

PIRATE TWIST PEN KIT

Instructions

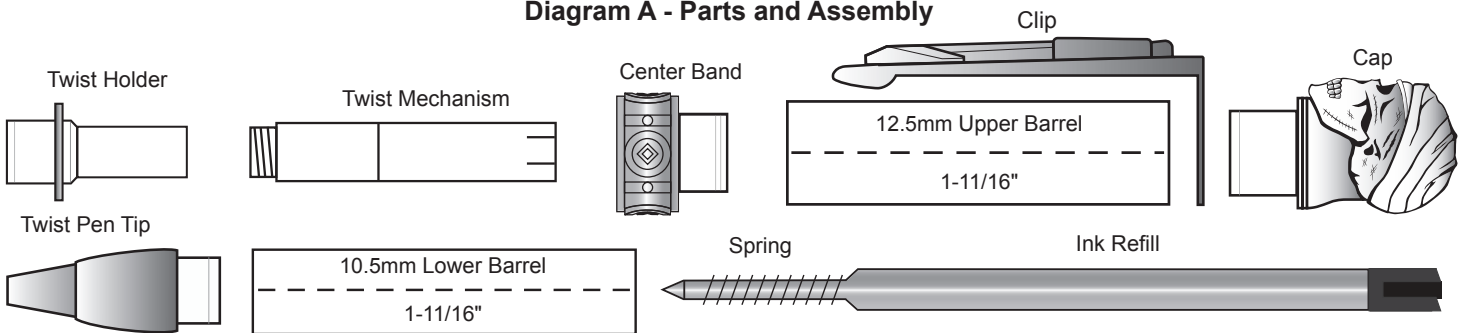
Kit Features

- Larger and more substantial than the Slimline pen
- Shows off the wood in a way a smaller pen cannot
- Uses smooth-writing Parker™ style refill (RE-PARK)

Required Accessories & Materials

- 7mm mandrel
- 4-pc. Commander bushing set (PKCMDR-BU)
- 10.5mm and 12.5mm drill bits (DB10.5mm) (DB.492)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies
- Optional Barrel Trimmer Sleeves: PKMAJJRBTs

Diagram A - Parts and Assembly



BLANK PREPARATION

The tubes in a Pirate twist pen kit are the same length, but different widths. **Cut** your blanks approximately 1/16" longer than the tube 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. In setting up your bushings, you will use the smallest of the four bushings (bushing 1) at the tip of the pen. The lower barrel goes on the mandrel followed next by bushing 2. Using bushings 3 and 4, slide the upper tube onto the mandrel. **Turn** the pen blank to the bushing diameter at the ends. **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 pen press or a vise with covered jaws.

1. **Press** the Tip into the end of the 10.5mm lower barrel.
2. **Press** the Twist Holder into the opposite end of the lower barrel.
3. Drop the ink refill with the refill spring into the threaded twist holder and screw on the twist mechanism. Check for proper refill retraction. If it doesn't retract fully, the lower tube dimensions have most likely been shortened.
4. **Place** the Center Band into the end of the upper barrel.
5. **Assemble** the Clip and Cap and **press** into end of the 12.5mm upper barrel.

Diagram B - Bushings

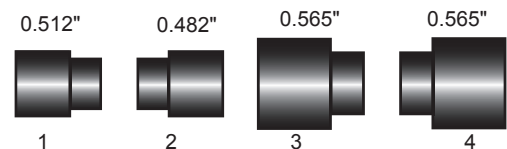


Diagram C - Turning the Pen

