

CEO TWIST PEN

REQUIRED ACCESSORIES

- 7mm pen mandrel
- 2-pc bushing set
- 0.368" Drill bit
- Pen Mill
- 2-part epoxy glue or Insta-cure (cyanoacrylate) glue

PREPARING THE BLANK

- Cut 3/4" to 5/8" square blank to the length of the brass tube (add 1/16" for squaring off).
- Use a 0.368" bit to drill a center hole lengthwise through the blank.
- Spread glue over tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When glue dries square the ends of the blank with the pen mill. Take the wood down, flush with the brass tube.

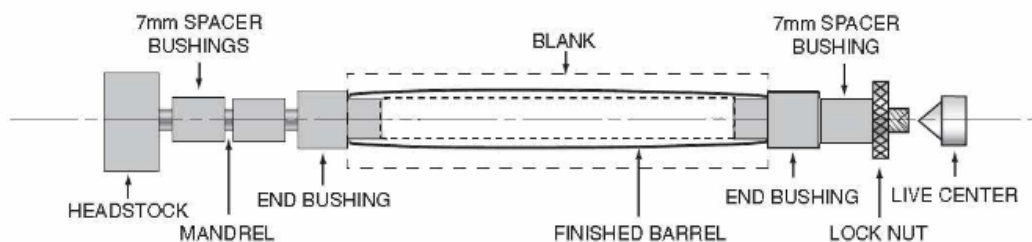


DIAGRAM B - MOUNTING ON THE LATHE

TURNING THE BLANK

- Place spacer bushings on the mandrel. Insert an end bushing wide end in first and follow with the wood blank. Place the other end bushing on the mandrel, narrow end in first. Place another spacer bushing to close up the space up to the threads. Thread on the knurled nut hand tight. Bring the tailstock over to engage with the mandrel shaft. Lock in place. Tighten the lock nut (Do not over-tighten, it could damage the mandrel).
- Turn the wood down flush with the bushing (you may create a slight profile) using lathe chisels and gradual higher grits of abrasives.
- Finish the wood with your choice of polish and wax.

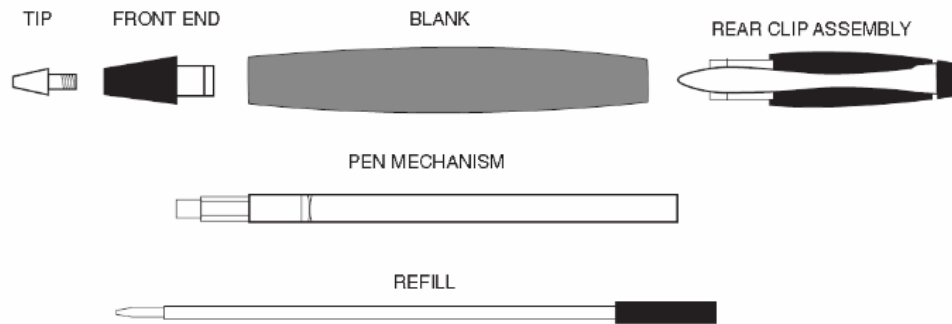


DIAGRAM C - PEN ASSEMBLY

PEN ASSEMBLY

- Line up finished parts according to Diagram C.
- Press the front end, recessed end in first into the barrel.
- Insert the twist mechanism, narrow end in first into the opposite end of the barrel.
- Thread in the tip through the front end into the mechanism tightly.
- Insert the pen refill, narrow end first, into the opposite end. Thread to the end.
- Slip the cap assembly over the refill top end and push in all the way.
- The pen operates by twisting the cap assembly to extend or retract the refill tip.