

American Patriot Twist Pen Kit

Kit Features:

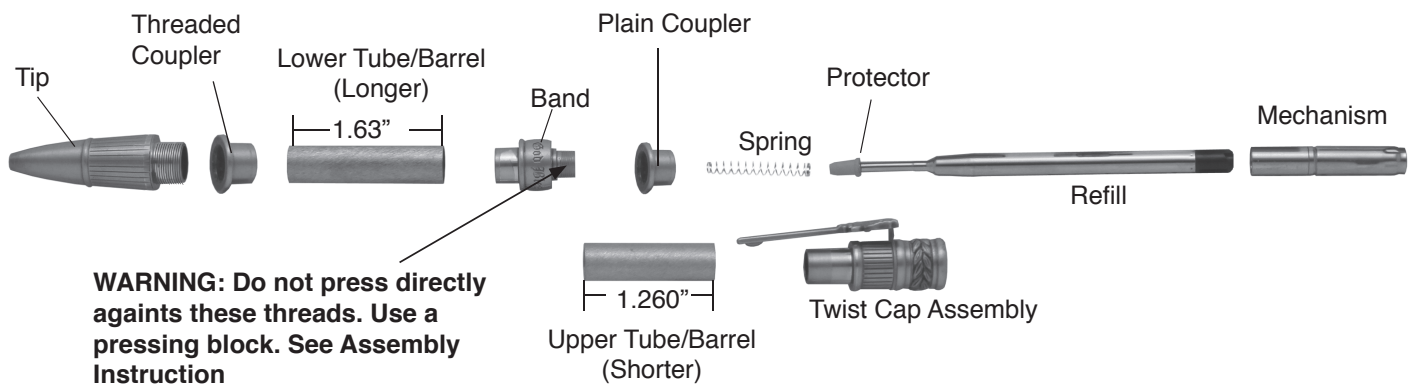
- Attractive Patriotic Styling
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refills
- Overall Length: 5-1/2"

Required Accessories:

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

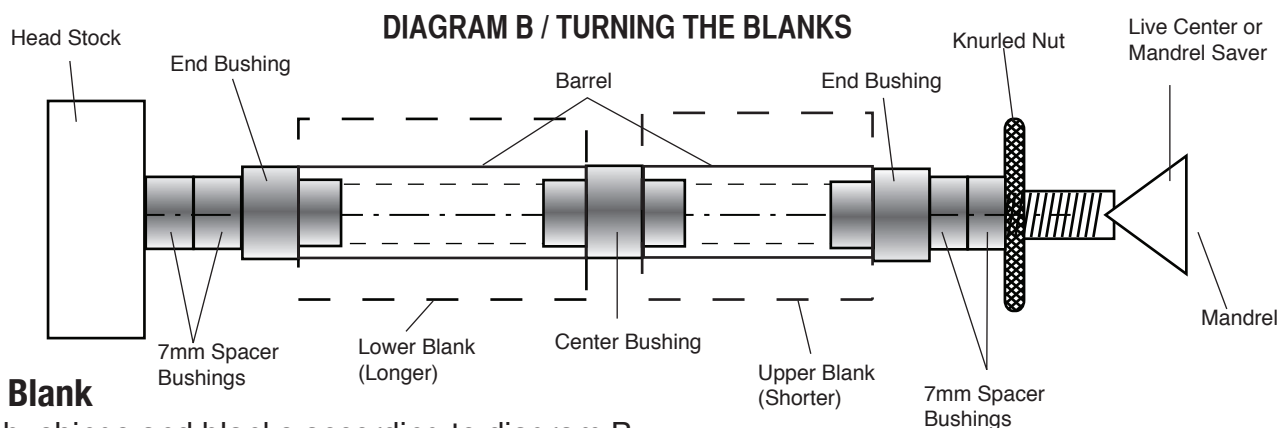


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill 3/8" holes lengthwise through the blanks.
- Spread glue over the tubes, insert into the blanks 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.



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 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 threaded coupler into either end of the lower barrel (longer)
- Press the band into the opposite end of the barrel using a pressing block as described below.
- **WARNING:** Do not press the band in directly pushing against the threads. Cut a block to about 1/2 to 3/4" long. Drill a 8mm hole through the block. Place the block over the threads and press into the tube.
- Thread the tip into the threaded coupler at the end of the lower barrel.
- Press the plain coupler into either end of the upper barrel.
- Press the cap assembly into the opposite end of the upper barrel.
- Remove the tip protector and slide the spring over the refill. Drop the refill into the opening at the band, screw the mechanism over the band.
- Engage the ends of the pen together.
- The pen operates by twisting the ends to extend or retract the refill.

Diagram C / Bushings #PKPPENBU

