



## Ivy Twist Pen Kit Instructions

### Required Materials

- 7mm pen mandrel
- Set of Ivy Twist Pen Kit bushings
- 7mm and 8mm drill bits
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
- Sanding supplies and finish



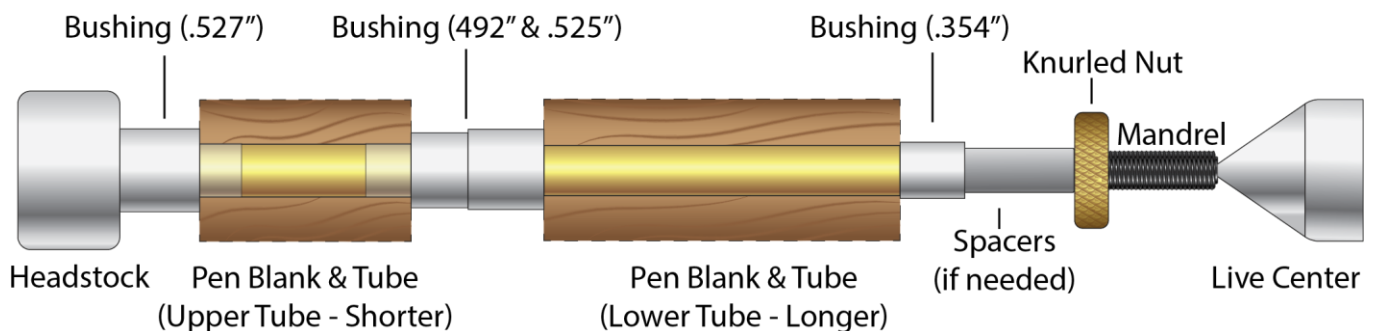
### Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 7mm hole lengthwise through the long blank, and an 8mm hole lengthwise through the short blank
3. Rub the brass tubes with low-grit sandpaper to roughen them
4. Apply a line of glue to the brass tubes and insert tubes into the middle of the blanks with a twisting motion to spread the glue throughout the blanks
  - Ensure the inside of each tube is free of any glue
5. Square off the ends of each blank with a barrel trimmer or sander to be flush with the brass tubes

### Turning the Blank

Follow diagram A below to set up the blanks on the mandrel for turning

Diagram A

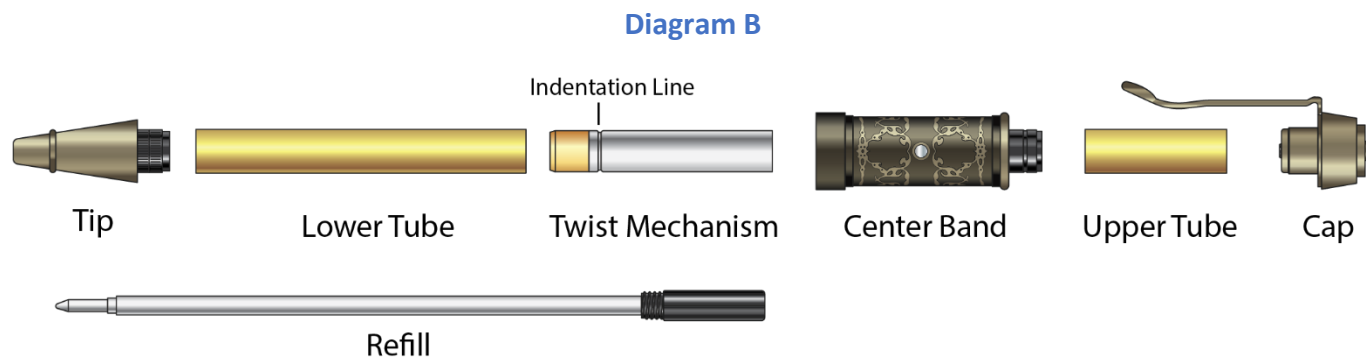


1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish



## Assembly

Follow diagram B below for assembly. Press parts using a pen press, vise, or clamp.



1. Press the Tip onto the narrower end (.354") of the Lower Tube/blank (longer tube)
2. Press the brass end of the Twist Mechanism onto the opposite end of the Lower Tube up to the Indentation Line
3. Insert refill into Twist Mechanism (thread into place) and test for extension
  - a. Press Twist Mechanism in further as needed (with Refill removed)
4. Press the narrower end (.492") of the Upper Tube/blank (shorter tube) onto the Center Band
5. Press the Cap onto the opposite end of the Upper Tube
6. Press together the two assembled halves until snug

## Additional Information

- Pen uses a Cross™-style refill
  - To replace refill, pull the two assembled halves apart by hand (reverse of assembly step 7)