

ITEM #PK2WAY
2 WAY TECH PEN KIT

REVISED 4.03

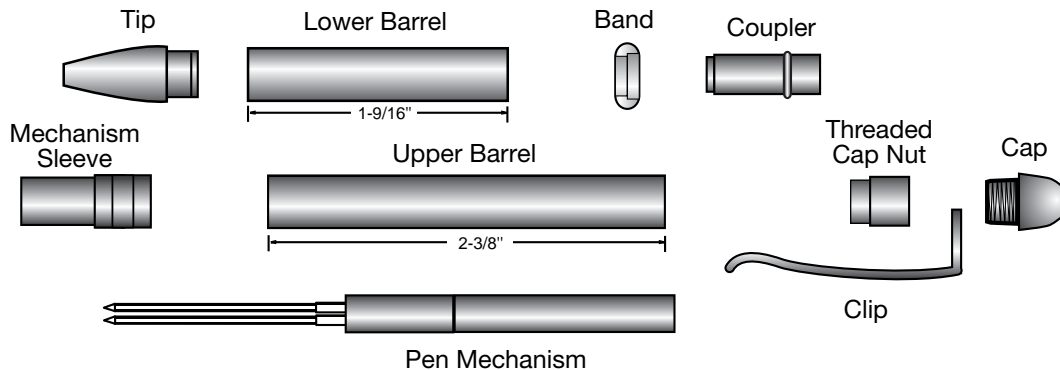
KIT FEATURES

- Heavy 24 kt. gold plating w/ epoxy coating
- Smooth twist operation and change of pen functions
- Kit includes 3 mini refills; PDA style, black and red inks.
- Choice of ball point pen only holds 2 refills at once.
- Contemporary clip design
- Over all length: 5-1/4"

REQUIRED ACCESSORIES

- 7mm, long mandrel
- 3-pc bushing set #PK2WAYBU
- 3/8" drill bit #PKEXEC-3/8
- 3/8" barrel trimmer #PKTRIMKIT
- 2 part epoxy glue, polyurethane glue or inst-cure (cyanoacrylate) glue.

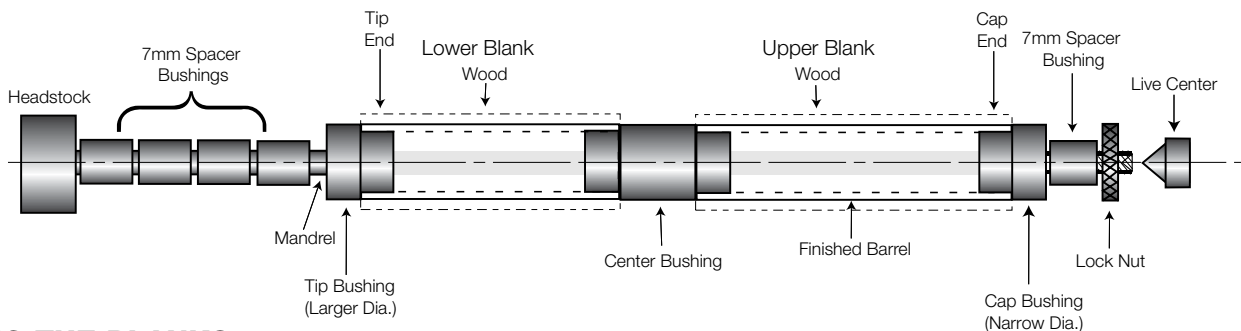
Diagram A - Pen Parts



PREPARING THE BLANKS

- Cut 5/8" square blanks to the length of the brass tube (add 1/16" for squaring off).
- Drill a 3/8" center hole lengthwise through each blank.
- Spread glue over the tube. Insert each tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When glue dries, square the end of the blanks. Use a 3/8" barrel trimmer to square ends. Take the wood down flush to the brass tube.

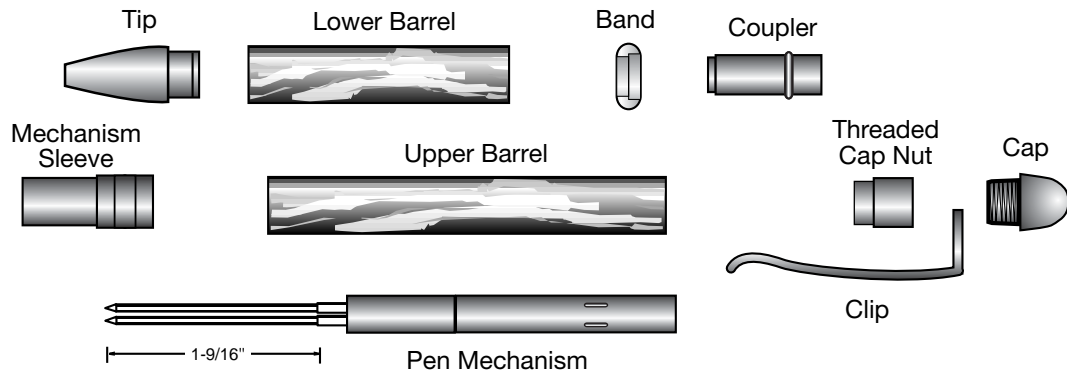
Diagram B - Turning the Blanks



TURNING THE BLANKS

- Place 3 or 4, 7mm spacer bushing onto the mandrel, followed by the tip bushing (larger dia) wide end in first. Insert the lower blank and follow with the center bushing. Insert the upper blank and the cap bushing (the smallest in the set) narrow end in first. Use additional bushings to fill the space on the shaft up to the threads.
- Thread on the lock nut and hand tighten to hold all items in place.
- Slide the tail stock snug to the mandrel shaft (do not over tighten, it could damage the mandrel). Lock in place.
- Turn the wood down, flush with the bushings using the lathe tools and gradual higher grits of sandpaper.
- Finish the wood with friction polish or use PSI clear hi-gloss project finish #HGPF off the lathe for a brilliant finish.

Diagram C - Pen Assembly



NOTE

- Line up finished parts according to diagram 'C'.
- To press parts in, use a pen press or a vice with covered jaws. Press parts slowly to avoid scratching and damaging the gold plating.

PEN ASSEMBLY

- Press parts together slowly to avoid scratching or damaging the gold plating.
- Press the tip into the narrow end of the lower barrel.
- Insert the coupler band, larger diameter hole first, onto the coupler over the recessed end of the brass part.
- Press this assembly, recessed end in first, into the opposite end of the barrel. Press to the stop (or to the shoulder) or until the band is secured in place and is not loose.
- Select 2 of 3 mini refills provided in the kit. Insert both into the nesting tubes of the pen mechanism until they stop. The refills will be 1-9/16" extended outside the tube (diagram C).
- Insert the mechanism with refills into the lower barrel. Push until they stop.
- Insert the recessed end of the threaded cap nut into the upper tube. Press in to be flush with the tube end.
- Insert the cap into the clip hole. Thread this assembly into the cap nut tightly.
- Slide the smooth end of the sleeve mechanism over the end of the exposed pen mechanism. Push in until it bottoms.
- Engage both ends of the pen together tightly. The pen is now complete.
- To extend the refill turn the upper barrel either clockwise or counter clockwise. Turn to a neutral position when the pen is not in use.

Diagram D -#PK2WAYBU

