

BEE PEN KIT

Instructions

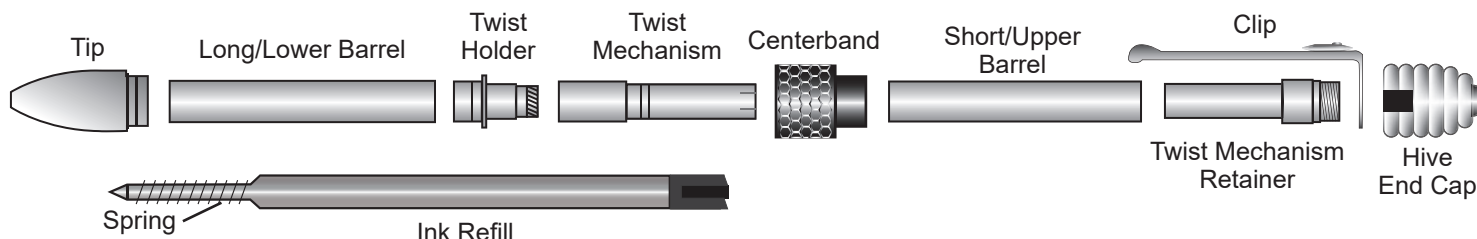
Kit Features

- Double-Twist Mechanism
- Uses smooth-writing Parker™ style refill (RE-PARK)
- Perfect for the Apiarist or Honey farmer.

Required Accessories & Materials

- 7mm mandrel
- 3-pc. Bee bushing set (PKBEE-BU)
- 10mm drill bit (DB10MM or DB10MMCT)
- Universal trimming kit (BTRIMKIT8)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Pen Parts and Assembly



BLANK PREPARATION

The tubes in a Bee pen kit are of different lengths. Make sure that as you cut the blanks for the tubes you orient them so that the longer 2-1/16" tube will be used as the lower pen barrel. The upper tube is a little shorter at 1-7/8" long. **Cut** your blanks approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. If using wood blanks, mark the blanks so it is easier to keep the grain running in the same direction when you place them on the mandrel for turning. Use a medium drill speed to **drill** the blanks. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blanks, **sand** the exterior of the brass tubes to roughen their surface and use CA **glue** to glue the tubes inside the blanks. Sand or barrel trim to **square** the ends of the blanks.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. In setting up your bushings, you will use the smallest of the three bushings (bushing 1) at the tip of the pen. The lower barrel goes on the mandrel followed next by the large combined bushing (bushing 2). Orient the middle bushing so the smaller end is toward the pen tip. Slide on the upper barrel, and then the last of the three bushings (bushing 3) will go at the top end of the pen. Keep in mind which pen barrel you are turning as the top and bottom. Remember, the upper tube is shorter than the lower tube. If you mistakenly get the short tube at the bottom of the pen, the refill will not retract properly. **Turn** the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

ASSEMBLY

(Line up finished parts according to Diagram A)

To avoid damage to components when assembling, use a pen press or a vise with covered jaws.

1. Assemble the clip assembly by screwing the twist mechanism retainer through the clip into the Hive End Cap.
2. Press the clip/cap assembly into one end of the upper barrel.
3. Press Centerband into opposite side of the upper barrel.
4. Press tip into one side of lower barrel.
5. Press twist holder into the opposite side of the lower barrel.
6. Drop the ink refill with the refill spring through the twist holder and screw on the twist mechanism.
7. Insert the twist mechanism on the lower barrel assembly through the centerband into the upper barrel.
8. The pen should be ready for use.

Diagram B - Pen Bushings

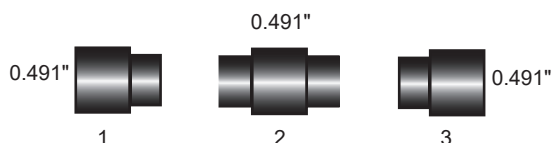


Diagram C - Turning the Pen

