

# PIRATE TWIST PEN KIT

## Kit Features:

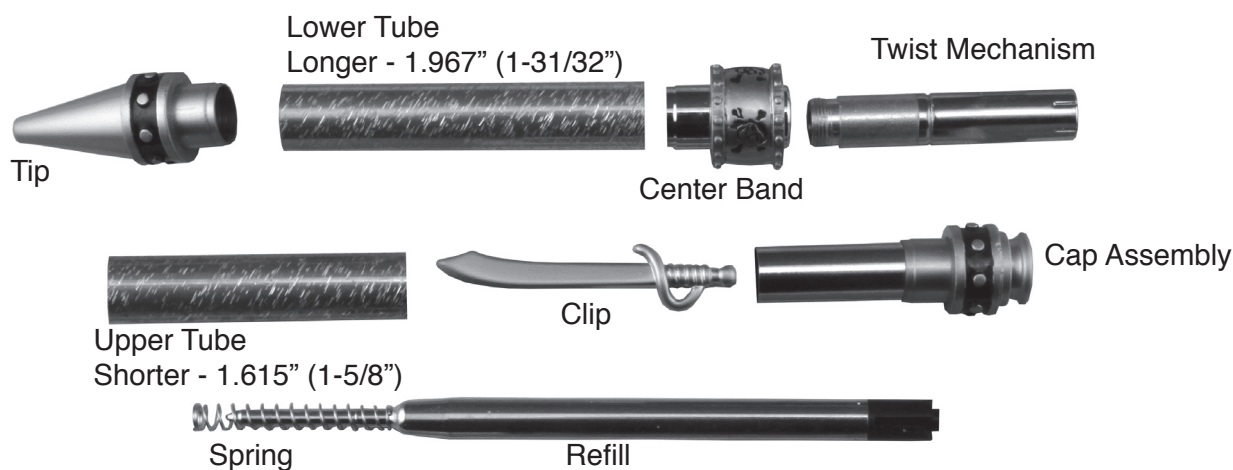
- Eye-catching pirate designs from 'fore to aft'
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-7/16"
- USES REFILL: PKPARK-R5

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PK38BP for wood or #PKEXEC-38 for plastic
- Bushing Set(3pc): #PKPIRBU
- 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: 3/4" x 3/4" x 3-13/16" (allows for single 1/8" wide cut)

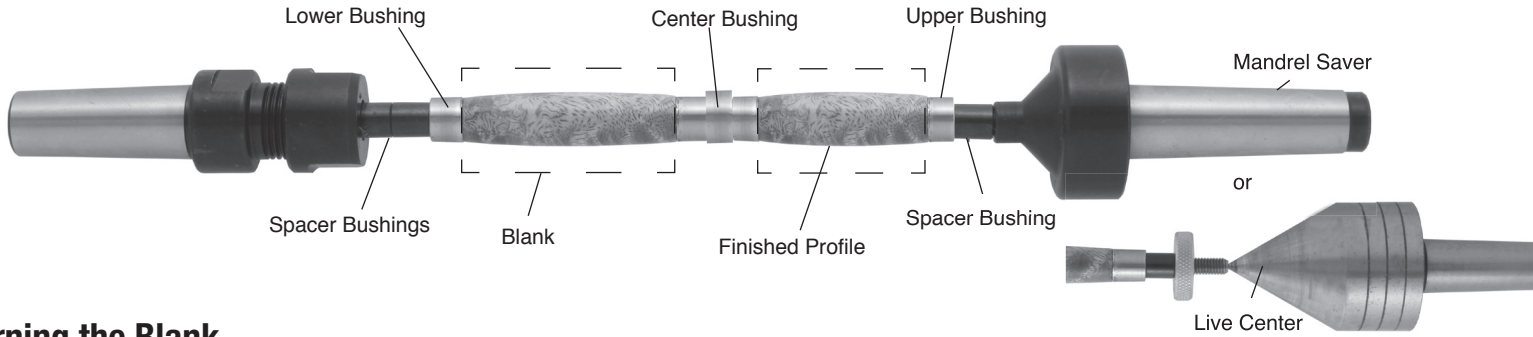


## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut blanks to the length 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 the Upper Barrel is longer than the Lower Barrel.
- 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.
- 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**

- Line up parts according to Diagram A
- Press the Tip into the narrow end of the Lower Barrel. Remember that Lower Barrel is the longer one.
- Press Centerband into open end of Lower Barrel.
- Push Spring onto Refill shaft and slide Refill through Centerband.
- Thread Mechanism over Refill and into Centerband.
- Slide Clip onto Cap Assembly
- Press Cap Assembly into narrow end of Upper barrel.
- Push Lower Barrel into the opening of Upper Barrel until gap is closed. (use pen press if necessary)
- To extend and retract refill, twist Upper and Lower Barrels.
- To change Refill, unscrew upper barrel (with mechanism inside) and replace refill. Remember to slide spring over tip of new Refill.

**Diagram C / Bushings #PKPIRBU**