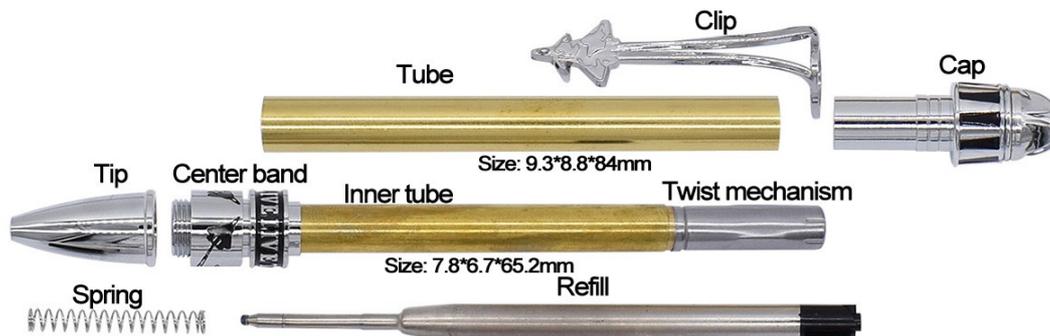


- Hand tighten the quill adjustment to firm up the mandrel. (Do not over tighten, it could damage the mandrel.)
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.

DIAGRAM B



Pen Assembly:

- Line up finished parts according to the diagram above.
- Screw the tip into the tip coupler in advance.
- Insert the refill with the spring into the inner tube.
- Screw the twist mechanism into the end of the inner tube until it stops.
- Press the clip and cap assembly into the tube.
- Push the clip and cap assembly with tube onto tip coupler by hand.
- Pen operates by twisting the cap to extend or retract the refill.