

Polaris Twist Pen Kits INSTRUCTIONS 【#PKM-15】

KIT FEATURES:

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

REQUIRED ACCESSORIES

- 7 mm pen mandrel
- Bushing set #BUM-15
- Drill bit : 9.5mm (3/8")
- 7mm 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. 72 + 2 mm). Grain should run lengthwise.

2. Drilling the blank

Drill a 9.5mm 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 7mm barrel trimmer to turn away the excess wood to finish flush with the ends of the brass tube. **Note, you only need to trim off the extra pen blank material, try not to trim the brass tube, or it will affect how far the pen refill can extend.**



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

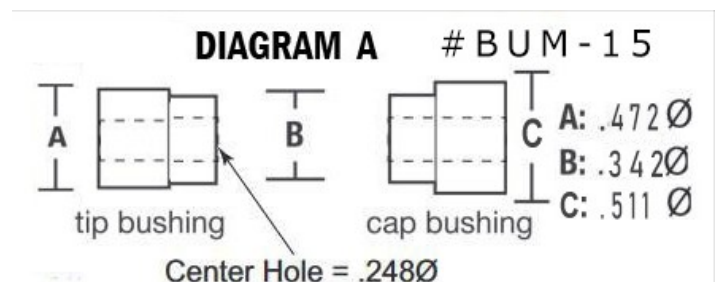
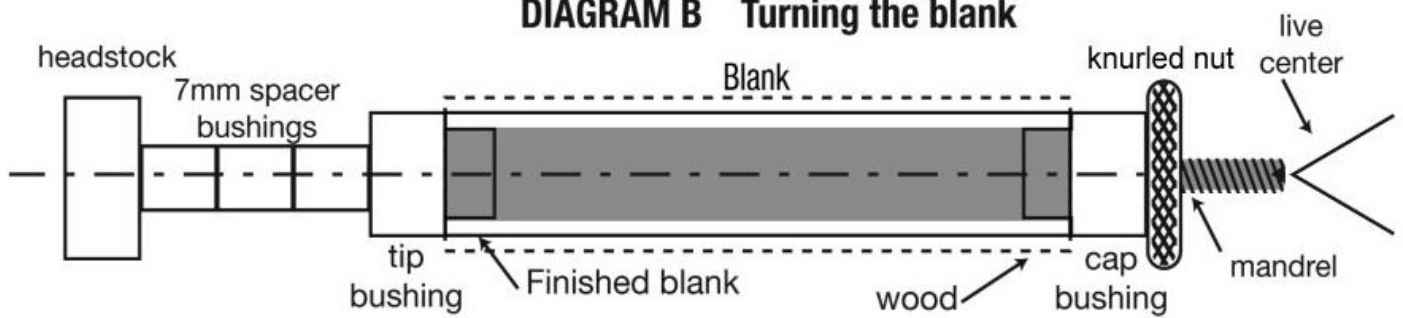


DIAGRAM B Turning the blank



ASSEMBLY:

Line up finished parts according to diagram C.

1. Press the pen tip into the narrow end of the barrel.
2. Insert the Sleeve into clip and press the sleeve in to opposite end of the barrel.
3. Screw the twist mechanism into the hole of the sleeve.
4. Push the pen cap onto mechanism.
5. The pen is now ready to operate. Twist clockwise to open.

DIAGRAM C

