

# Breast Cancer Awareness Twist Pen

PKBCPXX

## Kit Features:

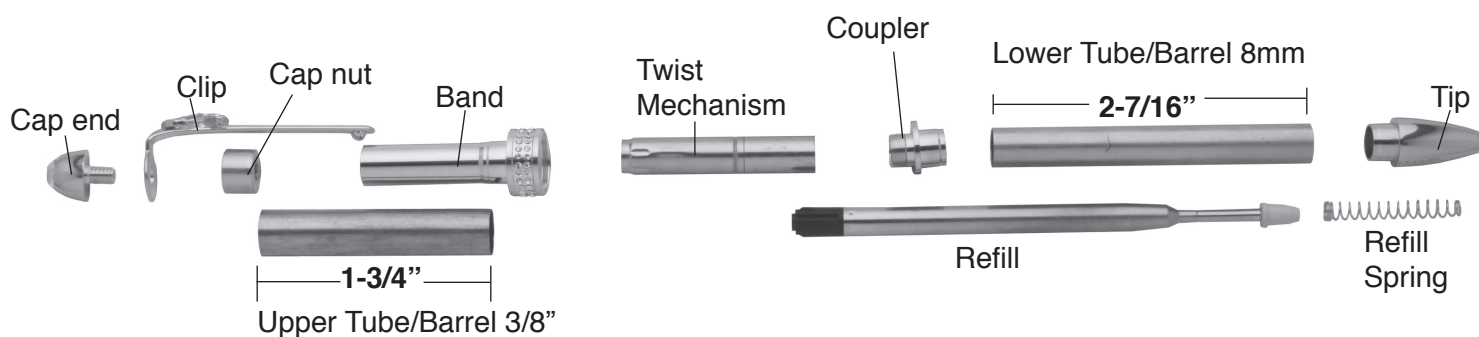
- An elegant pen design supporting breast cancer research
- Minimum parts - easy to assemble
- Available in multiple finishes
- Faceted Swarovski Crystals mounted in the clip, band & cap
- Uses Parker® type refill
- Overall Length: 5-1/2"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s) 8MM, #PKPARK-8MM  
3/8", #PKEXEC-3/8
- #PKBCPBU, Bushing set(3 pc)
- PKTRIMSET Barrel Trimming set Use 8MM & 3/8" Shafts
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 5/8 x 4-1/2 Long

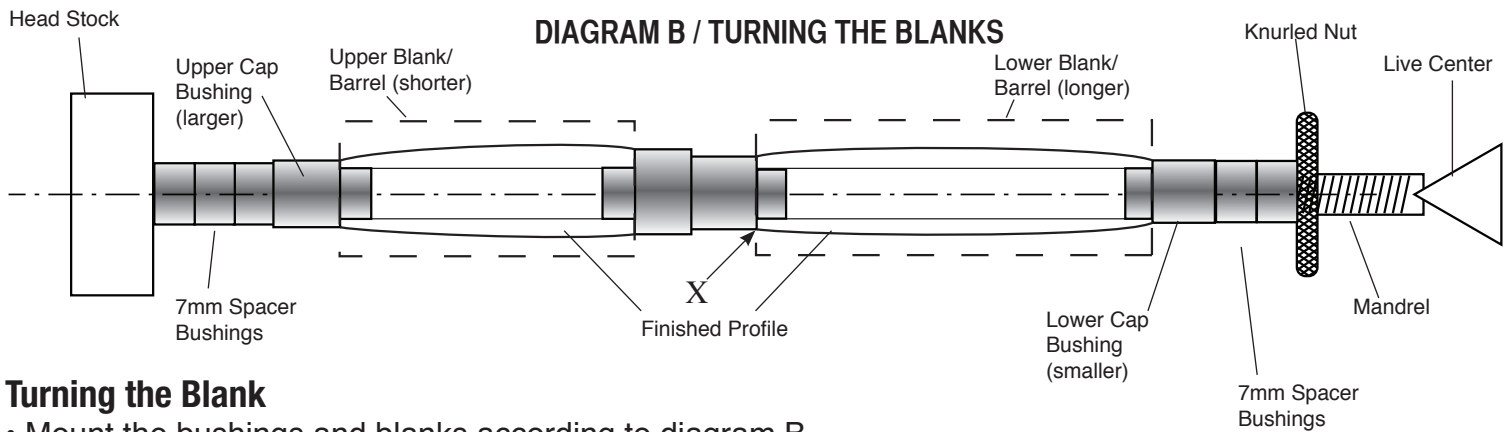


DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill an 8mm & 3/8" hole lengthwise through the appropriate blanks. 8mm(long blank), 3/8" (short blank)
- Spread glue over the tube(s), insert into the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use the proper barrel trimmer for each blank, 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).



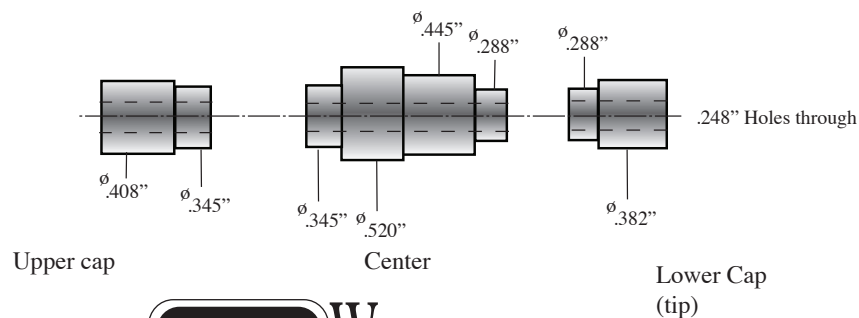
## Turning the Blank

- 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 lower barrel to a profile of your choice. It is important to meet the bushing dia. at X since the center band must clear the wood barrel at this point.
- 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.
- Press the tip end into the narrow end of the longer barrel.
- Press the coupler, recessed end in first into the opposite end of the same barrel.
- Remove the tip protector, affix the spring over the refill and insert into the opening at the end of the barrel, screw the twist mechanism over the refill and into the coupler.
- Insert the band, long extension in first into the larger diameter of the upper barrel and press in.
- Insert the cap nut, recessed end in first into the opposite (narrow end) of the barrel.
- Insert the cap end into the hole in the clip. Screw this into the opposite end of the upper barrel.
- Engage the two ends of the pen to the bottom.
- The pen operates by turning the clip end of the pen to advance or retract the refill. To replace the refill, unscrew the cap counter clockwise until it releases. Remove/Insert the refill & re-assemble.

## Diagram C / Bushings #PKBCPBU



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PRODUCTS