

# Yoga Twist Pen Kit

## Kit Features:

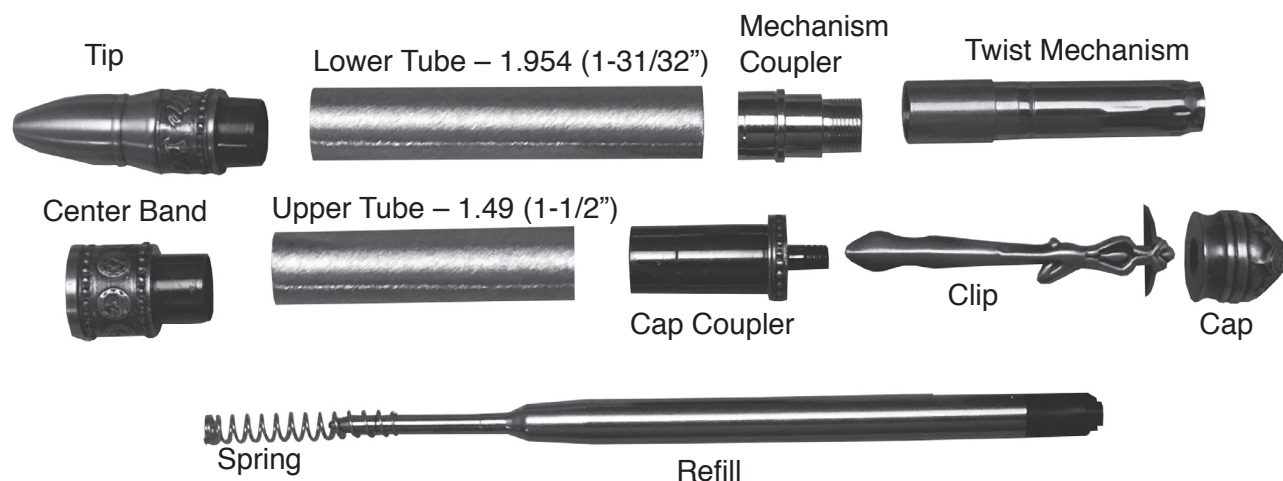
- Mandala designs on Cap and around Centerband
- Clip depicts Vriksasana ("Tree Posture")
- Easy to Turn With Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-17/32"
- USES REFILL:#PKPARK-R5

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38 for plastic, #PK-38BP for wood
- Bushing Set(3pc): #PKYOGABU
- Barrel Trimming set: PKTRIM38 or 3/8" sleeve from PKTRIMSET.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 3-11/16"L



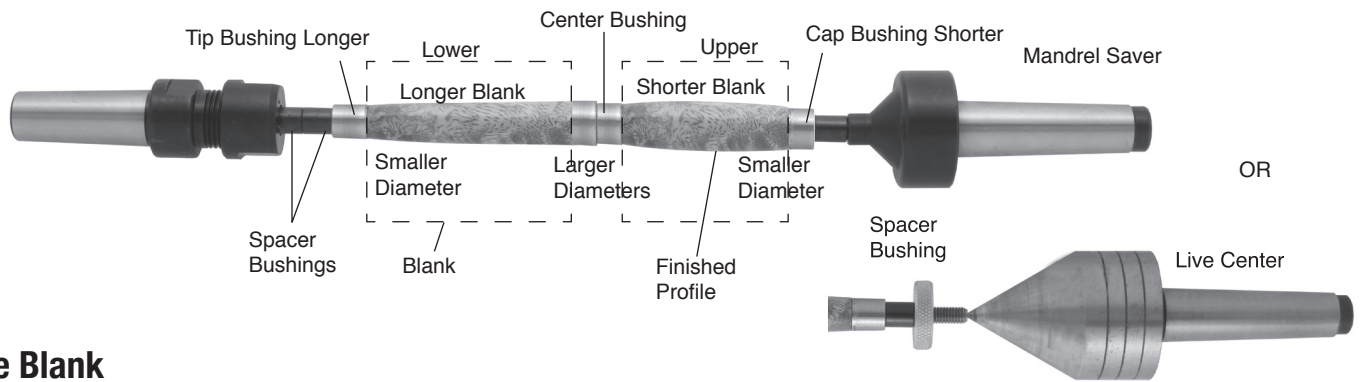
## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut blank to the to the lengths of the tubes, adding 1/16" for squaring off.
- Drill 3/8" hole lengthwise through the blanks.
- Spread glue over tube, insert the tube into 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 blanks, making sure the trimmed ends are 90° to the tube. Use a 3/8" barrel trimmer, or a pen blank squaring jig with a 3/8" sleeve on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with the operation of the mechanism and assembly. Use a barrel trimmer to clean the inside of the tube.

### DIAGRAM B / TURNING THE BLANKS



### Turning the Blank

- Mount the bushings and blanks according to diagram B. Note that wide side of Center Bushing points towards Tip Bushing.
- 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 Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel straight or to a profile of your choice. A slightly rounded profile near tip is recommended.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

### Assembly

- Layout finished barrels as turned in diagram B. To ensure proper assembly, it is important to clearly identify the shorter barrel and longer barrel and the large and small diameters of the barrels.
- Thread Cap onto Cap Coupler without Clip to avoid scratching Barrel during pressing.
- Press Cap Coupler with cap attached into Smaller diameter end of Upper Barrel. Cap should go against soft jaw on press.
- Unscrew Cap and place Clip over post on Cap Coupler and Re-attach Cap.
- Press Centerband into open end of Upper Barrel.
- Press Tip into smaller diameter end of Lower Barrel.
- Press Mechanism Coupler into opposite end of Lower Barrel. Be careful not to over press on threads.
- Place Spring, narrow side first, over Refill shaft.
- Insert Refill through Mechanism Coupler.
- Thread Mechanism over refill onto Mechanism Coupler until fully tightened.
- Insert Mechanism into Upper Barrel.
- To extend and retract refill, twist Upper and Lower Barrel.
- To Change refill, unscrew Lower Barrel from Mechanism and replace Refill. Remember to switch Spring to new Refill.

### Diagram C / Bushings #PKYOGABU

