

# Federal Twist Pen Kit

## Kit Features:

- Easy to turn with a single tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® Style Refill
- Overall Length: 5-3/4"

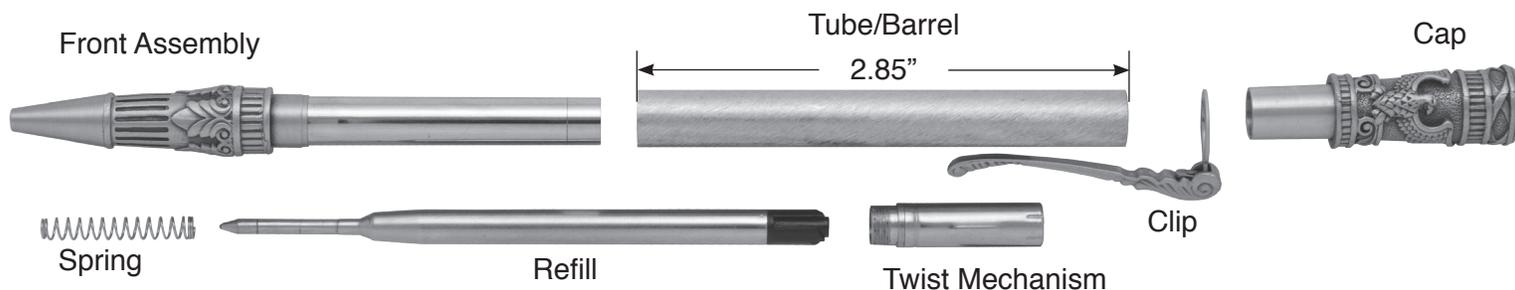
## Required Accessories:

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

**Note:** Cap & clip alignment



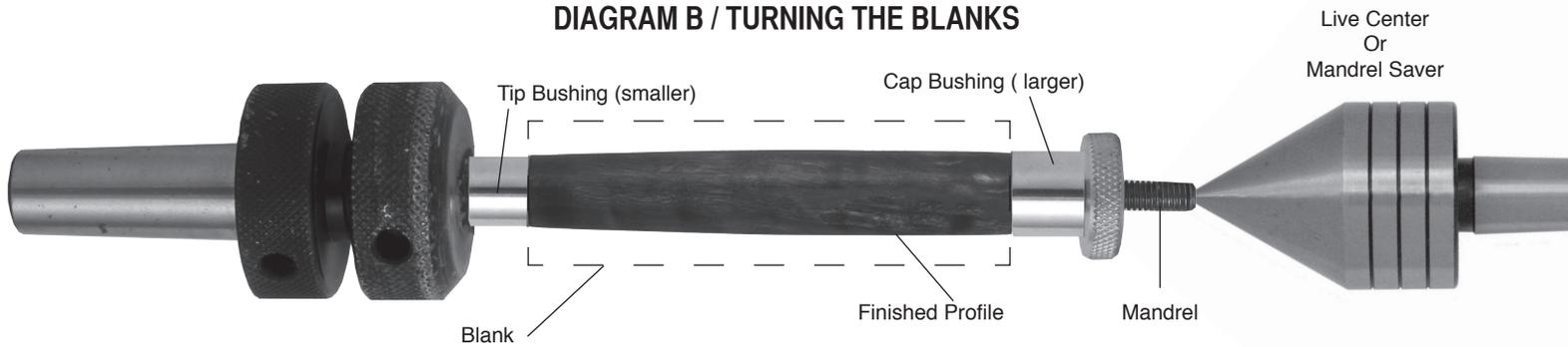
## DIAGRAM A / PARTS LAYOUT



## 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, 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 blank according to diagram A.
- 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
- Slide the clip over the extension of the cap end
- Align the clip with the eagle on the cap cast for best presentation. Press the wide end of the barrel over the extension of the cap end at the clip.
- Insert the spring, narrow end in first over the refill. Drop into the front assembly. Thread the mechanism over to secure the refill.
- Engage the ends of the pen to close the space and secure the mechanism out the cap end.
- The pen is ready to operate by twisting the front end to advance or retract the refill.
- To replace refill twist the tip counter clockwise to remove the front end assembly. The mechanism will be secured by the cap. Replace the exposed refill then re-attach the front assembly.

## Diagram C / Bushings #PKFEDBU

