

# Royal Pen Kits Assembly Instructions



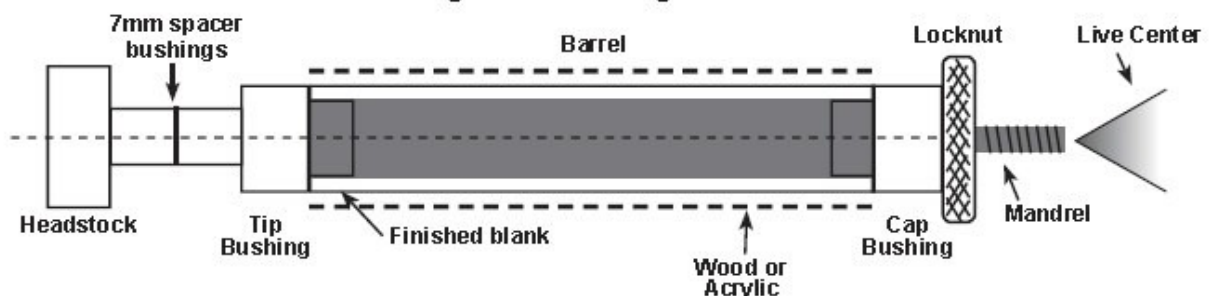
## Required Accessories:

- 7mm, Pen Mandrel
- 3/8" Drill Bit R
- 2 piece Bushing Set
- Universal Barrel Trimmer 3/8 shaft
- Sandpaper/Finish
- Glue (Thick CA or Epoxy)

## Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 3/8" hole lengthwise through the blank.
- Glue the brass tube in the blank. Spread the glue on the tube. Insert into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank. Allow it to dry.
- After the glue dries, use a 3/8" Barrel Trimmer to square the ends of the blank to flush with the ends of the brass tube.

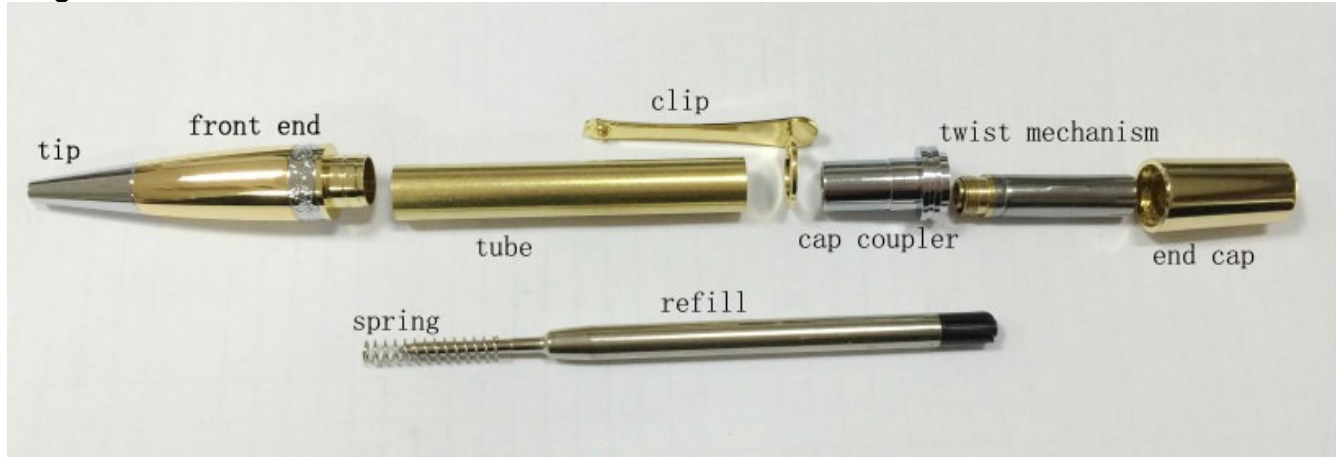
## Diagram A



## Turning the Blanks (see Diagram A)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing; narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

## Diagram B



## Assembly

(Line up finished parts according to Diagram B)

- Slide the clip to the cap coupler, then press into one end of the tube.
- Screw on the mechanism into the opening at the clip assembly to bottom.
- Insert the cap over the the exposed end of the mechanism and press in.
- Press front end, recess end in first into the opposite of the tube
- Pull the protective tip off the refill. Insert into the opening at the opposite end of the pen. Insert spring and screw the tip over the refill.
- The pen is ready to operate. Just twist the cap from one position to another to extend or retract the refill.