



Fig. 1

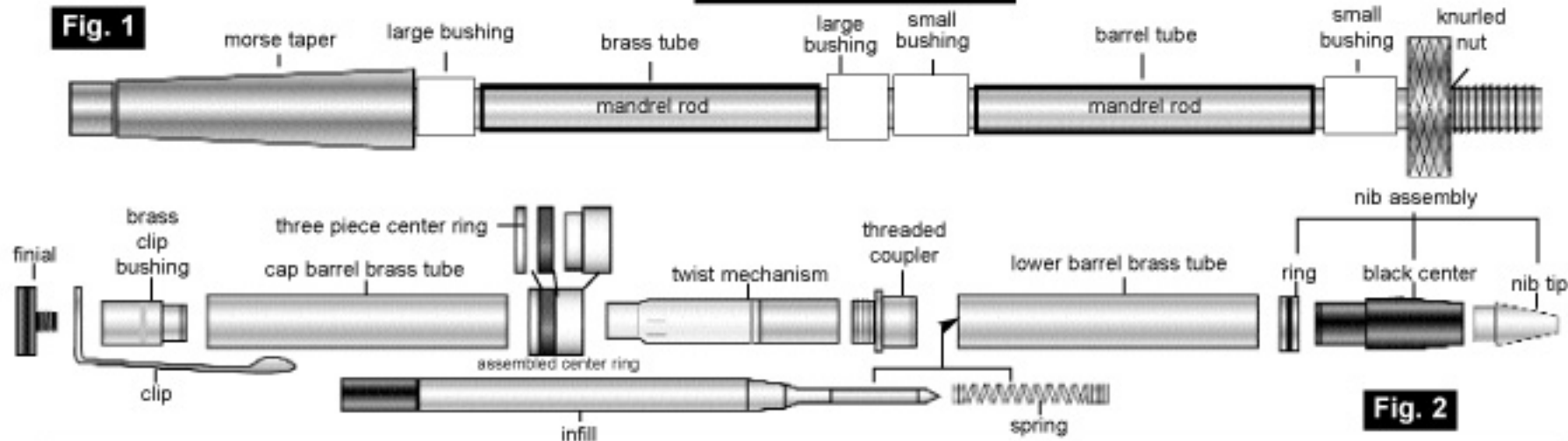


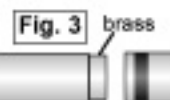
Fig. 2

Materials: Preparation: Turning: Assembly:

- 1) Ameroclassic Double Twist kit
- 2) Pen blank, minimum size: 5/8 x 5/8 x 5"
- 3) 21/64" drill bit 174
- 4) Maxi-cure Extra-thick CA 184, epoxy 189, or polyurethane 196
- 5) 5/8" barrel facing tool 331 with pilot 334
- 6) Ameroclassic mandrel and bushing set 326
- 7) Sanding rolls, 4 pk. 1120
- 8) HUT PPP combo 109

- 1) Mark blank using tubes as guides. Cut blank in two pieces, each approximately 1/8" longer than its respective tube.
- 2) Drill blanks with a 21/64" drill bit.
- 3) Glue tubes into blanks.
- 4) When glue is cured, square ends with barrel facing tool. Do not remove any brass. This pen will not function properly if tube lengths are altered.

- 1) Turn on an Ameroclassic mandrel with bushing set 326. Arrange bushings and tubes as shown. (Fig. 1)
- 2) Turn wood down to bushings. Barrels should have straight, Ameroclassic profile. Cap must measure between 45.5mm (1.79") and 46mm (1.81").
- 3) Using a parting tool, remove 3/16 of material down to brass tube on the center ring end of cap. (Fig. 3) Make sure all glue is off brass.
- 4) Sand and finish with HUT PPP combo.



- 1) Assemble three-piece center ring. Press center ring over exposed portion (Fig. 3) of brass tube on cap barrel, flat end first.
- 2) