



Panache Pen Kit Instructions

Required Materials

- 7mm pen mandrel
- Set of Panache Pen Kit bushings
- 13/32" and 12.5mm drill bits
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
- Sanding supplies and finish



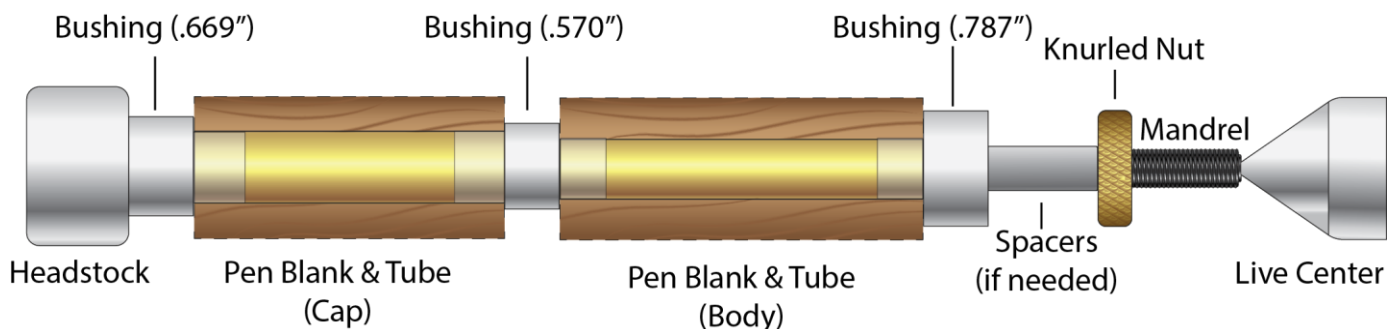
Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 13/32" hole through longer blank and 12.5mm hole through shorter 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 blanks with a twisting motion to spread the glue throughout the blanks
 - 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

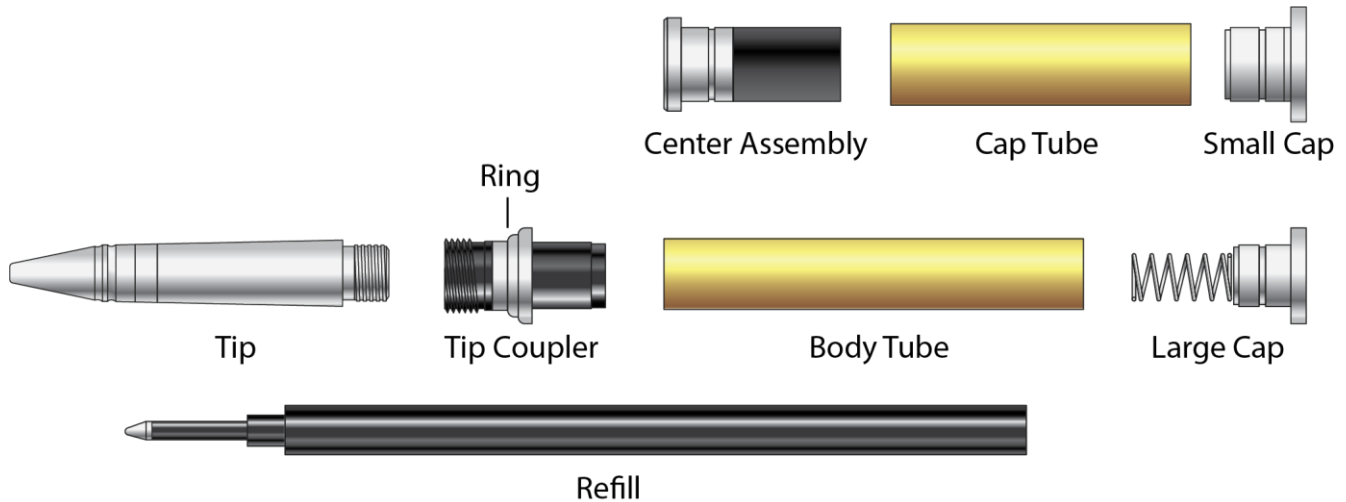
Follow diagram B below for assembly. Press parts using a pen press, vise, or clamp.

Diagram B



1. Unthread the Center Assembly, Tip Coupler, and Tip from each other as shown in diagram B

Diagram C



2. Press the Small Cap onto the thicker end (.669") of the blank/Cap Tube (shorter tube)
3. Press the Center Assembly onto the opposite end of the Cap Tube
4. Press the Large Cap with spring onto the thicker end (.787") of the blank/Body Tube (longer tube)
5. Press the Tip Coupler with Ring onto the opposite end of the Body Tube
6. Insert the Refill through the Tip Coupler and thread on the Tip

Additional Information

- Pen uses a standard rollerball refill (such as the Schmidt 888)
 - To replace refill, unthread the Tip