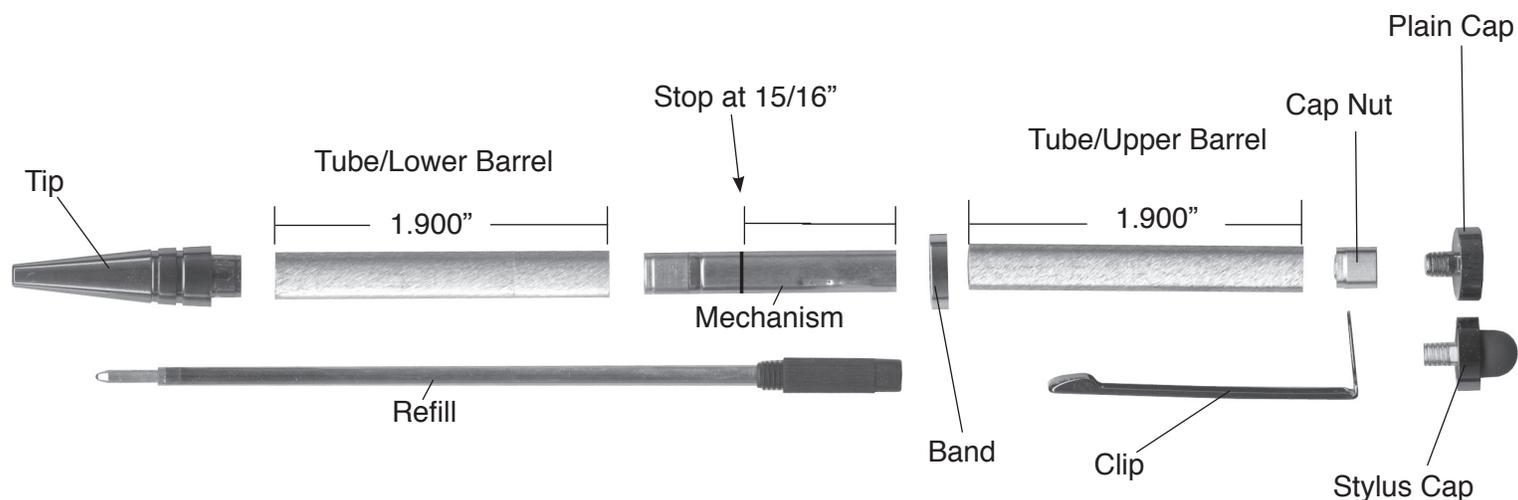
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Cross® Style refill
- Interchangeable End Caps
- Overall Length: 5-1/8"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit:#PK-7MM
- Bushing set(3 pc): #PKTSTECBU
- Barrel Trimming set: #PKTRIM7
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 5/8" X 4-1/4"

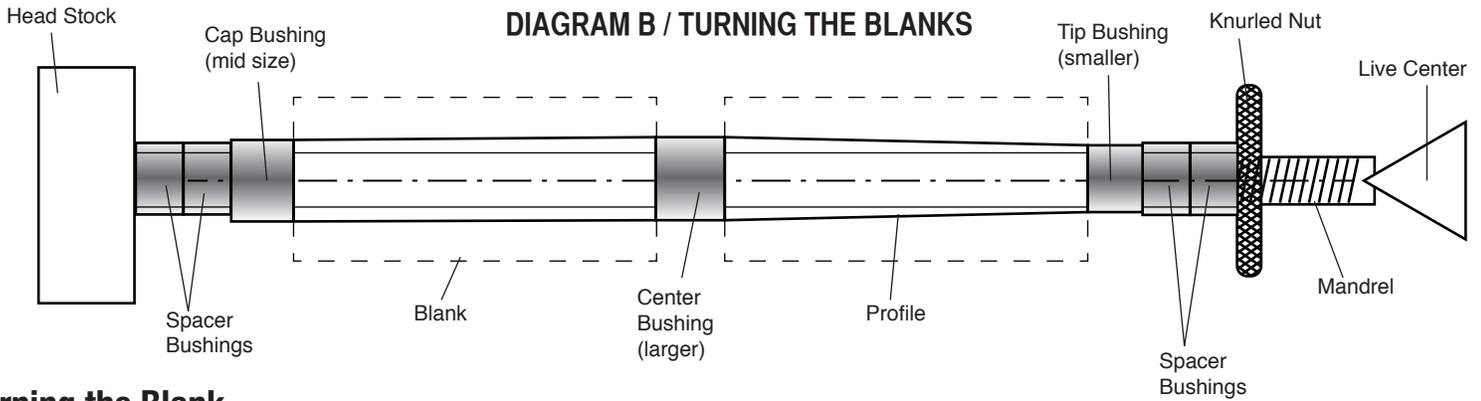


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill 7mm holes lengthwise through the blanks.
- Spread glue over the tubes, 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 7mm 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.



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 the bushing diameters. 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 into the narrow end of the lower barrel.
- Mark 15/16" on the chrome end of the mechanism (see diagram A) Press the mechanism, brass end in first into the opposite end of the barrel. Stop slightly short of the mark.
- Hand twist the mechanism to assure tip of refill extends properly out of the tip - if too short - press the mechanism further in as necessary.
- Slide the band over the mechanism.
- Press the cap nut, recessed end in first into the smaller diameter of the upper barrel.
- Affix either the plain cap or stylus cap into the hole at the clip, screw into the cap nut/barrel.
- Screw the refill into the mechanism to bottom.
- Press the upper barrel over the mechanism.
- The pen is ready to operate by twisting the two sections to advance or retract the refill.

Diagram C / Bushings #PKTSTECBU

