

## MINI "BULLET" TWIST PEN KIT Instructions

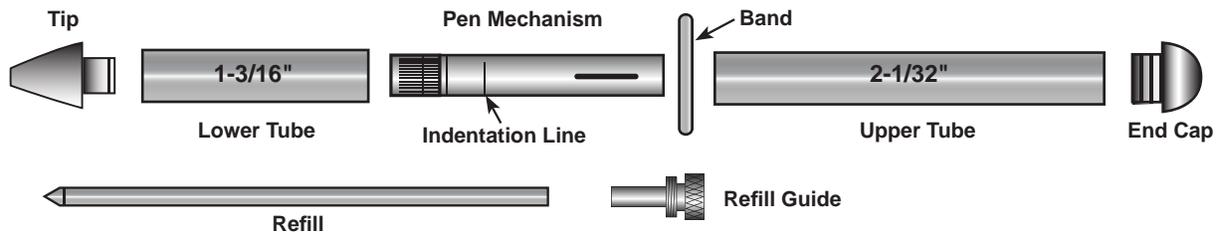
### Kit Features

- Heavy plating with epoxy coating
- Pen mechanism with locking device
- Compact mini twist pen is purse size
- Uses mini-style refills (RE-MINI)
- Overall length is 4"

### Required Accessories & Materials

- 7mm mandrel
- 3-piece bushing set (PKBULPENBU)
- 7mm drill bit (DB7MM or DB7MMCT)
- 7mm barrel trimmer (PKTRIM7)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

### Diagram A - Parts and Assembly



### BLANK PREPARATION

**Cut** your blanks approximately 1/16" longer than the tubes to allow for squaring with the barrel trimmer. If using wood blanks, mark the blanks so it is easier to keep the grain running in the same direction when you place them on the mandrel for turning. Use a medium drill speed to **drill** the blanks. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blanks, **sand** the exterior of the brass tubes to roughen their surface and use CA **glue** to glue the tubes inside the blanks. Sand or barrel trim to **square** the ends of the blanks.

### TURNING THE PEN

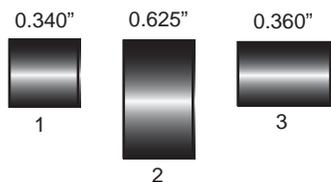
**Set up** the mandrel as shown in Diagram C. **Turn** the blanks down to create a *rounded profile* from each end to the center, then **sand** with abrasives and **finish** with your choice of polish.

### ASSEMBLY

(Line up finished parts according to Diagram A)  
*To avoid damage to components when assembling, use a vise with covered jaws or one of WoodTurningz' pen presses.*

1. Press the tip into the lower barrel.
2. Press the pen mechanism, brass end in first, into the opposite end of the barrel checking the proper depth with the refill as you go (see diagram C).
3. Insert the refill into the refill guide making sure it is inserted as far as it can go.
4. Hold the lower assembly of the pen and turn the mechanism counterclockwise to advance the inside thread upward. Insert the refill assembly and thread inside using the knurled end. When finished, 3/32" brass will show on the outside.
5. Place the band over the exposed mechanism.
6. Press the end cap into the small diameter opening of the upper barrel.
7. Engage both parts of the pen together.
8. The pen operates by twisting the end of the pen to extend or retract the refill tip.

### Diagram B - Bushings



### Diagram C - Turning the Pen

