

CLASSIC TWIST PEN

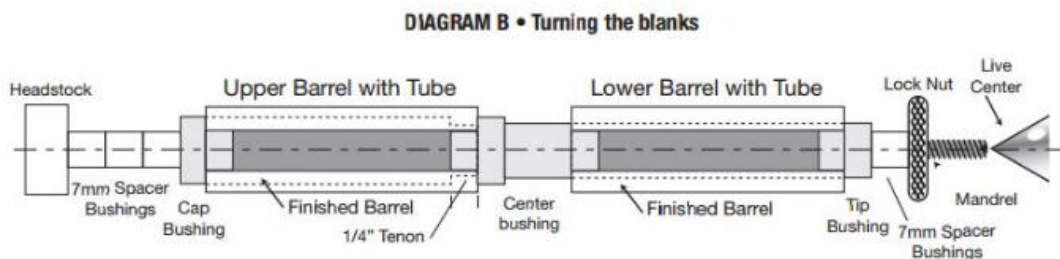
- 7mm Pen Mandrel
- 3-piece Bushing Set
- 8mm Drill Bit
- Universal Barrel Trimmer
- 2-part epoxy glue or insta-cure glue (cyanoacrylate).

PREPARING THE BLANKS

- From 5/8" or larger square stock, cut blanks to the length of each tube plus 1/16" to each end for trimming.
- Drill carefully since excessive pressure may cause the drill bit to wander and/or split the blank. Slow the feed rate and back the bit out repeatedly for chip removal. Use a 8mm HSS drill bit.
- Apply epoxy or a gap filling cyanoacrylate (super glue), to the tube and insert into the blank with a twisting motion. This will spread the glue evenly. Centre the tube within the blank and allow to dry.
- Use a barrel trimmer to square the ends of the blank to the brass tube.

TURNING THE BLANKS

- Mount the wide bushing, one wood blank (cap) and centre bushing on the mandrel as indicated in Diagram B. Make sure that the centre bushing is positioned properly to turn the cap and body to different diameters matching the outside dimensions of the bushings. The cap is the wider, and the body is narrower. For the best results, the blanks must be turned to the exact diameter of the bushings. After final turning and before finishing, a tenon must be cut in the cap to accommodate the centre band.



- The diameter of the tenon should match the narrow diameter of the centre bushing. To ease the turning of the tenon, slide the centre bushing off the mandrel and turn it around 180 degrees. Next, slide the centre band onto the bushing (flat end towards the wood) and replace it on the mandrel as indicated in Diagram B.
- The length of the tenon can be approximately 1/4" which is about 5/32" less than the width of the centre band. This is done to allow the pen body to inset into the centre band when closed. When ready for the final cut, slide the centre band from the bushing onto the tenon to test for fit. The proper diameter for the pen cap body should be the same as the outside diameter of the centre band, When the proper fit is obtained, move the band away from the wood and finish the blank. You may then permanently mount the band by adhering with a drop of glue.
- NOTE: When turning this blank near the centre bushing, use a small piece of tape to secure the centre band to the bushing so it does not spin and possibly hit your turning tool.
- Sand both blanks and then finish the blanks with your choice of polish and wax.

Diagram A



Assembly:

- Line up the pen parts according to the Diagram A.
- Press the clip assembly into the pen blank opposite the tenon.
- Press the tip assembly into the front tube.
- Press the threaded coupler into the opposite end of the front tube leaving the threads exposed.
- Insert the pen refill with the spring into the pen body. Screw the twist mechanism onto the coupler.
- Glue the center band onto the tenon you cut in the pen cap body making sure you place the squared end against the wood.
- Push the two pen halves together aligning the grain as desired. The pen is operated by twisting the halves in opposite directions to extend or retract the point. If the pen point is not retracting smoothly, try to stretch the spring and retry