

ST. CHARLES PET KIT INSTRUCTIONS

KIT FEATURES

- Heavy Plating W/ Epoxy Coating
- Easy To Turn & Assemble
- Overall Length: 5-3/8"

Blank Preparation

1. Cut your blanks from 5/8" stock, cut the blanks at least 3/8" longer than the tube to accommodate drilling and squaring the blank.
2. Drill a 7mm hole lengthwise through the center of each blank. To prevent breaking the blank, do not drill through the bottom of the blank. Only drill as deep as necessary to accommodate the tube and then cut off the excess on your band saw.
3. Sand the tube to create a rough surface for the glue to adhere to. Using Epoxy, CA or Gorilla Glue; spread the glue on the tube and insert the tube into the blank with a twisting motion to smooth out the glue into all areas. Center the tube in the blank and allow it to dry.
4. Using a 7mm barrel trimmer, or other sanding device, trim the ends of the blank flush to the ends of the tubes. **DO NOT SAND INTO THE BRASS**, this will make your blanks too short and will result in kit failure.

Turning Sanding and Finishing the Blanks

1. Place the bushings and blanks on the mandrel, the smallest diameter bushing is for the tip, the largest diameter bushing is for the centerband and the medium diameter bushing is for the cap/clip assembly.
2. Turn the blanks down to about the thickness of a fingernail above the bushings.
3. Sand the blanks starting with the coarse grit and move up to the desired smoothness. We recommend using Micromesh and sanding to 12000 grit.
4. Be sure the blanks are smooth to the bushings for a good fit of the parts.
5. Apply your finish choice

REQUIRED ACCESSORIES

- 7mm mandrel
- 3 Piece Bushing Set STCBU
- 7mm Drill Bit
- 7mm Barrel Trimmer
- Your Choice of Adhesive

Assembly



1. Line up the parts as seen in the picture above.
2. Press the Tip into the lower Tube.
3. Press the Twist Mechanism into the opposite end of the lower tube as far as the embossed line on the mechanism.
4. Screw in the refill and check for proper operation in and out. If the refill does not come out far enough then remove the refill and press the mechanism in further. Repeat this as necessary until you have a proper fit. If the refill comes out too far and will not retract completely then you have either pushed the mechanism in too far or you sanded off too much brass back in the Blank Preparation step.
5. Slide the centerband on over the twist mechanism. Note: this may be a very tight fit but it will slide on.
6. Press the clip/cap assembly into the top of the rear tube.
7. Slide the rear tube onto the twist mechanism and twist the pen to operate.
8. Make a few scratches of the new ball point on some scratch paper to get the ink flowing.
9. Your pen is now ready for operation.
10. Coat all parts metal and wood with Renaissance Wax to keep it looking great.

For questions concerning this kit call Wood-N-Whimsies at 1-800-820-1099 or email us at woodnwhimsies@woodnwhimsies.com