

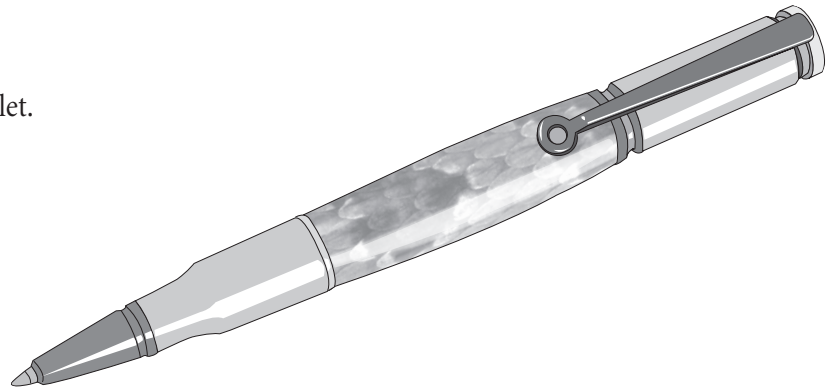
30 CALIBER BULLET CARTRIDGE TWIST PEN KIT

KIT FEATURES

- Replicates an actual 30-caliber shell casing.
- Tip plated in rose gold to simulate an actual copper bullet.
- Twist type mechanism.
- Most components pre-assembled.
- Uses Parker™ style refill (gel compatible).
- Overall length: 5-1/4"

REQUIRED ACCESSORIES:

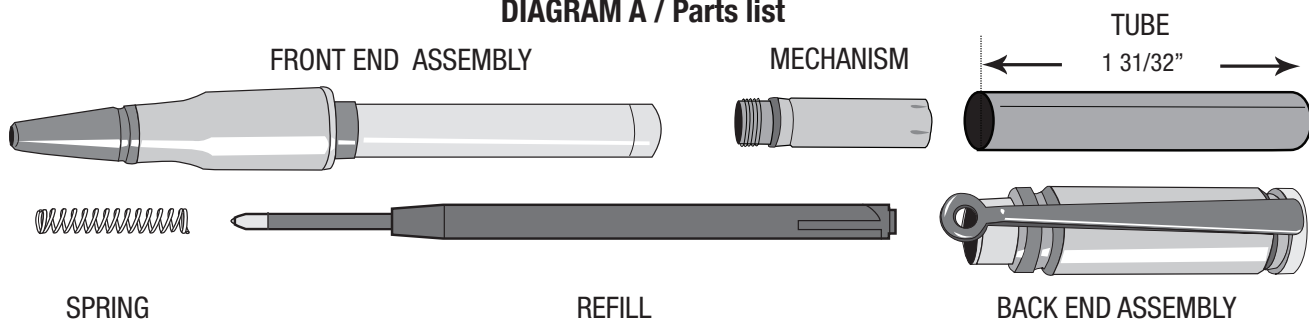
- 7mm Pen Mandrel
- 3/8" Drill Bit -#PKEXEC -3/8
- 2 pc Bushing Set -#PKCP3000BU
- Universal Barrel Trimmer system #PKTRIMKIT (Use 3/8" shaft)
- 2-part epoxy glue or insta-cure (cyano acrylate) glue



PREPARING THE BLANK

- Cut 5/8" or larger square blank to the size of the brass tube. Add 1/16" to each end for squaring off.
- Drill an 3/8" hole through the center of the blank.
- Apply glue to the tube and insert it into the blank with a twisting motion to spread the glue evenly. Center the tube within the blank and allow to dry.
- Use a barrel trimmer (PKTRIMKIT) to square the ends of the blank to the brass tube.

DIAGRAM A / Parts list



TURNING THE BLANK

- Place spacer bushings on the mandrel. Place one end bushing on, followed by the prepared blank.
- Insert the second end bushing. Follow with additional spacer bushings as needed.
- Thread the lock nut hand tight onto the mandrel. Do not overtighten, it could damage the mandrel.
- Bring tailstock snug to the mandrel and lock it into place. Tighten the lock nut for turning.
- Using sharp tools, turn the blank down and sand it to the size of the end bushings.
- Finish the blank with your choice of polish.

DIAGRAM B / Turning the blank

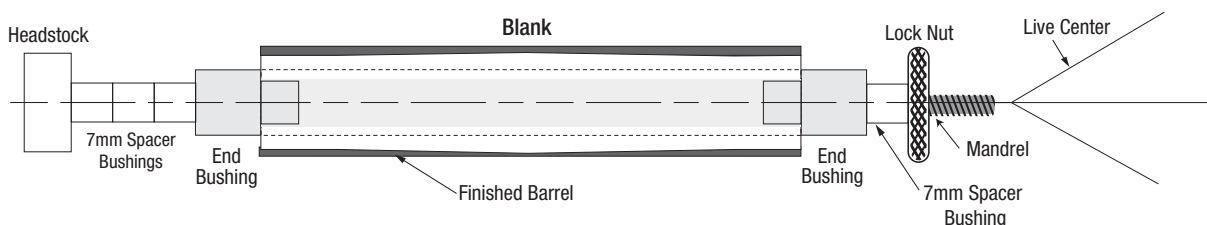
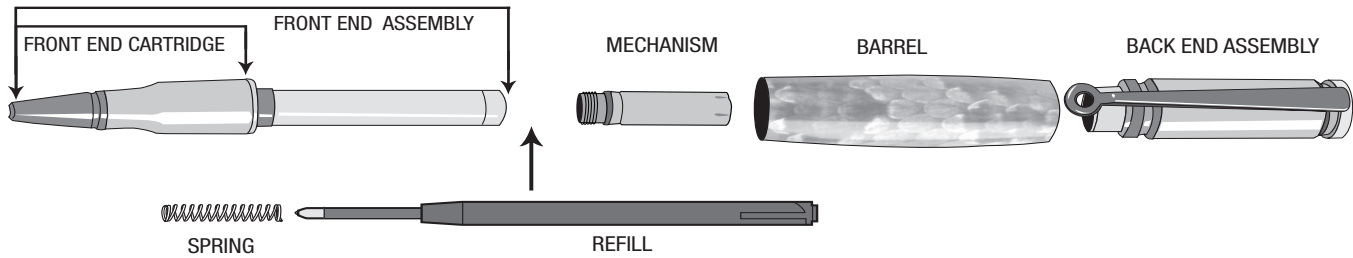


DIAGRAM C / Pen assembly



PEN ASSEMBLY

- Line up the pen parts according to DIAGRAM C.
- Remove the refill protector.
- Place the refill spring over the tip end of the refill.
- Insert the refill into the front end of the assembly.
- Thread the mechanism in the front end assembly behind the refill.
- Press the barrel into the connector at the back end assembly.
- Insert the front assembly with mechanism installed into the barrel; push in until barrel is flush to the front end cartridge. The back end assembly will firmly engage the mechanism.
- The pen operates by twisting the front end cartridge to advance or retract the refill.
- To replace the refill - unscrew the barrel from the front end cartridge (mechanism will remain in back end assembly).

DIAGRAM D • #PKCP3000BU

