

Music Twist Pen Kit

Kit Features:

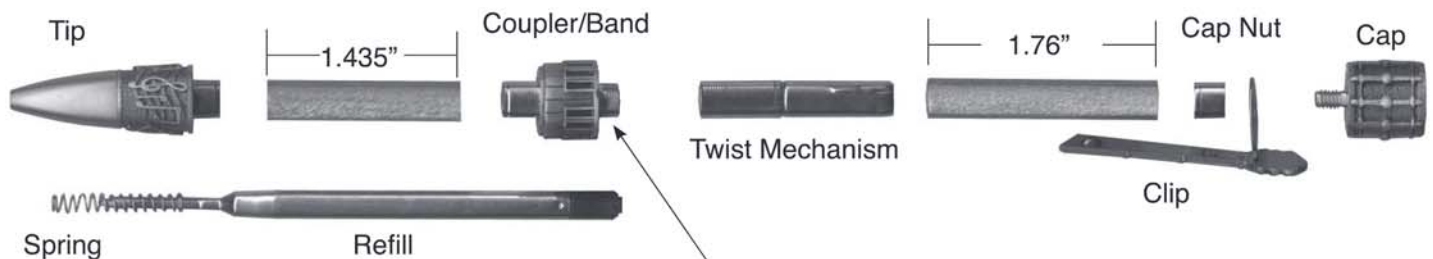
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Overall Length: 5-1/2"
- Uses standard Parker® style refills
- Tube size: 8mm

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 8mm #PKPARK-8MM
- Bushing set(3 pc): #PKMUSBU
- Barrel Trimming set: #PKTRIM8
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/2" Long



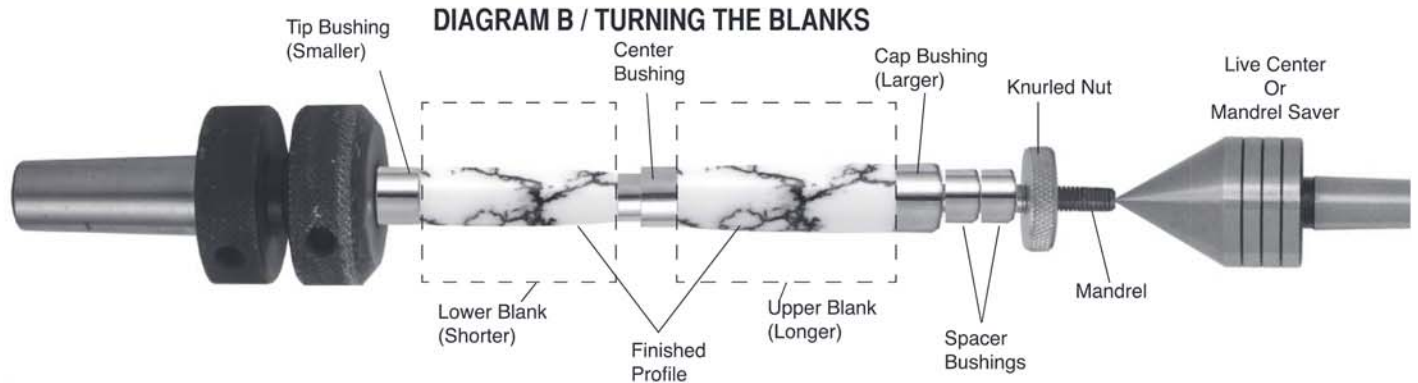
DIAGRAM A / PARTS LAYOUT



NOTE: When assembling, do not press directly on the threads

Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill 8mm holes lengthwise through the blanks.
- Spread glue over the tube(s), insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 8mm barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly). Use a barrel trimmer to clean the inside of the tube.



Turning the Blank

- Mount the bushings and blanks according to diagram B.
- 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 in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.)
- 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 the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.
Refer to polish instructions.

Assembly

- Layout parts according to diagram A
 - Press the tip into the narrow end of the shorter barrel.
 - Press the coupler into the opposite end of the barrel.
- WARNING:** It is not advised to press directly over the threads, instead use a pen blank. Cut a section 3/4" long. Drill a 8mm hole through. Affix this blank over the threads and press the coupler in.
- Insert the spring over the refill end and drop into the opening at the coupler.
 - Screw in the twist mechanism over the end of the refill.
 - Press the cap nut into the narrow end of the upper barrel.
 - Affix the clip into the threaded stem of the cap, thread this assembly into the cap nut tightly.
 - Press both ends of the pen together to close the gap in the center.
 - The pen operates by twisting the ends to extend or retract the refill.
 - To remove refill - twist off upper cap to expose the refill (**DO NOT PULL OFF CAP**)

Diagram C / Bushings #PKMUSBU

