

## ISTRUZIONI KIT PENNA "WRENCH" - ENG



**Before starting any work, check the completeness of the kit and press the kit loosely together for checking purposes.**

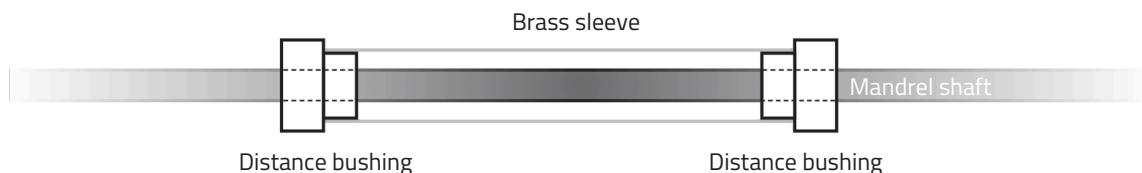
Refill type	Refill with tungsten carbide ball, oil based ink.
Drill-Ø	9.52 mm
Distance bushing	No. U721290M
Replacement sleeves	No. U721304M
Shaft diameter of mandrel	6.2 mm

### Preparation of the pen blanks

We recommend a pen blank with a diameter of at least 15 mm; the length should be at least 76 mm (2 mm added to the length of each brass sleeve). Now drill a hole with  $\varnothing$  9.52 mm in the centre of the pen blank. We recommend using a special pen blank drill (No. 707848). Before bonding, the brass sleeve must be polished with steel wool or a fine abrasive fleece. This removes any oil/grease residues or separating agents which may be present on the sleeves depending on the production process.

Now bond the brass sleeve to the pen blank with a superglue or an epoxy adhesive of moderate viscosity (e.g. Titebond No. 450375) using a sleeve insertion tool (No. 731020). Make sure that there is no glue on the internal surfaces of the brass sleeve. The pen blanks should protrude minimally (approximately 1 mm) at the front and rear, as the front end will now be planed or milled at right angles to the level of the brass sleeves.

Once the adhesive has hardened, the pen blank can be clamped onto the mandrel (e.g. No. 731510). This requires distance bushings No. U721290M. Arrange the bushings as follows:



Turn the pen blank. The surface sealant can be applied in the next step in whatever form you want (e.g. oil or wax).

### Assembly

Release the finished pen blank and assemble the pen loosely together. The quickest and easiest way to press the pen together is by using a pen press. Pressing directly with the tailstock of the lathe and wooden inserts is also possible, or by gently tapping it together with support pieces.

First, the tip is pressed into the pen blank. Then press in the cap and clip. Now unscrew the tip and insert the refill and the click mechanism.