



Jr Edward Pen Kit Instructions

Required Materials

- 7mm pen mandrel
- Set of Jr Edward Pen Kit bushings
- 10.5mm and 12.5mm drill bits
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank (2 may be necessary depending on length of blanks)
- Pen press, vise, or clamp
- Sanding supplies and finish



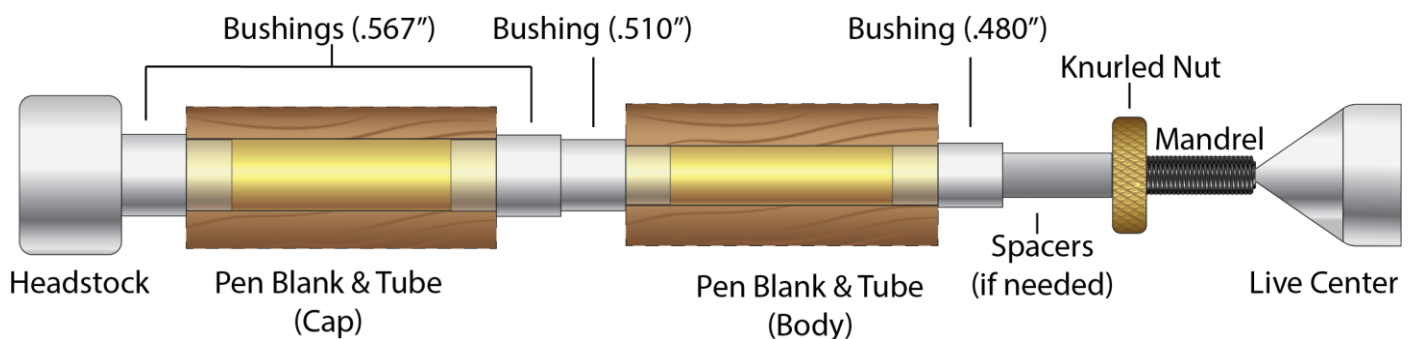
Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 10.5mm hole lengthwise through one blank and a 12.5mm hole lengthwise through the other 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 each tube into the middle of the respective blank with a twisting motion to spread the glue throughout the blank
 - Ensure the inside of the tubes are 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



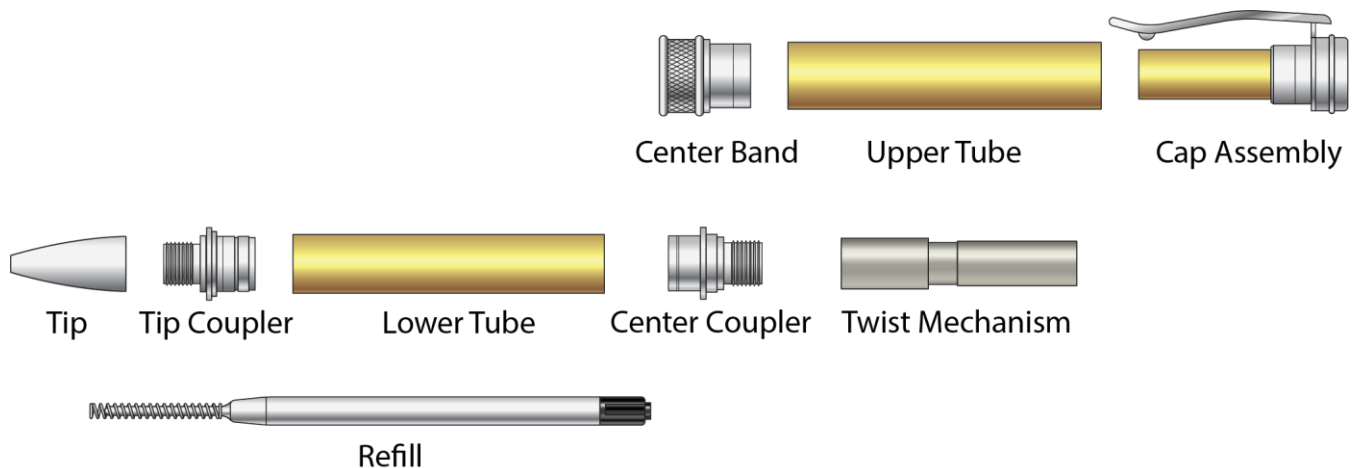
1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish



Assembly

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

Diagram B



1. Unthread the Twist Mechanism from the Center Coupler
2. Press the Center Coupler onto the thicker (.510") end of the Lower Tube (smaller diameter tube)
3. Unthread the Tip from the Tip Coupler
4. Press the Tip Coupler onto the thinner (.480") end of the Lower Tube
5. Thread the Twist Mechanism back onto the Center Coupler
6. Place the spring over the Refill and insert through the Tip Coupler
7. Thread the Tip back onto the Tip Coupler
8. Press the Cap Assembly with clip onto one end of the Upper Tube (larger diameter tube)
9. Press the Center Band onto the opposite end of the Upper Tube
10. Press the Upper Tube assembly over the exposed Twist Mechanism until snug
 - a. The small tube of the Cap Assembly will fit firmly over the Twist Mechanism

Additional Information

- Pen uses a Parker style refill
 - To replace refill, unthread the Tip