

## 7mm Slim Style Hybrid Pen Kit



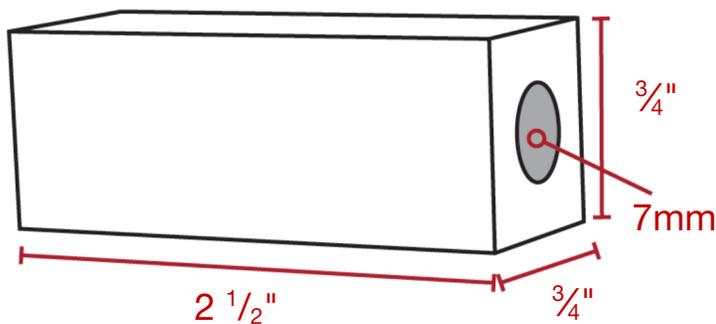
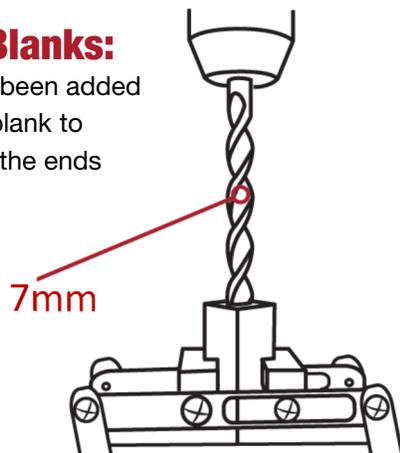
### From Setup To Sanding:

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

- 7mm Pen Maker's Bit
- 3/4" x 3/4" x 2 1/2" Pen Blank
- Pen Mandrel
- Slim Style Pen Kit Bushings (06R03)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- Pen Mill Pilot Shaft 7mm (153193 or 165707)
- 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.



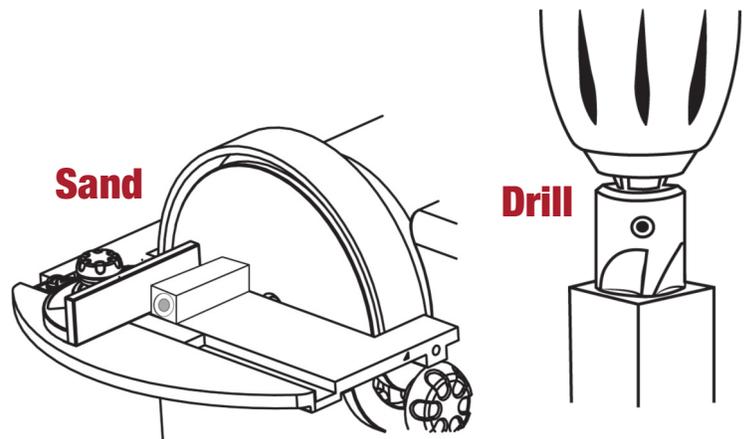
Product : #166184, #166185, #166186, #166187, 5/15/2019  
 #166188, #166189, #166190, #166191,  
 #166192, #166193, #166194, #166195

### Gluing Blanks to Tubes:

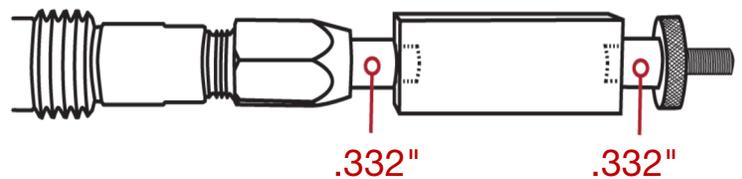
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive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

### Squaring the Blank to Length:

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



### Mandrel Preparation:

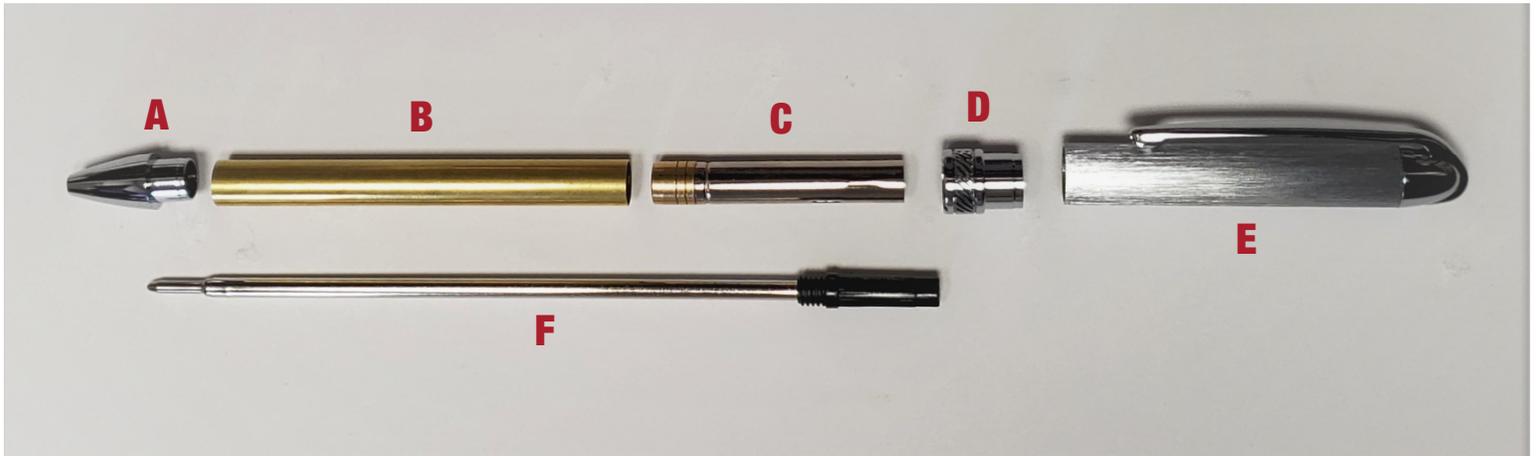


### Turning & Finishing the Blanks:

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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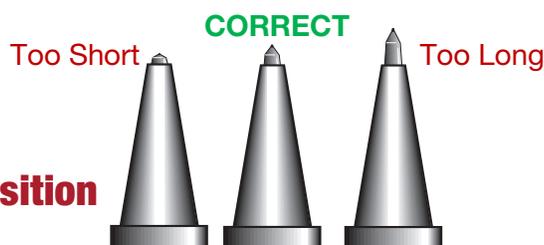


### Assembly:

- Press Nib (A) into one end of Finished Blank (B).
- Next press Twist Mechanism (C) brass end first just to the second ring into other end of Finished Blank (B). While pressing the Twist Mechanism (C) into place, test the position by extending the ink refill's tip and noting its position in respect to the end of nib. **Note: Refer to below graphic.**
- To test the extension/retraction of the ink refill's tip, install Ink Refill (F) and rotate the twist mechanism and note the position of the refill's tip in the extended/retracted position. This is a trial and error process so take your time as this may require several attempts of pressing the twist mechanism (without ink refill installed) further in to achieve the correct position.
- Once you are satisfied with the position, thread Ink Refill (F) into Twist Mechanism (C). Set this portion of the kit aside.

- Next press Center Band (D) into open end of Upper Clip Assembly (E).
- Finish the assembly by sliding Cap Assembly (D, E) over Twist Mechanism (C) joining the two sections, pressing together by hand.

To advance the ink refill turn the Upper Clip Assembly clockwise, to retract the ink refill turn the Upper Clip Assembly counter clockwise.



### Fully Twisted Position