

Big Wig Twist Ballpoint Pen Kit

Product : #164111, #164112, #164113, #164114

8/8/2018



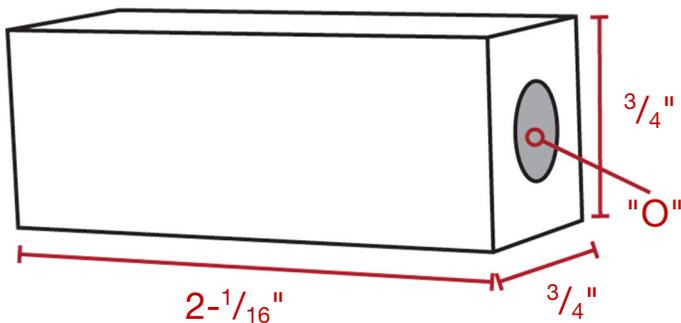
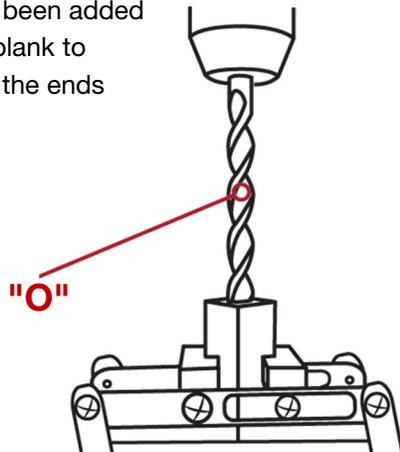
From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- Letter "O" Pen Maker's Bit
- 3/4" x 3/4" x 2-1/16" Pen Blank
- Pen Mandrel
- Big Wig Pen Kit Bushings (164115)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- Pen Reamer "O" (153204)
- Pen Press
- Eye & Ear Protection
- Dust Mask

Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.

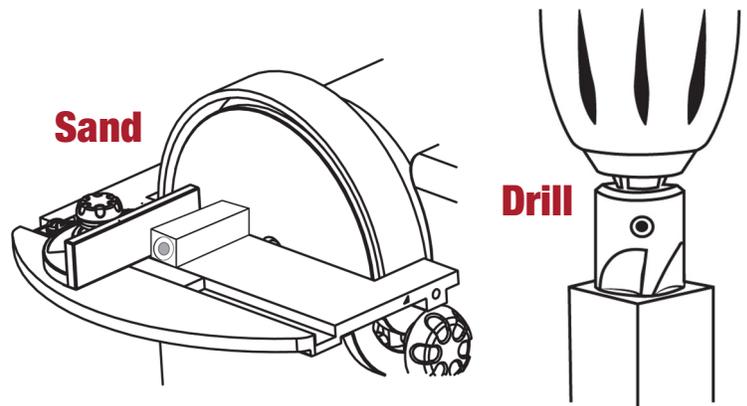


Gluing Blanks to Tubes:

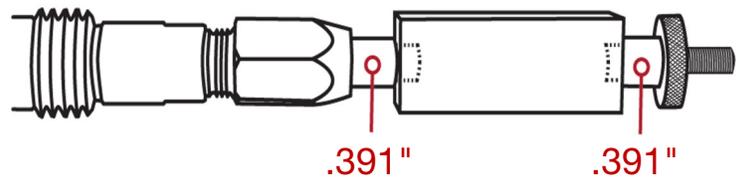
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.

Squaring the Blank to Length:

When squaring the blanks work only to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.



