

Phoenix Rising Twist Pen Kit

Kit Features:

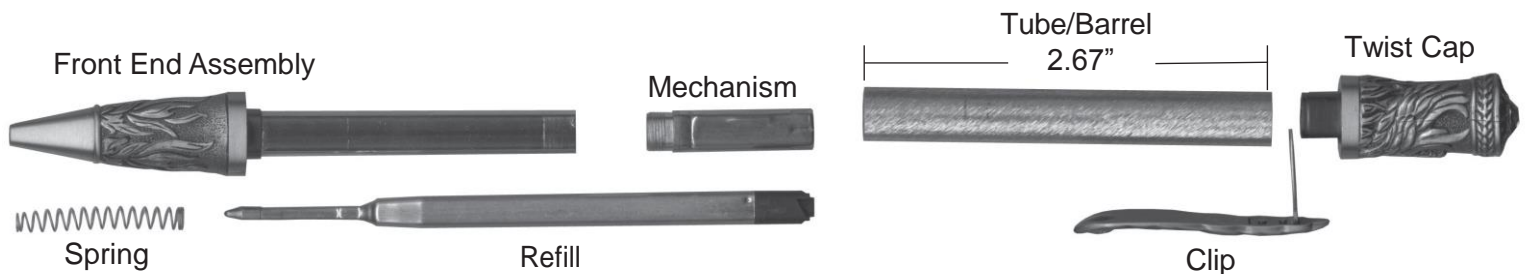
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refill
- Overall Length: 5-1/2"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" Colt BG039
- Bushing set(2/pc): #PSI264
- Barrel Trimming – Squaring Jig or Barrel Trimmer
- Live Tailstock Center
- 2 Part Epoxy Glue or (Cyanoacrylate) CA Glue
- Pen Blank: Minimum Size - 3/4" x 3" Long

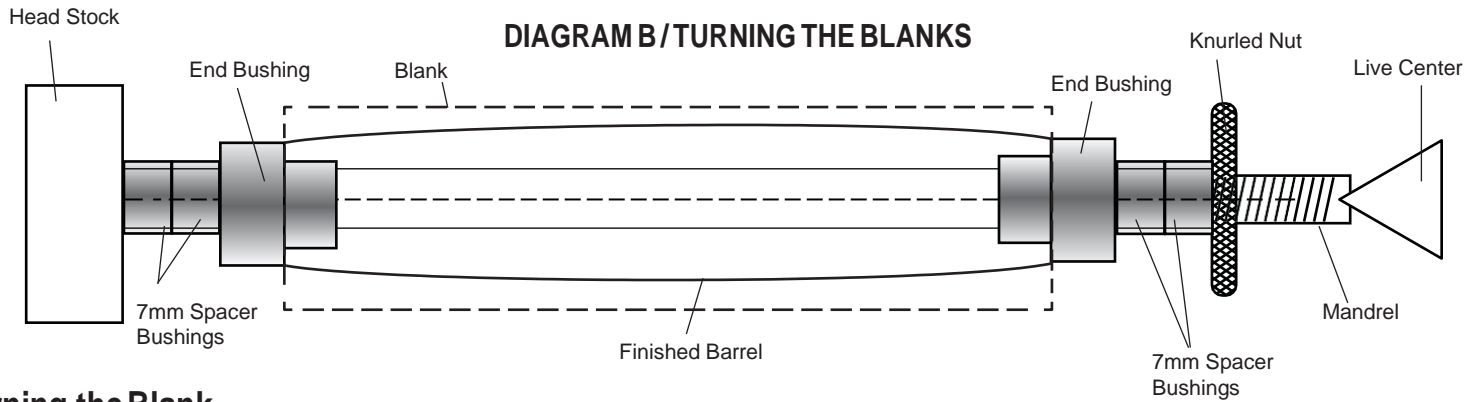


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill 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 blank. 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
- Affix the spring over the refill, drop into the opening at the front end assembly.
- Screw on the mechanism over the refill end.
- Affix the clip over the recess at the twist cap.
- Press this assembly into either end of the barrel. Note the alignment of the clip and cap (see photo on first page).
- Press the barrel assembly over the first end assembly until the barrel seats on the cap.
- The pen operates by twisting the top and bottom to advance or retract the refill.
- Replace the refill by unscrewing the barrel assembly and exposing the refill.

Diagram C / Bushings #PSI264

