

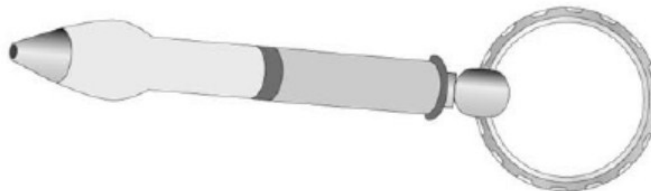
PENKITS UK

PEN KITS ASSEMBLY INSTRUCTIONS

Mini Key Chain Pen Kit

KIT FEATURES

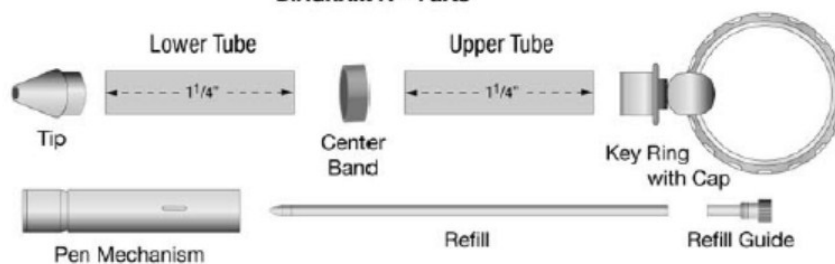
- A clever twist pen/combination key ring
- Smooth operating twist mechanism
- Overall length: 3-1/4"
- Uses refill
- Available in 24kt Gold, Brushed Satin and Chrome Finish



REQUIRED ACCESSORIES

- 7mm Pen Mandrel
- 7mm Drill Bit
- 3-piece Bushing Set
- 7mm Barrel Trimmer or Universal Barrel Trimmer system
- Insta-cure (cyano acrylate) glue or 2-part epoxy glue

DIAGRAM A • Parts



PREPARING THE BLANKS

- Cut 1/2" (or larger) square blank to the length of the tubes included in the kit. Add 1/16" for squaring off.
- Drill a 7mm hole through each blank lengthwise. Excessive pressure may cause the drill bit to wander and/or split the blank. Slow the feed rate and back the drill bit out repeatedly for chip removal. For best results, use a HSS drill bit.
- Apply epoxy or gap filling cyano acrylate (super glue) to the tubes and insert into the blank with a twisting motion, spreading glue evenly. Center the tube within the blank and allow to dry.
- Trim each blank to the length of the brass tube.

TURNING THE BLANKS

- Install 7mm pen-making mandrel on the lathe, and live center onto tailstock. Refer to **DIAGRAM B**.
- Place spacer bushings on the mandrel. Place one bushing on, followed by the lower blank.
- Insert the a second bushing on mandrel, followed by the upper blank. Insert the third bushing.
- Thread the lock nut hand tight onto the 7mm mandrel. Do not overtighten the lock nut, it could damage the mandrel.
- Bring tailstock snug to the mandrel and lock it into place. Tighten the lock nut for turning.
- Using sharp tools, turn the blank down. Sand the blanks to the size of the bushings.
- Finish the blank with your choice of polish.

DIAGRAM B • Turning The Blanks

