

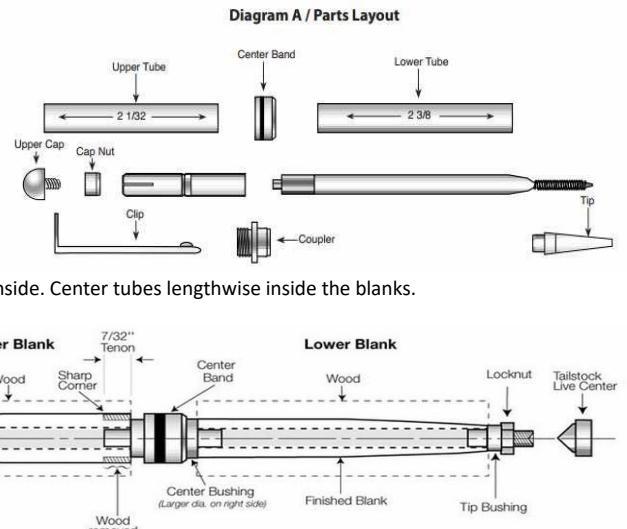
## Premium Designer Pen Kits Assembly Instructions

### Required Accessories:

- 7mm, long mandrel
- 8mm drill bit
- Premium designer bushings
- Universal barrel trimmer (Use 8mm shaft)
- 2 part epoxy glue or insta-cure (cyanoacrylate)

### Preparing the Blanks

- Cut 5/8" square blanks, to the length of the brass tubes (add 1/16" for squaring off).
- Drill 8mm centered hole lengthwise through each blank.
- Spread glue over tubes. Insert into blanks with a twisting motion to spread the glue evenly inside. Center tubes lengthwise inside the blanks.
- When glue dries, square the ends of the blanks. Use an 8mm barrel trimmer. Take wood down flush to the brass tube.



### Turning the Blanks:

- Place stop bushings onto the mandrel. Place the cap bushing next on the mandrel, then slide on the upper blank. Place the center band or a scrap band over the center bushing, square end of band toward cap. Place this on mandrel. Use tape to hold the center band against the lower blank. Place lower blank against the center bushing, next, slide on the tip bushing, thread the lock nut hand tight. Bring the tailstock snug with the mandrel. (Do not over tighten, it could damage the mandrel). slide the stop bushing towards the blank, adjusting to remove spaces, then tighten the screw set and lock nut.
- Turn the wood down to the bushings and the diameter of the center band with chisels and sand paper. Taper the end cap and tip ends of the blanks (follow diagram C for profile) to conform with the cap and tip. Remove tape and use the outside dia. of the band to determine the outside diameter of the upper blank.

Be sure the wood on the lower blank next to center bushing does not exceed the bushing diameter, it may cause the twisting mechanism to jam when parts are engaged. Sand down to the final size.

### Cutting the Tenon

- Keep the center band away from the upper barrel. Make a pencil mark 7/32" from end. Use a parting tool to cut a 7/32" tenon down to the diameter of the bushing. Use the center band by sliding it over tenon to achieve a good snug fit. Make sure you keep a sharp outside 90° corner on the tenon. Finish, polish and wax both barrels.
- Use a finish of your choice but be careful if brushing on a poly, etc. You can stick the tube, bushings, and mandrel together.

### Assembly

- Line up finished parts according to diagram C.
- To press parts together, use a vice or a clamping instrument with wooden jaws. Press with caution, to avoid scratching gold plated parts.
- Press the cap nut, recessed end in first into tapered end of the upper barrel
- Insert the upper cap threads into clip, screw together tight into cap nut.
- Press the tip into the tapered end of the lower barrel
- Press the coupler, recessed end first into the opposite end of the barrel.
- Drop the refill with spring into the opening at the coupler. Thread the mechanism, brass end in first to the coupler. Test for function
- Slide the center band, tapered end in first over the mechanism.
- Engage the upper and lower barrels of the pen.
- Pen operates by twisting the barrels to extend or retract the writing tip.

## CONTACT DETAILS: