

Sierra Twist Pen Kit

INSTRUCTIONS 【#PKM-9】

KIT FEATURES:

- Single tube
- Parker style refills - #RF-2-BK
- Overall length: 5-1/4"

REQUIRED ACCESSORIES

- 7 mm pen mandrel
- Sierra bushing set #BUM-9
- 27/64" drill bit #PKTU-M9
- Barrel trimmer
- 2-part epoxy glue or insta-cure glue (cyanoacrylate)
- Wood or acrylic blank, minimum size 5/8"
- Live tailstock center
- Sanding and finishing supplies

PREPARING AND TURNING THE BLANK

1. Cutting the wood or acrylic blank

Cut one blank to the length of the brass tube plus approximately 2 mm.(Approx. 67 + 2 mm). Grain should run lengthwise.

2. Drilling the blank

Drill a 27/64" diameter centered hole lengthwise through the blank. Excessive pressure will cause the drill bit to wander and/or split the blank. Slow the feed rate and back the bit out repeatedly for chip removal.

3. Gluing the brass tube into the blank

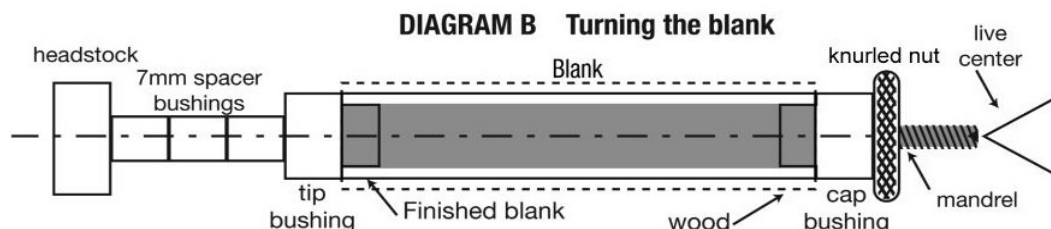
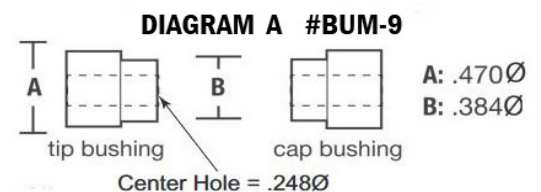
Use epoxy or a gap filling cyanoacrylate. Spread the glue on the tube. Insert into the blank with a twisting motion to spread the glue evenly inside. Centre the tube lengthwise in the blank. Allow the glue to dry. Remove all glue residue from the tube.

4. Squaring the ends of the blank

Use a barrel trimmer to turn away the excess wood to finish flush with the ends of the brass tube.

TURNING THE BLANK:(Ref to DIAGRAM A& B)

- Mount 7mm spacer bushing 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 knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled 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



ASSEMBLY:

- Line up finished parts according to diagram C.
- Slide the spring onto the refill and place inside the tip assembly. Screw the pen mechanism into the tip assembly.
- Press the clip assembly into the upper end of the barrel.
- Push the pen tube with cap assembly onto completed lower part.
- The pen is now ready to operate. Twist clockwise to open.

DIAGRAM C ASSEMBLY

