

PEN KITS ASSEMBLY INSTRUCTIONS FOR GOSPEL TWIST PEN KITS

Required Accessories

- 7mm pen mandrel
- 3-piece Bushing Set RZ-BP247#-BU
- 8mm Drill Bit RZ-DB008
- Universal Barrel Trimmer RZ-PM012
- Live Tailstock Center
- Glue (Thick CA or Epoxy)



Preparing the Blank

- Cut 2 blanks to the length of the tube and add 1/16" for squaring off.
- Drill 8mm holes 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 barrel trimmer, 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 since this may interfere with operation of the mechanism and assembly). Use a barrel trimmer to clean the inside of the tube.



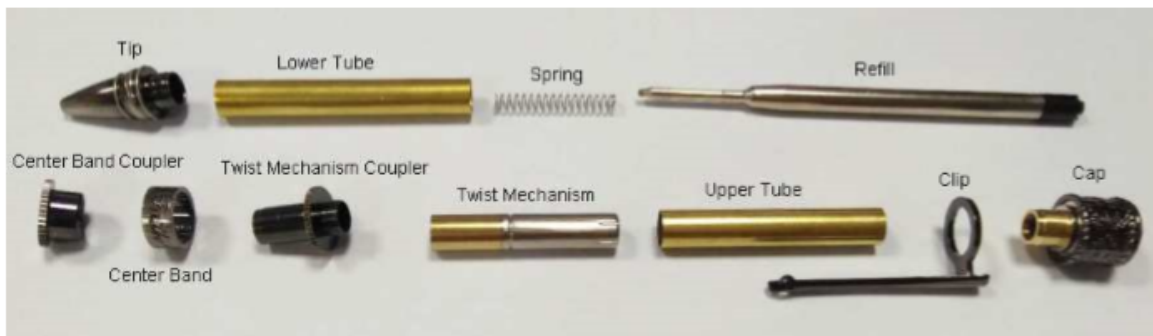
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Turning the Blank

- Mount the bushings and blank according the diagram above.
- 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 to cure.

Diagram A



Assembly

Layout parts according to diagram A

- Press the tip into the turned nib end (narrowest part) of the lower tube.
- Put the Twist Mechanism Coupler, Center Band and the Twist Mechanism Coupler together as per the picture below and then press into the opposite end of the tube. Ensure that you get the Centre Band round the correct way before you put it into the tube.

NOTE: To avoid damage, do not press directly over the threads. Rather cut a section of a pen blank to 1/2" long. Drill a 8mm hole through the section, affix over thread and press.

- Affix the spring over the refill and drop into the opening of the lower tube. Screw the mechanism over.
- Affix the clip into the cap, thread into the upper tube.
- Engage the upper and lower ends.
- The pen operates by twisting the ends to advance or retract the refill tip.