Mandrel Preparation:



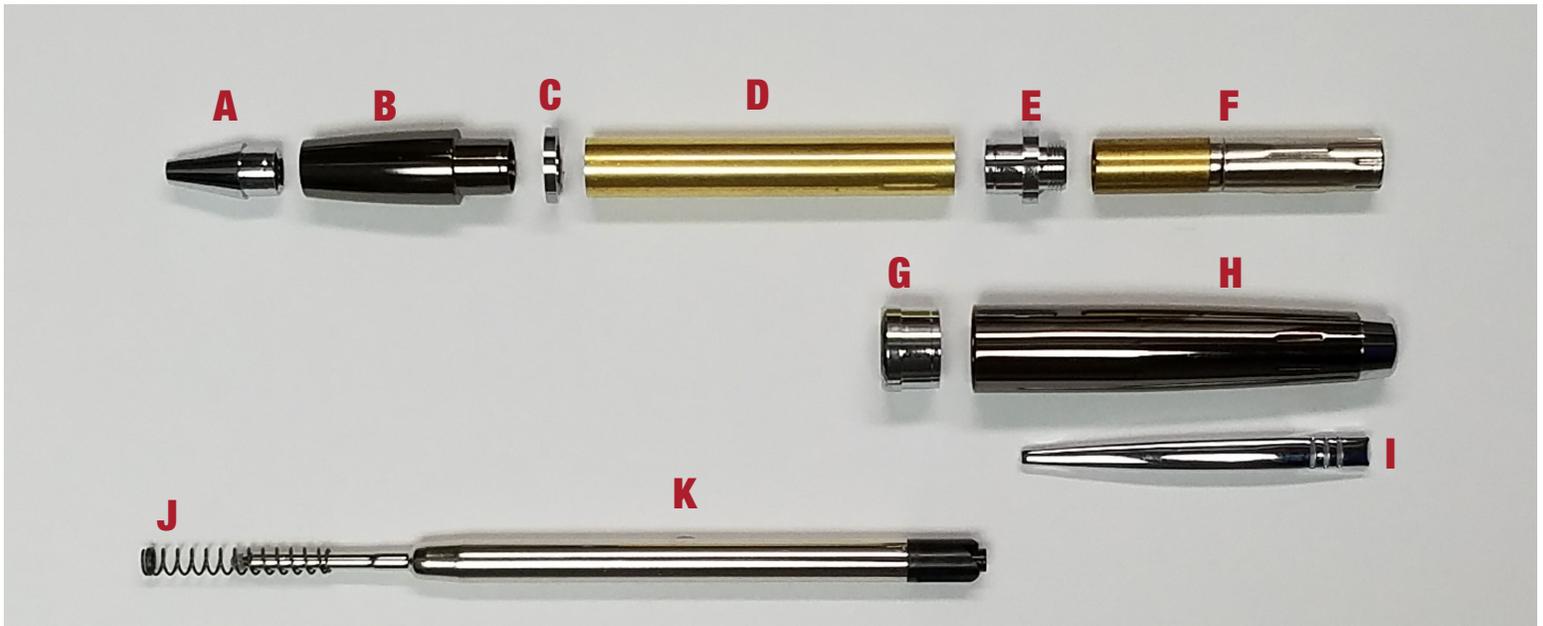
Turning & Finishing the Blanks:

Turn the blank to your desired profile, leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120-grit paper, progress through the finer grits, finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

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**Assembly:**

- ❑ Press Nib (A) into Nib Adapter (B). Slide Nib Accent Ring (C) onto the post of Nib Assembly (A, B) and press into one of the ends of the Finished Barrel (D). Next press the Twist Mechanism Adapter (E) non threaded end into the open end of the Finished Barrel (D).
- ❑ Slide Spring (J) small end first over end of Ink Refill (K) and insert into open end of Twist Mechanism Adapter (E). Thread Twist Mechanism (F) onto the end of the Twist Mechanism Adapter (E) and test action. Clockwise to extend, Counter clockwise to retract.
- ❑ Press Center Band (G) into the open end of Cap (H). Next, press Clip (I) onto Cap (H). This will simply click into place with simple thumb pressure. Insert tabs of the clip into the slots on the cap and press downward.
- ❑ Finish the assembly by pressing Cap Assembly (G, H, I) by hand over Twist Mechanism (F) until it seats firmly against the shoulder of the Twist Mechanism Adapter (E).