



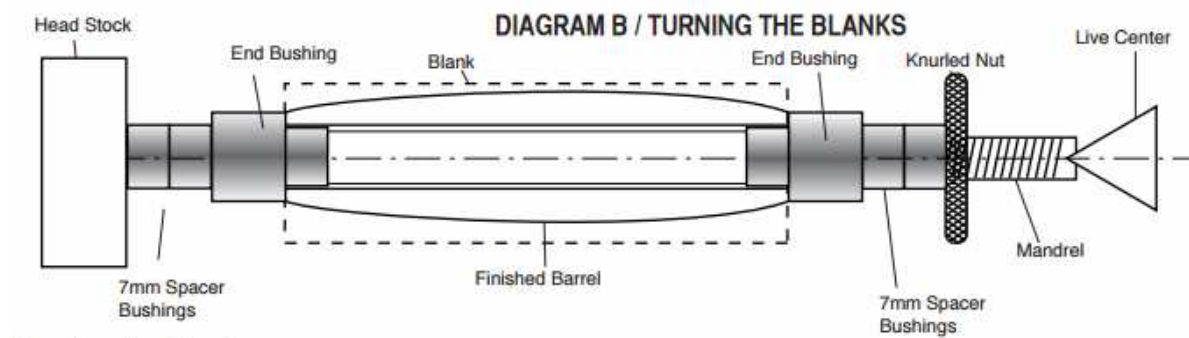
Spiritual Twist Pen Kits Assembly Instructions

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8"
- Bushing set #9553
- Barrel Trimming set 3/8
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/4"

Preparing the Blank:

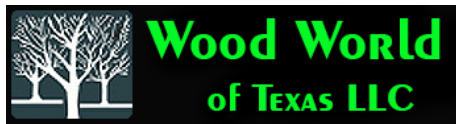
- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks. Use a 3/8" 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.



Turning the Blank

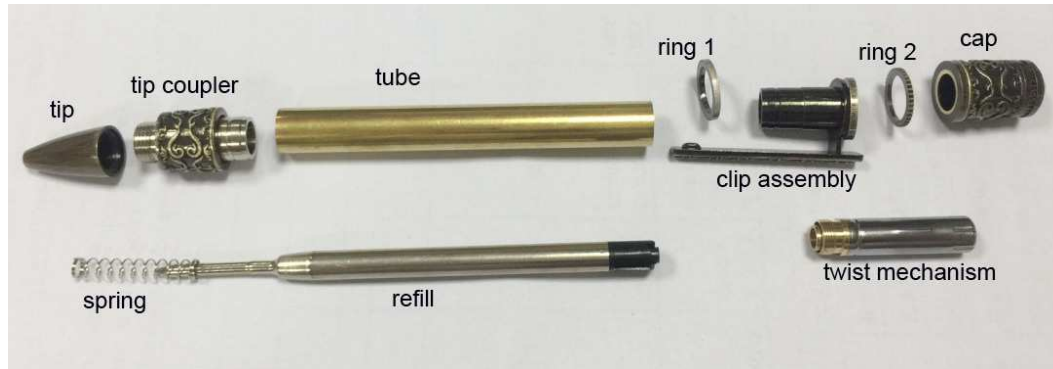
- Mount the bushings and blanks according to diagram B.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.)

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- 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. Refer to polish instructions.

Diagram A



Assembly

Layout parts according to diagram A

- Screw the tip over the tip coupler.
- Press the tip coupler into either end of the barrel. DO NOT press directly on threads.
- Put the ring1 into the clip assembly, then press into the opposite end of the barrel.
- Screw on the mechanism into the opening at the clip assembly.
- Affix the spring over the refill and drop the refill into the opening at the tip coupler, then screw the tip into the tip coupler.
- Press in the cap with the ring 2 over the mechanism extension.
- To change the refill unscrew the cap/mechanism assembly and replace.
- The pen operates by twisting the cap to extend or retract the refill tip.

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