

## AMAZING GRACE TWIST PEN KIT

### Instructions

#### Kit Features

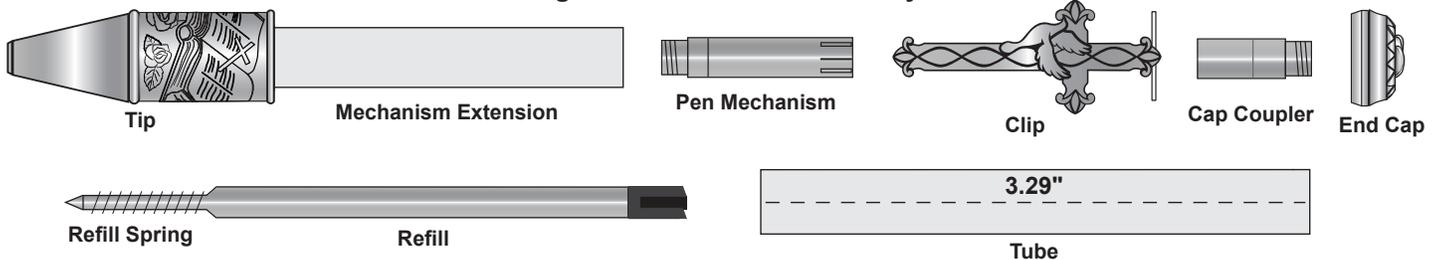
- Smooth twist mechanism
- Parker™ style refills (RE-PARK)
- Overall length: 5-3/8"

Optional Ready-made Pen Blanks: Carbon Fiber  
*No turning necessary*

#### Required Accessories & Materials

- 7mm mandrel
- 2-pc. Halloween bushing set (PKHAUNT-BU)
- Drill bit – 3/8" (DB3/8)
- Universal trimming kit (BTRIMKIT9)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

#### Diagram A - Parts and Assembly



#### BLANK PREPARATION

The Amazing Grace Twist pen has a single tube measuring 3.29". **Cut** your blank approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. Use a medium drill speed to **drill** the blank. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blank, **sand** the exterior of the brass tube to roughen its surface and use CA **glue** to glue the tube inside the blank. Sand or barrel trim to **square** the ends of the blank.

#### TURNING THE PEN

**Set up** the mandrel as shown in Diagram C. The Amazing Grace Twist pen's upper and lower bushings both have an outside diameter of .51" (see Diagram B). **Turn** the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

#### ASSEMBLY

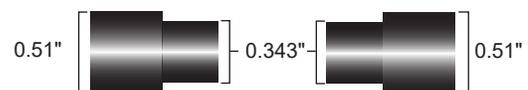
(Line up finished parts according to Diagram A)

*To avoid damage to components when assembling, use a vise with covered jaws or one of WoodTurningz' pen presses.*

1. Press Cap Coupler into tube until only the threads are visible.\*
2. Place Clip over threads on the Cap Coupler, screw End Cap onto Cap Coupler threads.
3. Drop refill with spring into the back of the Mechanism extension spring first.
4. Screw pen mechanism onto the end of the Mechanism Extension extension over the end of the refill.
5. Press by hand the assembled tip, extension, and mechanism through the pen barrel securely into the cap.
6. The pen is now ready to operate; twist to open.

\* Non-Turner Option: You can use a C-Clamp instead of a pen press if used carefully.

#### Diagram B - Bushings



#### Diagram C - Turning the Pen

