Sagiters Twist Pen Kits Assembly Instructions

Required Accessories

• 7mm pen mandrel
• 2-piece Bushing Set RZ-BP306#-BU
• 9.1mm Drill Bit
• Barrel Trimmer
• Live Tailstock Center
• Glue (Thick CA or Epoxy)

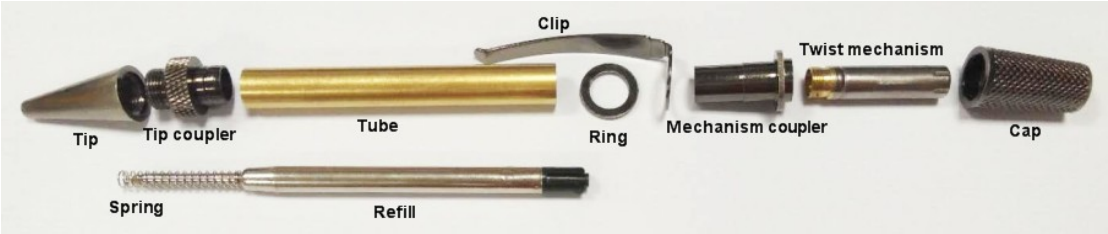
Preparing the Blank

• Cut 1 blank to the length of the tube and add 1/16" for squaring off.
• Drill a 9.1mm 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 barrel trimmer, 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.

Turning the Blank

• Mount the bushings and blank according the diagram above.
• 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.

Diagram A



Assembly

• Arrange parts according to Diagram A.
• Press the Tip coupler into one end of the Tube.
• Attach the Clip and Ring into the Mechanism coupler in place, and then press the assembly into the other end of the Tube.
• Next slide the Refill with the Spring into the Tube.
• Screw the Tip into the Tip coupler.
• Screw the Twist mechanism into the Mechanism coupler.
• Push the Cap into the Twist mechanism and test action.