

PHOENIX PEN Instructions

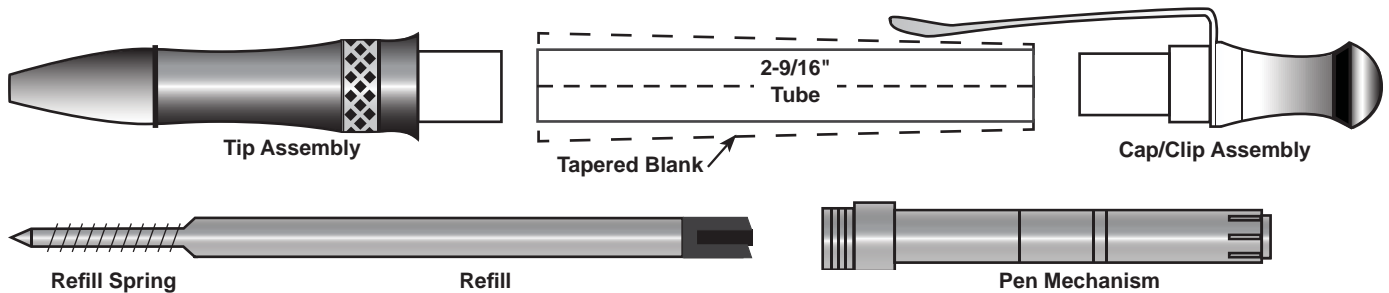
Kit Features

- Smooth twist mechanism
- Parker™ style refills (RE-PARK)
- Overall length: 5-1/2"

Required Accessories & Materials

- 7mm mandrel
- 2-pc. bushing set (PKPHXBU)
- Drill bit – 27/64" (DB27/64)
- Universal trimming kit (BTRIMKIT9)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Parts and Assembly



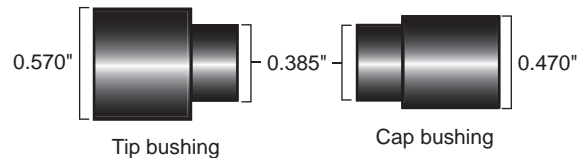
BLANK PREPARATION

The Phoenix pen has a single tube measuring 2-9/16". **Cut** your blank approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. Use a medium drill speed to **drill** the blank. 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 blank, **sand** the exterior of the brass tube to roughen its surface and use CA **glue** to glue the tube inside the blank. Sand or barrel trim to **square** the ends of the blank.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. The Phoenix pen's two bushings are of different sizes (see Diagram B), so slide them onto the mandrel considering which is the tip and the cap ends. The tip bushing is larger with an outside diameter of .570"; the cap bushing is smaller with an outside diameter of .472". **Turn** the pen blank as a **tapered core** unless otherwise desired. Be cautious that the wood or acrylic blank is turned to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

Diagram B - Bushings



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. Slide the spring onto refill and place inside the tip assembly. Screw the pen mechanism into the tip assembly.
2. Press clip assembly into the upper end of the barrel.
3. Push pen barrel with clip/cap assembly onto completed lower assembly.
4. The pen is now ready to operate; twist clockwise to open.

Diagram C - Turning the Pen

