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Twist Pen Assembly



For use with the following:

050-4401, 050-4001, 050-2404, 050-4405, 050-4410,
050-4440, 050-4441, 050-4420

Blank Size and Cutting: The blank size is determined by the project you are working on. Please refer to the Assembly instructions for blank and drill sizes.

Drilling: Mark the center of the blank and drill to the required size. To help prevent blanks from overheating or splitting, clear the drill often and only drill deep enough for the tube length and trimming.

Gluing: We recommend cyanoacrylate glue for fast drying and epoxy for slow drying. Apply a coat of glue to the tube and rotate the tube as you push it into the drilled blank.

Trimming: Use a barrel trimmer to square the ends of the blank. This is the fastest and most accurate method. You may use a disc sander to sand the ends square with the tube. Note: Make sure you do not remove any of the brass tube as this may affect the finished item.

Mandrel Setup: Place the bushing(s) and barrel(s) onto the mandrel (see figure). Some projects and mandrels will require the use of a wood spacer, cut to length and drilled with a 7mm hole.

Figure 1



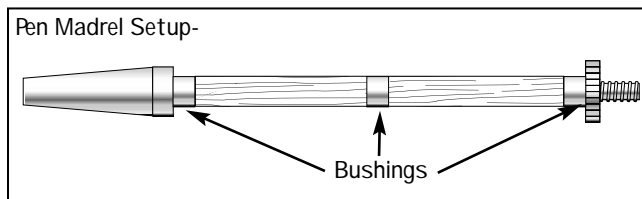
2 Turning the Pen

STEP 1

Mount the bushings and the barrels onto a pen mandrel. Advance a cone live center into the dimpled end of the pen mandrel. Do not over tighten the tailstock or the mandrel nut as this may cause the mandrel to flex and produce an oval pen barrel.

STEP 2

Turn the barrels down to the same diameters as the pen bushings. Sand the barrels smooth using progressively finer grits, then apply a finish such as friction polish or french polish.



3 Assembling the Pen

Before Assembly:

Read the assembly instructions completely. Layout the pen parts according to the drawing. This will help familiarize yourself with the parts and how they will go together. We strongly recommend using a vice clamp with wooden jaws during assembly to avoid damaging the parts.

Assembly:

1. Press the writing tip into the end of one barrel.

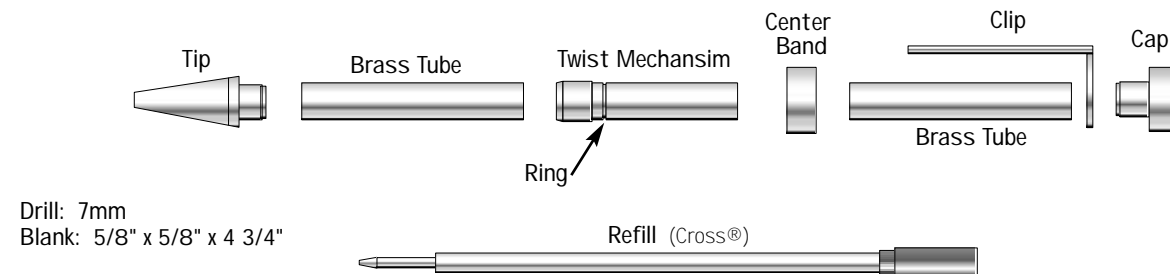
2. Press the twist mechanism, brass end first, into the opposite end of the same barrel up to the ring-like indentation on the chrome portion of the mechanism. Test the fit and press the mechanism in until the refill extends through the tip to your liking. **DO NOT** push it in too far, as you cannot pull it back.

3. Slide the clip onto the stepped portion of the cap. This will only slide part way on so do not attempt to force it on.

4. Press the clip/cap assembly into the end of the other barrel.

5. Slide the center band over the twist mechanism.

6. Slide the clip/cap barrel over the exposed twist mechanism to complete the pen.



Drill: 7mm
Blank: 5/8" x 5/8" x 4 3/4"