

Fly Fishing Twist Pen Kit

Kit Features:

- Attractive fly fishing theme
- Easy to turn with a straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Uses Parker® style refill
- Overall Length: 5-1/4"

Required Accessories:

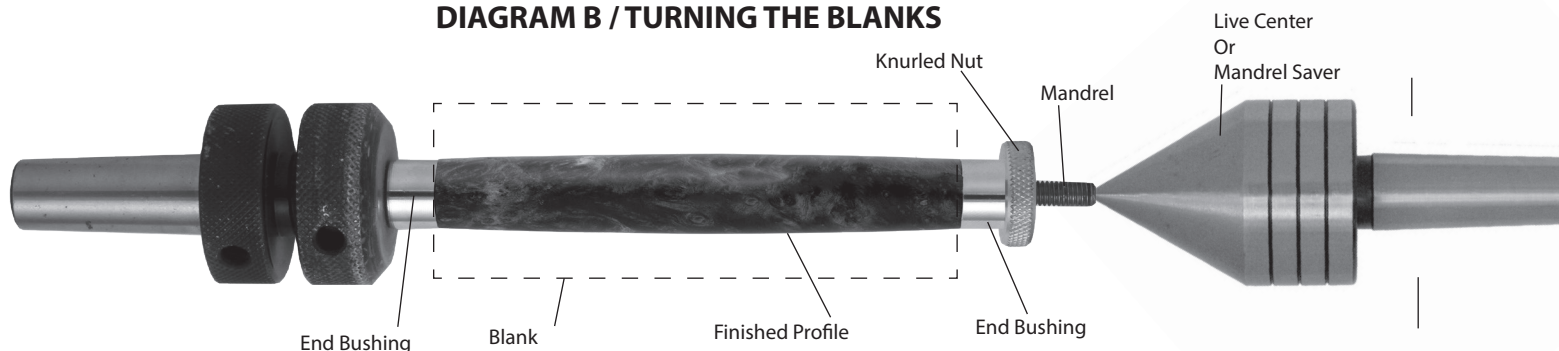
- 7mm Pen Mandrel
- Drill Bit: 3/8" #PKEXEC-38 for Plastic #PK-38B for Wood
- Bushing set(3) Use 2 of 3 in set: #PKPPENBU
- Barrel Trimming set: #PKTRIM38
- Live Tailstock Center
- 2 Part Epoxy Glue or CA (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/4"



Preparing the Blank:

- Cut 1 blank to the length of the tube and plus 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 blanks. 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 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 the polish manufacturers instructions.

Diagram C / Bushings #PKPPENBU (USE 2 END BUSHINGS ONLY)

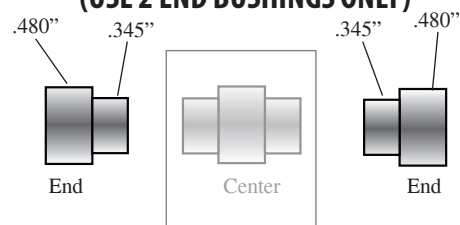
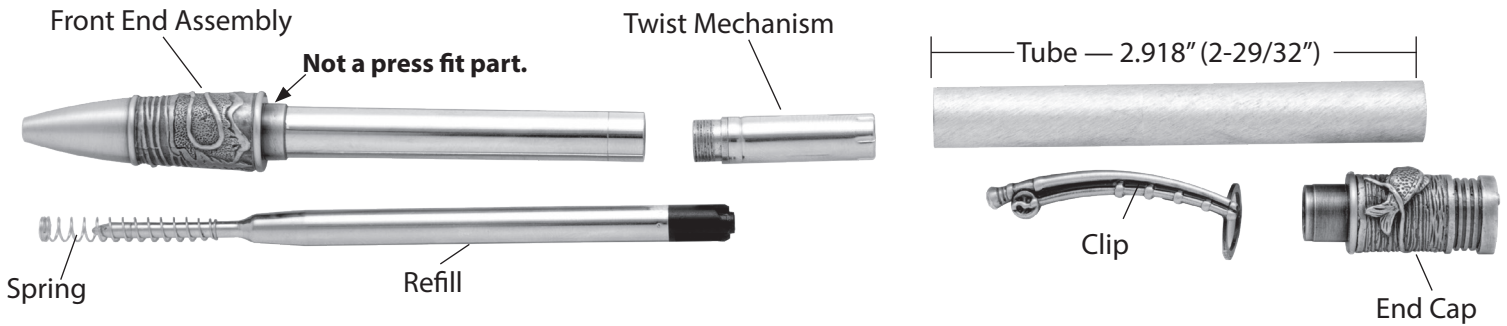


DIAGRAM D / PARTS LAYOUT



Assembly

- Layout parts according to Diagram D. Notice that Front End Assembly is not a press fit part.
- Affix the Spring over the Refill shaft
- Insert the Refill into the opening at the back of Front End Assembly
- Thread the Mechanism over the refill into the back of the Front End Assembly
- Affix the Clip over the extension on the End Cap and line up the rod tip with the fishing line on the end
- **Tip: to prevent crushing the raised elements on the top of the cap, make a small jig with a channel 1/8 inch wide x 1/6" deep that can fit over the 3 raised points. See Diagram E**
- Press this Cap Assembly into either end of the barrel.
- Push the Front End Assembly into the open end of the Barrel by hand (do not use Press!). Continue pushing until the tip seats flush against the Barrel.
- The pen operates by twisting the tip to advance or retract the Refill.
- To replace the refill, unthread the Front End Assembly. Remember to switch Spring to new Refill.
- **IMPORTANT: When replacing Front End, do not push in. Simply insert until it hits the mechanism and then thread onto mechanism. Pushing on mechanism may make it slide so further in to the point that the Assembly cannot reach it.**

Diagram E / Pressing Jig

