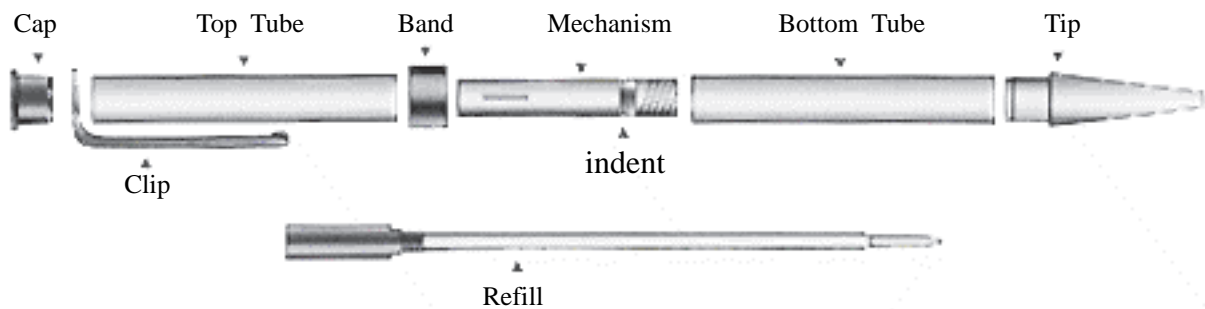




Pen Instructions



Parts Requirement

- Pen Mandrel PM-2
- 3 pce bush set PB-3 (as supplies with PM-2)
- 7mm Drill Bit SD070
- Pen Mill AR100
- Glue Insta Cure or 2 part epoxy
- Sandpaper
- Hut Wax PPPB & PPPW

Preparation

- 1 Cut 2 wood blanks 13mm square x length of the tubes
- 2 Drill a 7mm hole lengthwise in the top & bottom tubes .Use a slow feed rate & back out regular for chip removal
- 3 Glue the tubes to the wood blanks. Insert with a twisting action for even glue coverage.Allow to dry
- 4 Trim the ends with the pen mill

Turning

- 1 Position the 3 pce bush set on the mandrel.as shown below Use the adjustable stop or spacers if required
- 2 Turn wooden blanks to top diameter of bushing.
- 3 Sand to desired finish, finish with HUT PPP range.

Assembly

Use a vise or clamp to press parts together

- 1 Press the tip into the bottom tube
- 2 Press the mechanism into the other end of the of the bottom tube (usually to the indent) do not press to far
- 3 Slide band over the mechanism
- 4 Screw refill into mechanism
- 5 Press cap & clip into top tube (we recommend that you assemble cap &clip before pushing into tube)
- 6 Slide top tube over mechanism & test pen by twisting tubes in oposite direction.
- 7 If pen refill does not fully retract,the mechanism will have to be adjusted with a pen disassembler.

