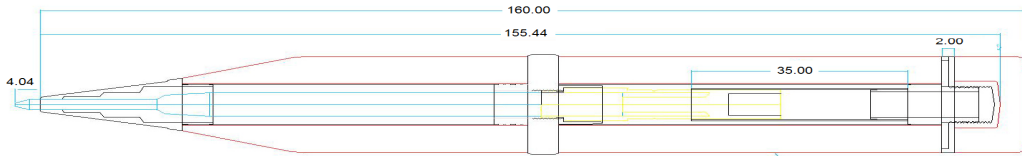


## OVERSIZE PEN KIT ASSEMBLY INSTRUCTIONS



### REQUIRED ACCESSORIES

- 7mm, Long Mandrel.
- 4 Pc. Pen Bushing Set
- $\frac{27}{64}$ " Drill Bit
- 2 Part Epoxy Glue or Insta-Cure (cyanoacrylate).

### PREPARING THE BLANKS

Cut the blank slightly longer than the brass tube

- Drill the blank through the center, lengthwise, with a  $\frac{27}{64}$ " Bit
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise inside the blank.
- When the glue dries, square the ends of the blank.

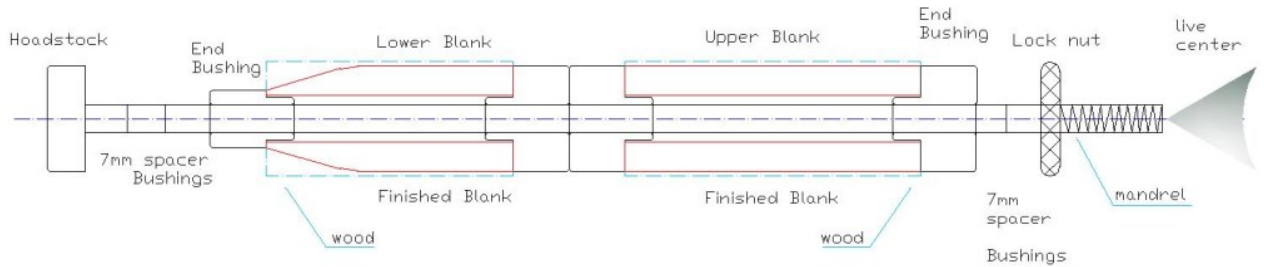
Use a barrel trimmer or a belt / disc sander to trim the wood down flush to the end of the brass tube.

### TURNING THE BLANKS

- According to Diagram-A Place the stop bushing, or 7mm spacer bushings, onto the mandrel hand tight. Next, place the cap bushing wide dia. in first, on the mandrel. Slide on the upper blank (longer), then place one center bushing (narrow first) on the mandrel, then put another center bushing (wide first). Slide on the lower blank (shorter) and follow with the tip bushing (narrow end first). Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not over tighten, it could damage the mandrel).
- Slide the stop bushing toward the blank, adjusting to remove spaces. Then tighten the set screw, and tighten the lock nut.
- Using a lathe chisel, turn the blank down flush with the bushings. Taper the ends of the blanks to conform with cap and tip bushings.
- Finish the blank with gradual higher grits of sand paper and your choice of polish and waxes.

## OVERSIZE PEN KIT ASSEMBLY INSTRUCTIONS

### DIAGRAM -A



### Pen Assembly

- NOTE: Line up the components according to the DIAGRAM-B
- Press the tip into the end of the lower barrel (shorter tube)
- Place the refill with spring inside the lower barrel.
- Press the coupler into the opposite end of the lower barrel.
- Press the upper barrel to the mechanism assembly
- press the clip assembly into the opposite end of upper barrel to complete the pen.

### DIAGRAM -B

