

# Victorian Twist Pen Kit

PKVIC24 • PKVICAB • PKVICAP

## Kit Features:

- Easy to turn
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refills
- Overall length: 6"

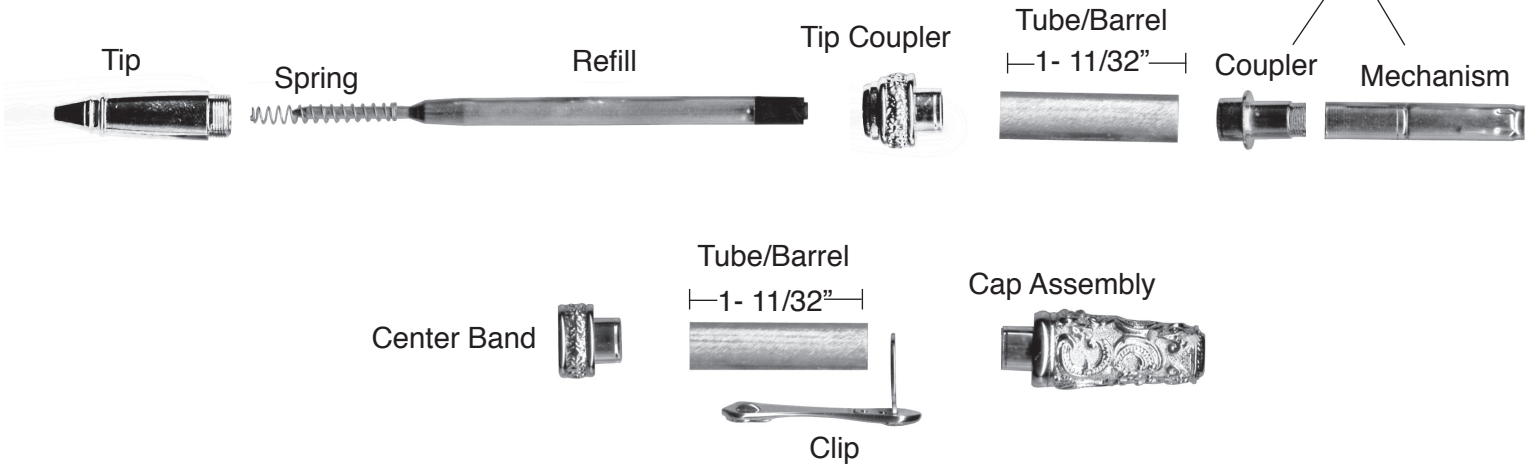
## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8"
- Bushing set(3 pc): #7918
- Barrel Trimming set:
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size: 3/4" X 3-1/4"



## DIAGRAM A / PARTS LAYOUT

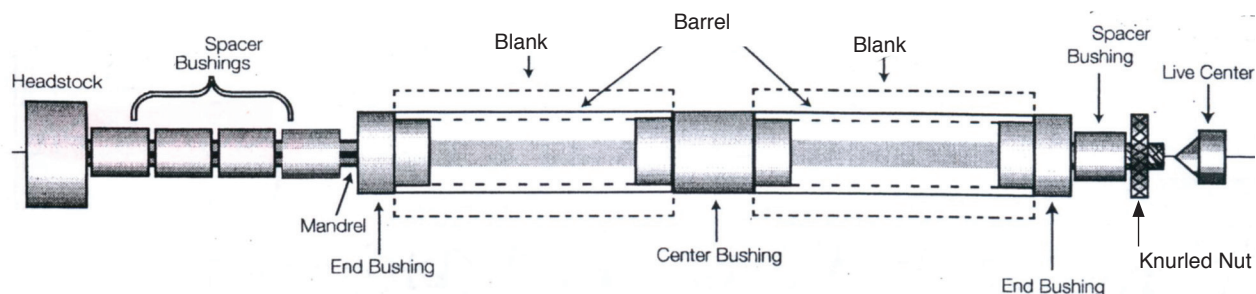
**Note: Screw together before pressing**



## Preparing the Blank:

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blanks.
- Spread glue over the tube(s), 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 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).

## DIAGRAM B / TURNING THE BLANKS

**Turning the Blanks**

- 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 tip coupler into either end of either barrel
- **Coupler Note: Do not press in directly over the exposed threads!!**
- Screw on the mechanism over the coupler, press this assembly into the opposite end of the barrel. Take care not to crush the mechanism.
- Press the band into either end of the other barrel.
- Affix the clip over the extension on the cap assembly. Press this assembly into the opposite end of the barrel.
- Drop the refill into the opening at the tip coupler, slide the spring over the refill tip. Thread the pen tip into the tip coupler over the refill.
- The pen operates by twisting the ends of the pen to advance or retract the refill.

**Diagram C / Bushings**