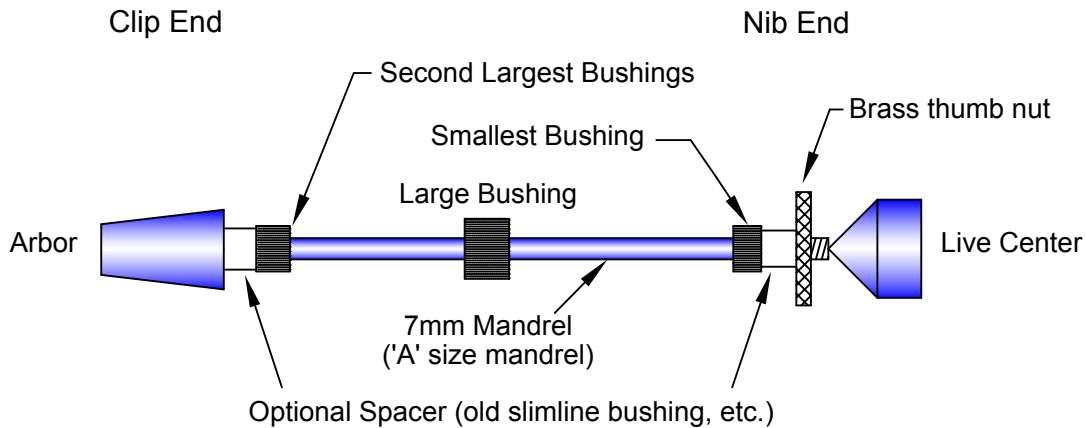


# Instructions for the Biscayne Flat Top Ballpoint Pen



Bushing: AZSB-14

Blank size: 3/4" x 3/4" x 5" long

Drill needed: 'J' or 9/32" (both barrels use the same drill size - either the 'J' or 9/32")

1. Utilizing a 7mm mandrel: Mount the 2nd smallest bushing, upper pen blank, the large center band bushing, lower pen blank and the smallest bushing and screw on the brass thumb nut. Do not over tighten the brass thumb nut!
2. Carefully slide the tail stock, with a 60° live center installed, up to the concave center of the mandrel shaft and slowly tighten the tail stock lock. Do not apply excessive force to the mandrel as this can possibly cause damage to the mandrel. Excessive force can also cause your pen blanks to come out oval in shape. Spacers may be installed to allow more room between the thumb nut & bushings & arbor and bushing. Turn the blanks to the desired shape using the bushings as a sizing guide. Sand the blanks and apply your choice of finish.
3. Assembly (helpful hint: Save yourself problems - chamfer the inside edges of each pen tube prior to assembly!):
  - A. Press fit the pen clip assembly into one end of the pen blanks (first insert the FINIAL into the CLIP).
  - B. Insert the NIB into the end of the other pen blank and press fit.
  - C. Press fit the TRANSMISSION into the opposite end of the pen blank in which the NIB is installed. There is a impressed ring around the TRANSMISSION that can be used as a guide on how deep to seat the TRANSMISSION. Insert the refill and cycle the transmission until you are satisfied with the extension of the transmission. Ensure that the tip of the refill can be fully retracted into the NIB.
  - D. Apply a tiny drop of machine oil on one side of the transmission and spread over the entire surface of the exposed transmission (to prevent galling). Slide the CENTERBAND onto the TRANSMISSION.
  - E. Slide the upper barrel assembly onto the transmission. Adjust for the grain pattern of the pen blanks.

