

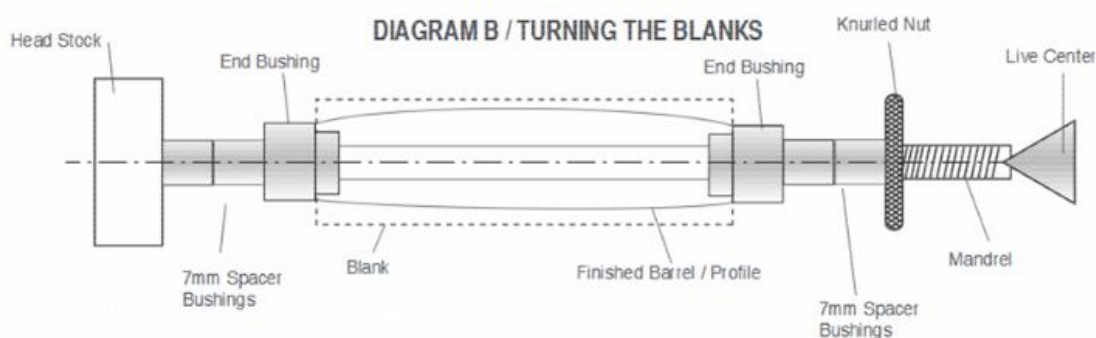
TRIO PEN INSTRUCTIONS

Supplies Needed

- 7mm Pen Mandrel
- 12.5mm Drill Bit
- Set of Bushings
- Barrel Trimming Set
- Glue (Thick CA or Epoxy)
- Sand paper/Finish
- Drill or Drill Press
- Pen Press or Clamp
- Eye and Ear Protection

Preparing the Blank:

- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 12.5 mm hole lengthwise through the blank
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use a 7mm barrel trimmer with the listed sleeve, 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.



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.

DiagramA



DiagramC



Assembly

Tear off the two retaining washers, insert and glue them into the opening of the barrel (See diagram C)

To change the mini refill: unscrew the light end of the assembly. Unscrew and remove the refill, replace.



To change batteries:

remove the light end of the assembly. Unscrew the battery holder from the LED holder. Remove and replace 3 batteries. Insert with (+) side towards the LED. Reassemble with spring in place.

