



## Officer Twist Pen Kit Instructions

### Required Materials

- 7mm pen mandrel
- Set of Officer Twist Pen Kit bushings
- 3/8" drill bit
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
- Sanding supplies and finish



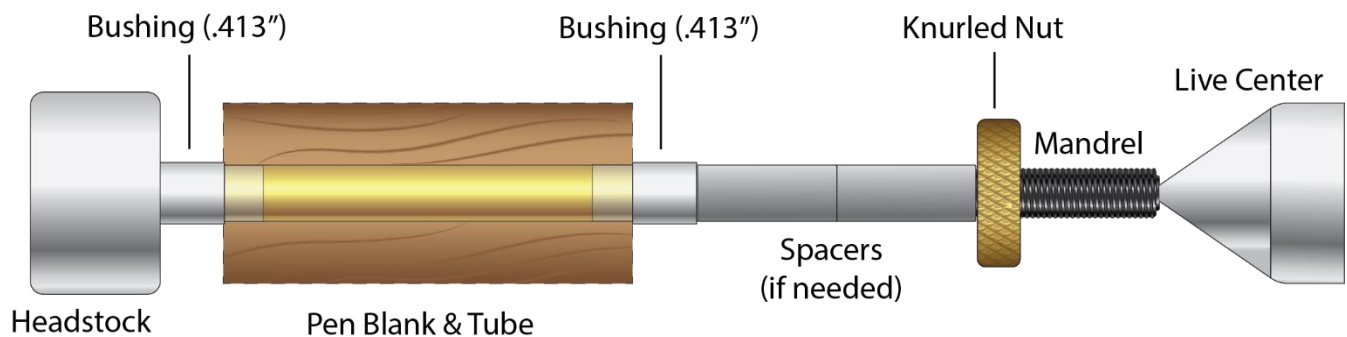
### Blank Preparation

1. Cut blank to length of brass tube, plus an additional 1/16" on each end for squaring off
2. Drill 3/8" hole lengthwise through blank
3. Rub the brass tube with low-grit sandpaper to roughen it
4. Apply a line of glue to the brass tube and insert tube into the middle of the blank with a twisting motion to spread the glue throughout the blank
  - Ensure the inside of the 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 tube

### Turning the Blank

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

Diagram A



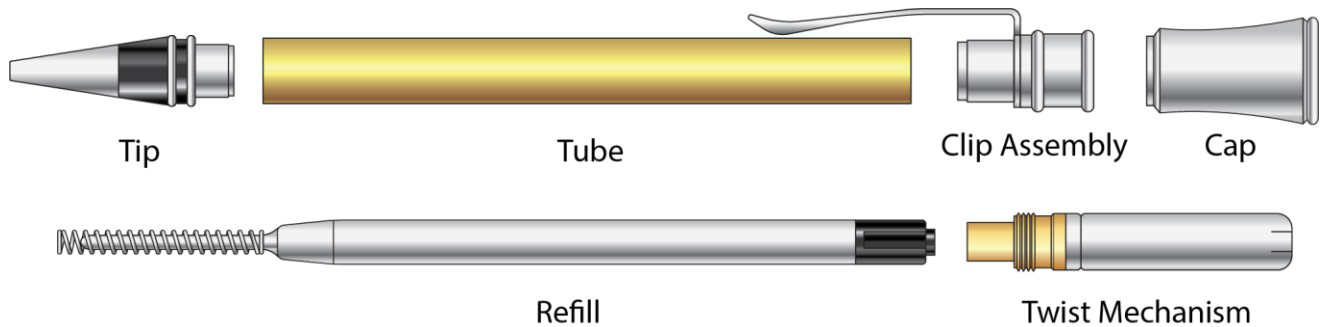
1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish



## Assembly

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

Diagram B



1. Press the Clip Assembly onto the Tube
2. Press the Tip onto the opposite end of the Tube
3. Place spring over the Refill and insert through the Clip Assembly opening
4. Thread the brass end of the Twist Mechanism into the Clip Assembly
5. Push the Cap onto the Twist Mechanism by hand

## Additional Information

- Pen uses a Parker-style ballpoint refill
  - To replace refill, pull off the Cap and unthread the Twist Mechanism