

Graduate Twist Pen Kit

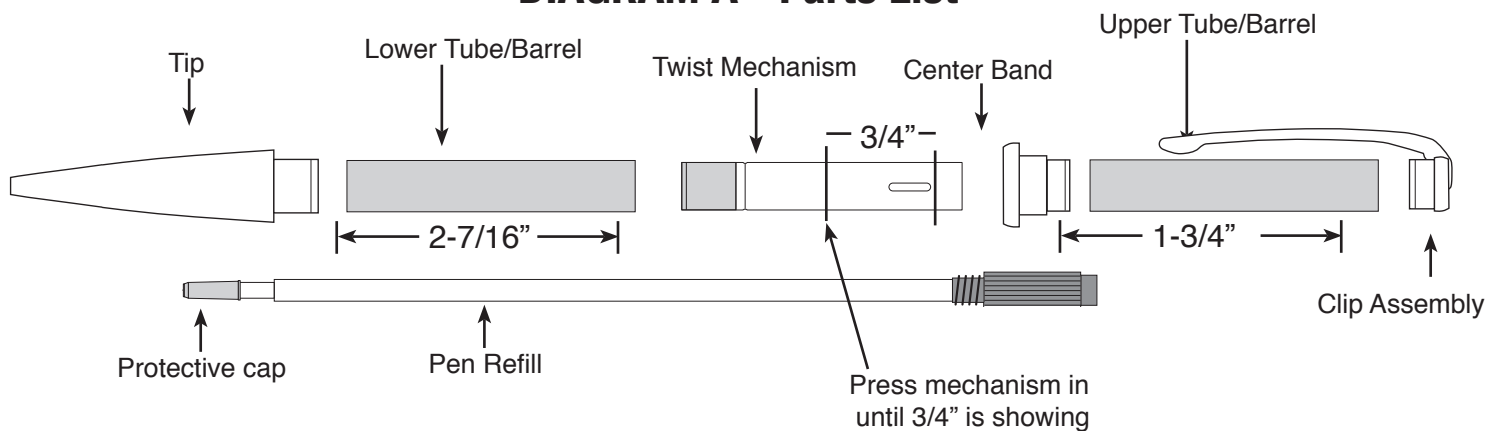
PKGRADxx

Required Accessories:

- 7 mm, pen mandral
- 3 pc. bushing set #7114
- 7 mm drill bit
- 3/8" drill bit
- Universal barrel trimming system #PK
- Pen uses Cross™ style refill
- 2 part epoxy glue or insta-cure (cyanoacrylate)
- Overall length: 5-3/8"



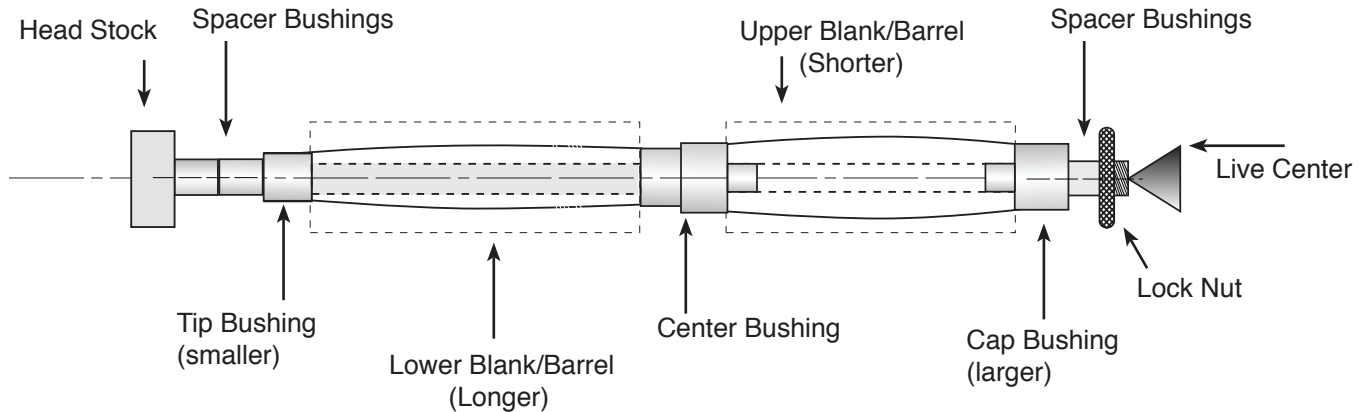
DIAGRAM A - Parts List



Preparing the Blank

- Cut 5/8" or larger pen blanks to the length of the brass tube (add 1/16" for trimming).
- Drill a 7mm hole lengthwise through the longer blank.
- Drill a 3/8" hole lengthwise through the shorter blank.
- 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 in the blank.
- When glue dries, Square the end of each blank. Use a 7mm Barrel trimmer for the longer blank and use a 3/8" barrell trimmer for the shorter blank. Take the wood down to the brass tube.

DIAGRAM B - Turning the Blanks



Turning The Blanks

- Mount the bushings and blanks onto the mandrel according to diagram 'B'.
- Turn the wood down close to the size of the bushings. Sand the wood down to the bushing diameter.
- Finish the wood with your choice of polish.

Assembly

NOTE: Layout Finished parts according to Diagram A

- Press the tip into the smaller diameter of the lower barrel.
- Press the twist mechanism into the opposite end of the barrel. Continue passed the I.D. line until only 3/4" of the chrome is showing.
- Remove the protective cap of the refill. Insert and screw in the refill through the mechanism hole.
- Press the center band into the wide end of the upper barrel.
- Press the clip assembly into the opposite end of the barrel.
- Engage the two halves of the pen. The pen operates by twisting the ends to advance or retract the refill, for writing.

DIAGRAM C - Bushings

7114

