

# Strongink #PKM-3 Pen Kit Instructions

## Kit Features:

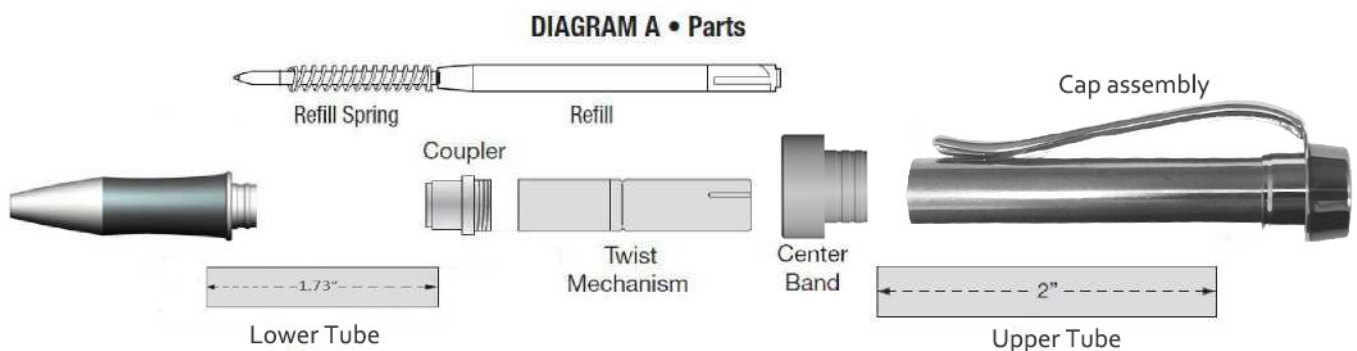
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker Style Refill

Overall Length: 5-1/2" Long

## Required Accessories:

- 7 mm Pen Mandrel
- Drill Bit: 8mm, 9mm
- Bushing set(3 pc) -#BUM-3
- Barrel Trimming set
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue

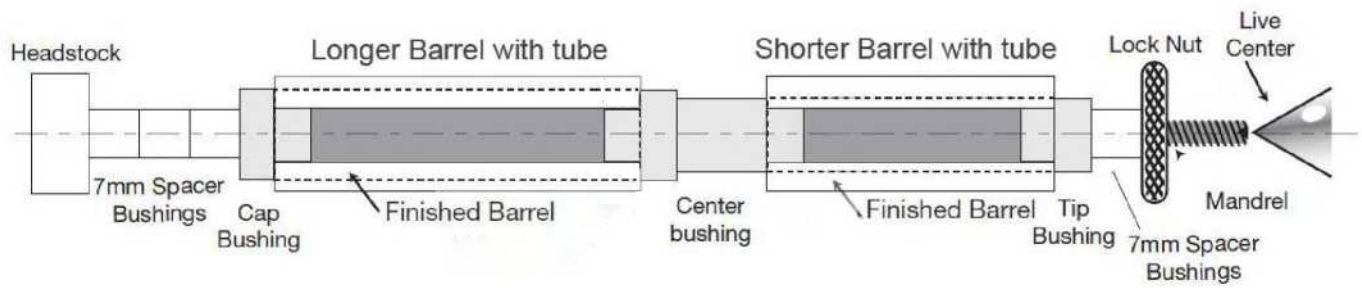
- Pen Blank: Minimum Size: 5/8" x 2-1/4"



## Preparing the Blank:

- From 5/8" or larger square stock, Cut 2 blanks to the lengths of the tubes and add 1/16" for squaring off.
- Drill **8mm** hole lengthwise through the shorter blank. Drill **9mm** hole lengthwise through the longer blank.
- Spread glue over the tubes, insert the blanks with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 8mm barrel trimmer .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).

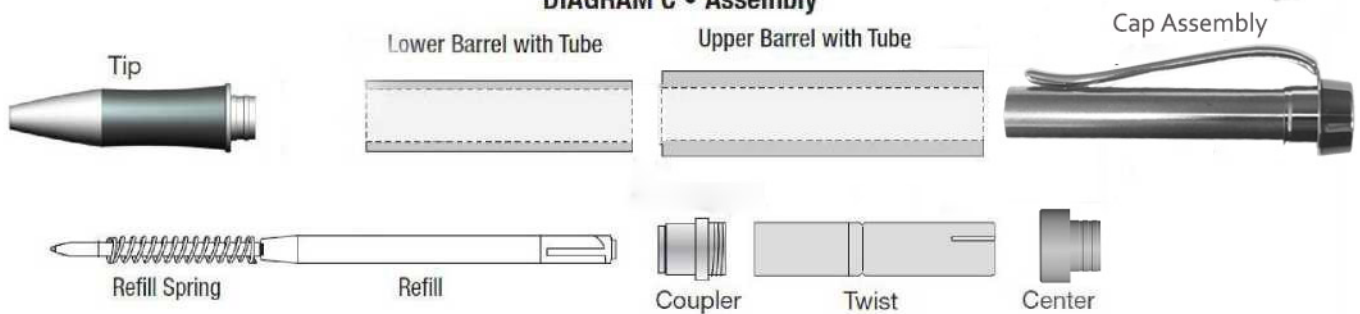
**DIAGRAM B • Turning the blanks**



## Turning the Blank

- Mount the wide bushing, one wood blank (cap) and center bushing on the mandrel as indicated in **Diagram B**.
- **NOTE:** The center bushing has two shouldered diameters made to match the wide and narrow bushings. The second wood blank should be mounted next to the center bushing, and the third (narrow) bushing mounted last (See *Diagram B*). Make sure that the center bushing is positioned properly to turn the cap and body to different diameters matching the outside dimensions of the bushings. The cap is the wider, and the body is narrower. For the best results, the blanks must be turned to the exact diameter of the bushings.
- Sand both blanks and then finish the blanks with your choice of polish and wax.

**DIAGRAM C • Assembly**



## General Assembly Hints:

- Line up the pen parts according to the **Diagram C**.
- Press the cap/clip assembly into the narrow end of the longer barrel
- Press the center ring into the opposite end of the longer barrel
- Press the pen tip into the other tube (the shorter tube)
- Insert the coupler into the opposite end of the pen barrel leaving the threads exposed; press together.
- Insert the pen refill—with the spring—into the pen body.
- Screw the twist mechanism onto the coupler.
- Push the two pen halves together aligning the grain as desired.

- The pen is operated by twisting the halves in opposite directions to extend or retract the point. If the pen point is not retracting smoothly, try to stretch the spring and retry.

## BUSHINGS

### DIAGRAM D • BUSHING

