



Classical Slimline Assembly Instructions

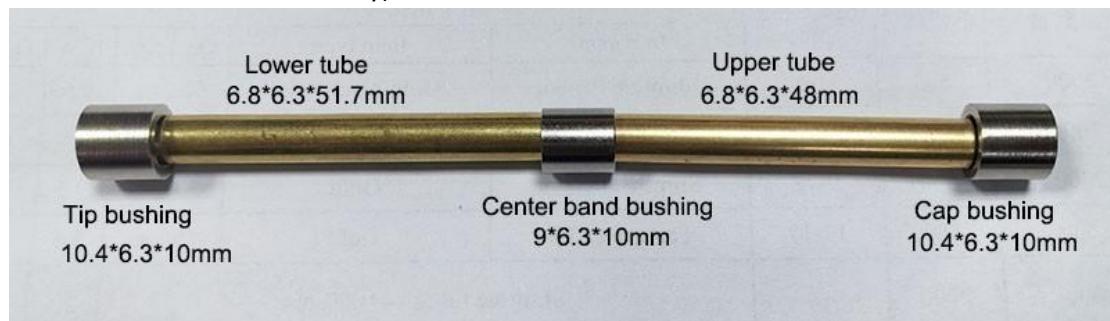
Required Accessories:

- 7mm Pen Mandrel
- 7 mm Drill Bit DB007
- Bushing BU791



Preparing the Blank

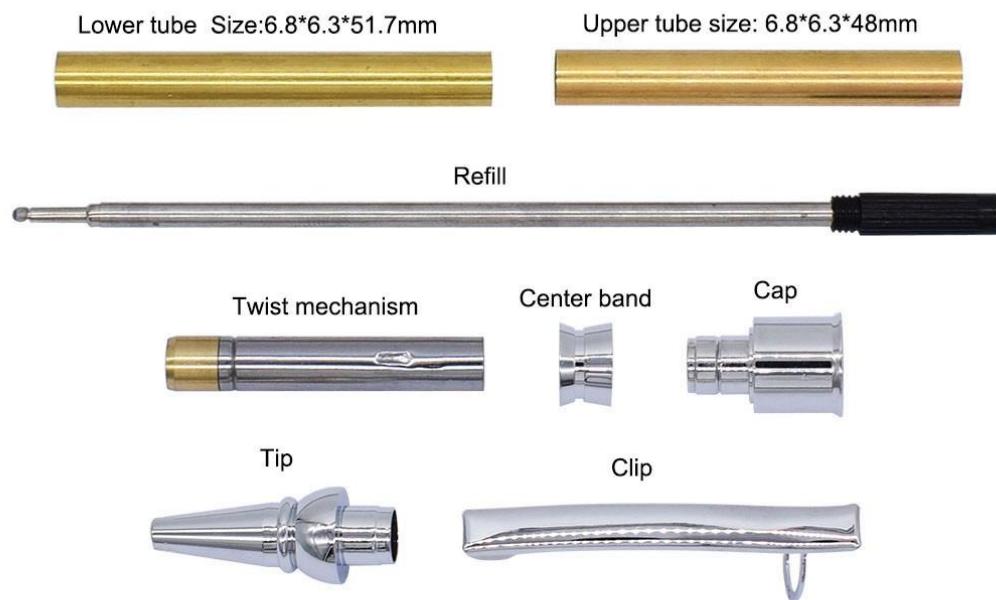
- Cut 2 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 7mm hole lengthwise through each blank.
- Spread glue over the tube; insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square 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 blanks according to 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, refer to polish instructions.



Pen Assembly

NOTE: Layout Finished parts according to Diagram above.

- Press the tip into either end of lower tube.
- Press the twist mechanism into opposite end of the lower tube. Don't press too far in.
- Slide the center band over the exposed mechanism.
- Screw the refill to the twist mechanism.
- Cross the clip to the cap and press the cap into either end of the upper tube.
- Push the two halves together aligning grain as desired. Pen is operated by twisting the halves in opposite directions to extend or retract point. Test the extension with the refill inserted. Uses Cross type refills.