

Skeleton Key Pen Kit

Kit Features:

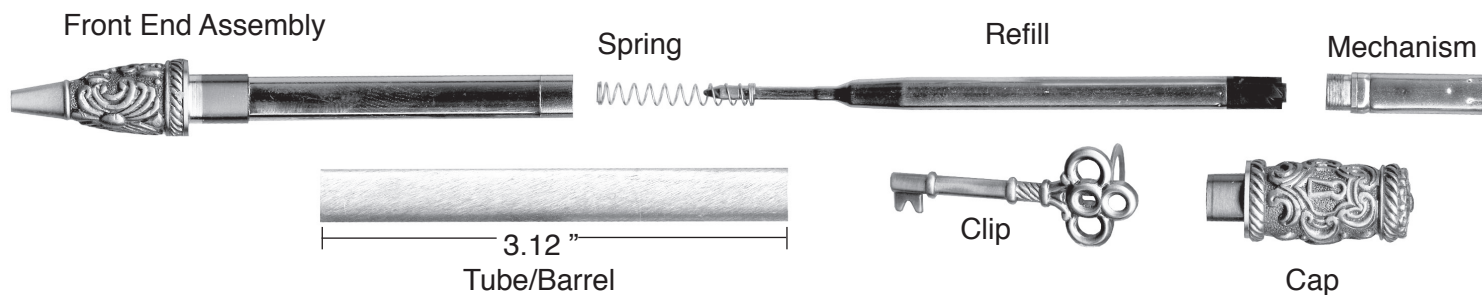
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Elegant Decorative components
- Uses Parker® Style Refill
- Overall Length: 5-1/2" Long

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38
- Bushing set(2 pc): #PKGAFBU
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center or Mandrel Saver Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/2"



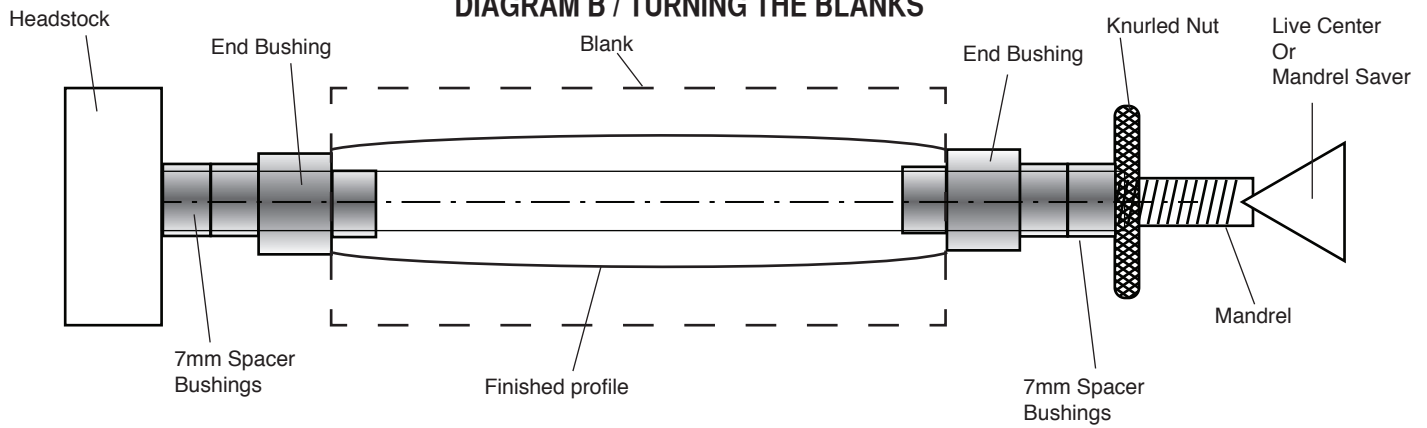
DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use a 3/8" barrel trimmer shaft, or a universal pen blank squaring jig with a power disc sander. 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). Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANKS

**Turning the Blank**

- Mount the bushings and blanks according to diagram B.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.)
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure. Refer to polish instructions.

Assembly

- Layout parts according to diagram A.
- Affix the clip into the recess at the cap.
- Press this assembly into either end of the barrel.
- Affix the spring over the refill end. Drop into the opening at the front end assembly.
- Thread the mechanism over the refill end.
- Engage and slide the barrel assembly over the front end assembly. Push the barrel to the shoulder. (or to close the space)
- The pen operates by twisting either end of the pen to advance or retract the refill tip.

Diagram C / Bushings #PKGAFBU