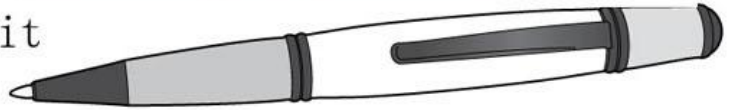


Gatsby 24kt Gold Twist Pen Kit



KIT FEATURES

- Smooth cap twist mechanism
- Parker™ style refills
- Overall length: 5-1/4"

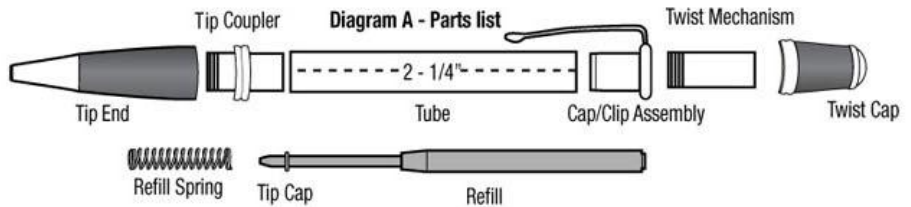
REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 2-pc bushing set
- Drill bit – 27/64"
- Barrel trimming sleeve
- Universal trimming kit
- 2-part epoxy glue or insta-cure glue (cyanoacrylate).

PREPARING THE BLANK:

- Prepare a master blank of at least 5/8" square. Cut to the length of the brass tube (add 1/16" for trimming)
 - Drill a 27/64" center hole through the blank.
- NOTE: Sand the tube with 220 grit abrasive for better adhesion.
- Glue the tube in the blank. Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Center the tube inside the blank.
 - Square the ends of the blank using a 7mm barrel trimmer with the adapter sleeve. Mount the sleeve over the shank. Trim the blank down flush with the brass tube.

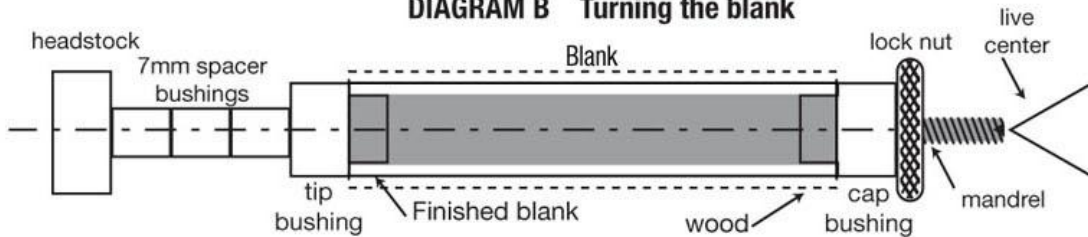
Diagram A - Parts list



TURNING THE BLANK:

- Mount 7mm spacer bushings on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing, narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the lock-nut hand tight. Bring the tailstock in snug to the mandrel and tighten the lock-nut for turning. Do not over-tighten the lock nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

DIAGRAM B Turning the blank



ASSEMBLY:

NOTE: Line up finished parts according to diagram 'C'.

- To avoid damage to components when assembling, use vise with covered jaws or PSI
- Press the tip coupler, plain side into either end of the barrel
- Insert and press the clip assembly into the opposite end of the barrel
- Screw on the tip end over the exposed threads of the tip coupler
- Pull the refill tip cover out and drop the refill with the spring into the opening at the clip end
- Screw the twist mechanism into the cup assembly threads
- Mount and push the twist cap over the mechanism stem to bottom
- The pen operates by twisting the cap in either direction to advance or retract the refill

Diagram C - Assembly

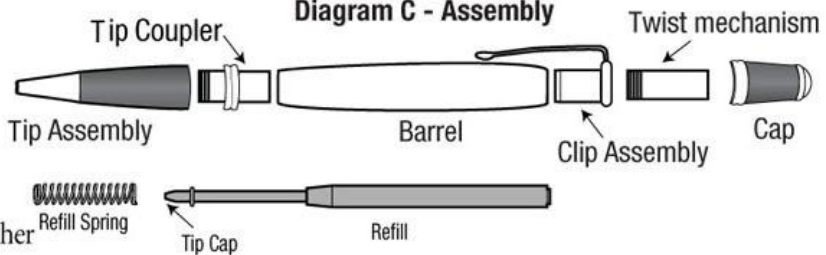


DIAGRAM D PKGAPENBU

