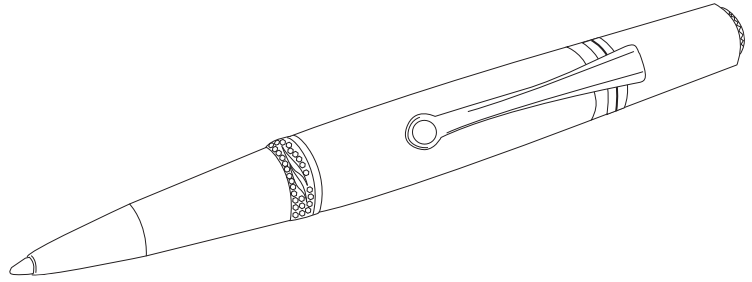


Majestic™ Squire Twist Pen Kit Instructions

KIT FEATURES

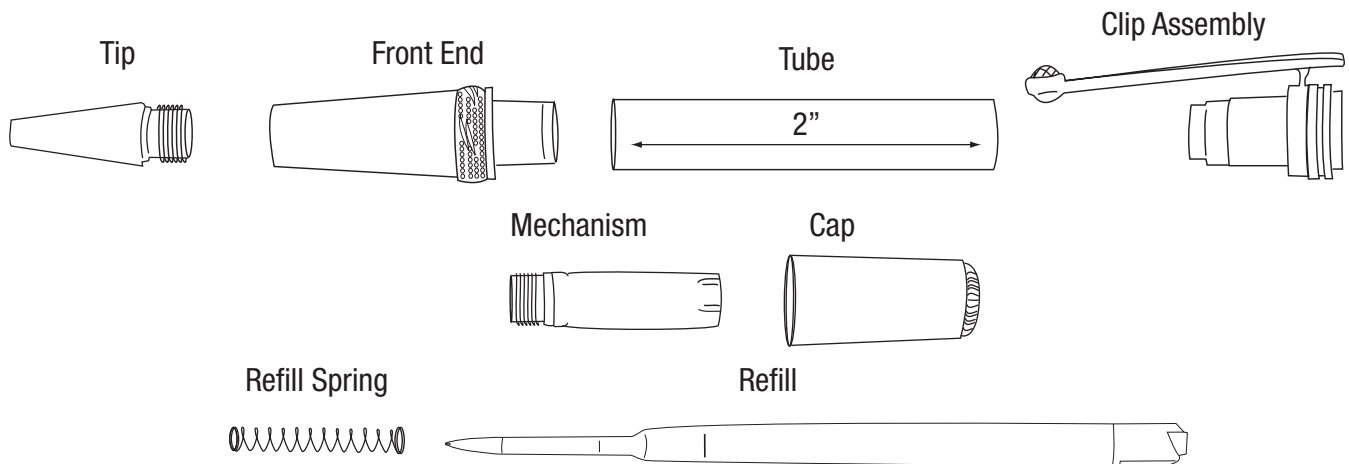
- Common 3/8" single tube construction
- Crystal in clip
- Attractive Majestic band and cap
- Uses Parker style refill/can be substituted with gel
- Overall length 5-1/4"



REQUIRED ACCESSORIES

- 7mm pen mandrel
- 3/8" drill bit
- 2-piece bushing set # 4446
- 3/8" barrel trimmer Use only 3/8" size
- 2-part epoxy glue or insta cure (cyanoacrylate) glue

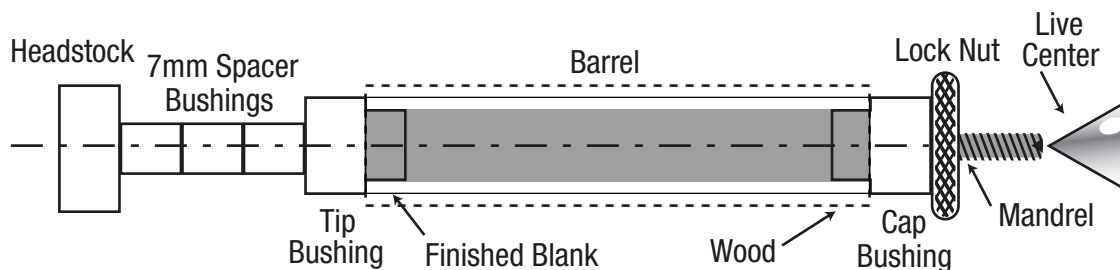
DIAGRAM A – PARTS LIST



PREPARING THE BLANKS

- From 3/4" square stock, the wood or acrylic blank to the length of the brass tube. Add 1/16" for squaring off.
- Drill 3/8" center hole lengthwise through the blank.
- Glue the brass tube in the blank. Spread the glue on the tube. Insert into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank. Allow it to dry.
- After the glue dries, use a 3/8" Barrel Trimmer to square the ends of the blank to flush with the ends of the brass tube.

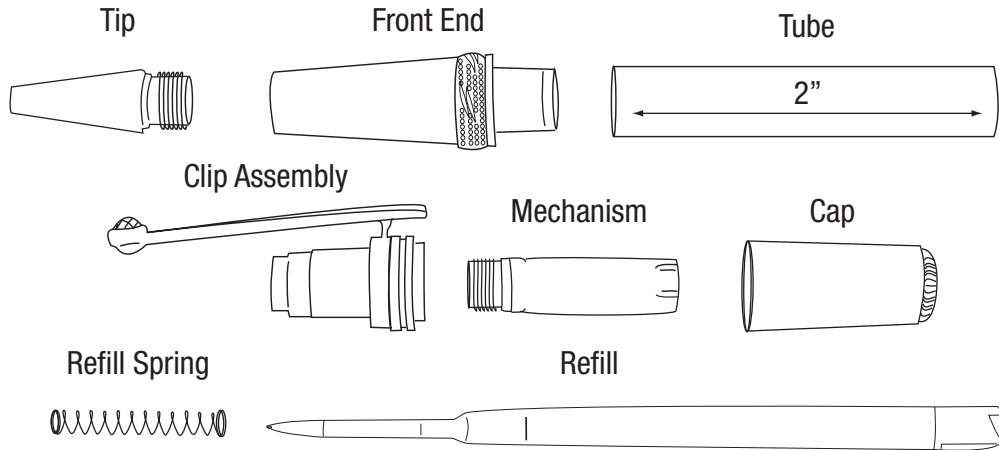
DIAGRAM B – TURNING THE BLANK



TURNING THE BLANK

- Place spacer bushings onto the pen mandrel. Slide an end bushing onto the mandrel, wide end first. Insert the blank and follow with the second bushing (narrow end first). Add additional spacer bushings to close the space to the threads on the mandrel. Thread the lock-nut onto the mandrel hand-tight. Bring the tailstock in snug with the mandrel. Do not overtighten- this could damage the pen mandrel. Lock the nut and the tail stock in place.
- Turn the blanks down close to the bushings located at the ends of the blanks. Sand the blanks down to the bushings.
- Finish the turned barrels with your choice of PSI polish.

DIAGRAM C – ASSEMBLY



ASSEMBLY

- Press front end, recess end in first into either ends of barrel.
- Press clip assembly, narrow end first into the opposite end of the barrel.
- Screw on the pen mechanism into the opening at the cup assembly to bottom.
- Insert the cap over the the exposed end of the mechanism and press in.
- Pull the protective tip off the refill. Insert into the opening at the opposite end of the pen. Insert spring and screw the tip over the refill.
- The pen is ready to operate. Just twist the cap from one position to another to extend or retract the refill.

BUSHINGS – #4446

