

Cirque Twist Ballpoint Pen Kit

Product: #164567, #164568, #164569,
#164570, #164571

12/3/2018



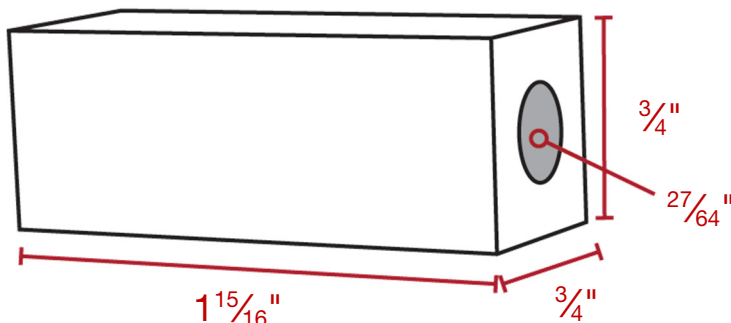
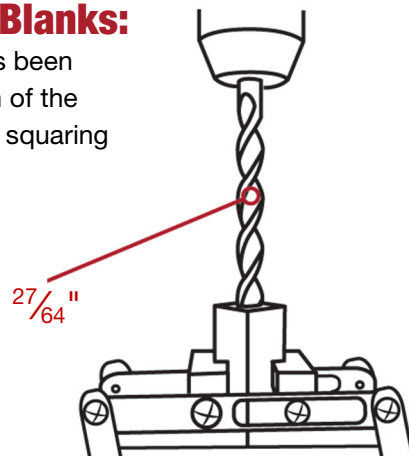
From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- $\frac{27}{64}$ " Pen Maker's Bit
- $\frac{3}{4}$ " x $\frac{3}{4}$ " x $1\frac{15}{16}$ " Pen Blank
- Pen Mandrel
- Cirque Twist Ballpoint Bushings (164572)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/MicroMesh
- Pen Mill Pilot Shaft $\frac{27}{64}$ " (165713)
- Pen Press
- Eye & Ear Protection
- Dust Mask

Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.

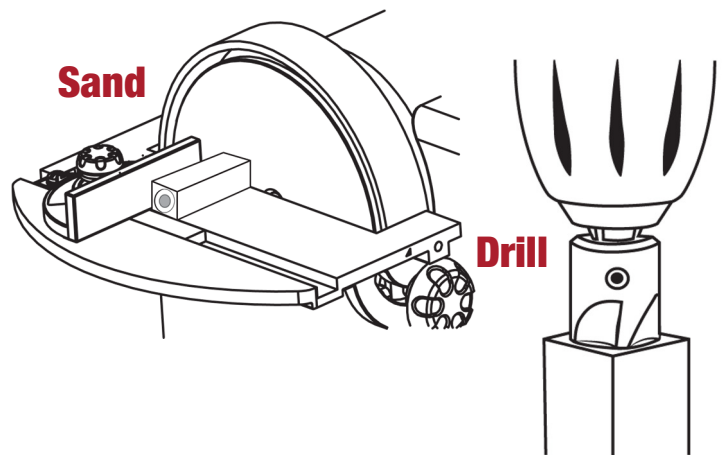


Gluing Blanks to Tubes:

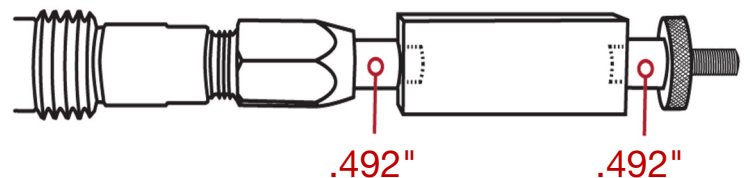
Rough the entire surface of the tube using 180 grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube into the inside of the blank make sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.

Squaring the Blank to Length:

When squaring the blanks to length ensure to only go to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.



Mandrel Preparation:



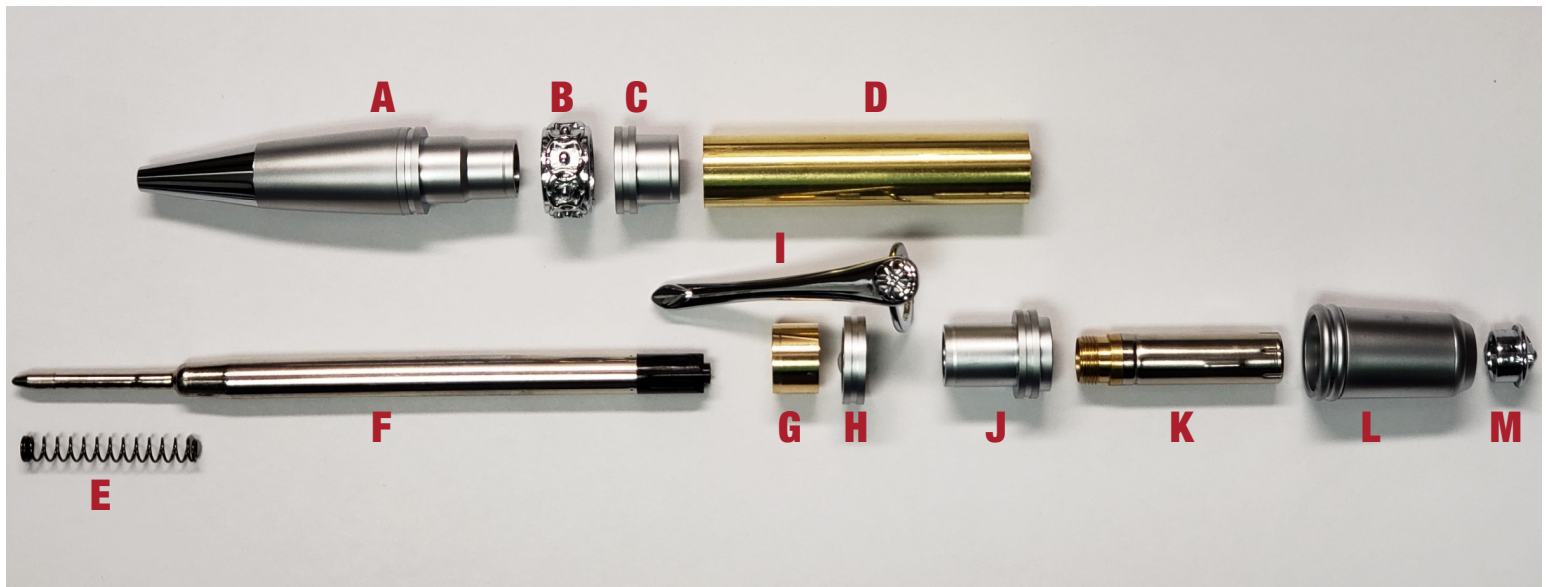
Turning & Finishing the Blanks:

Turn the blank to your desired profile leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120 grit paper progressing through the finer grits finishing at 320 grit. Once finished with sanding apply a finish of your choice.

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Assembly:

- ❑ Slide decorative Center Band (B) onto Nib (A) followed by pressing Nib Adapter (C) onto Nib (A). Set Nib Assembly (A, B, C) aside.
- ❑ Slide Clip (I) followed by Decorative Ring (H) onto Clip/Twist Adapter (J). Secure the Clip Assembly (H, I, J) by pressing Clip Bushing (G) onto the post. Ensure that the tapered end is facing out.
- ❑ Press the Clip Assembly (G, H, I, J) into one of the open ends of the Finished Barrel (D), followed by pressing Nib Assembly (A, B, C) into the other end of the Finished Barrel (D).
- ❑ Slide Spring (E) small end first onto Ink Refill (F) and insert into open end of Clip/Twist Coupler (J). Thread Twist Mechanism (K) into Clip/Twist Coupler (J) and check for proper operation.
- ❑ Epoxy Finial (M) into Finial Cap (L). Finial Cap has been designed to allow for use of the supplied Finial or to make one utilizing the same material as your pen for a custom look.
- ❑ Finish the assembly by pressing the Finial Cap Assembly (L, M) onto the Twist Mechanism (K) by hand.

To advance the ink refill hold the Body of the pen and rotate the Finial/Cap clockwise, to retract the ink refill hold the Body of the pen and rotate Finial/Cap counterclockwise.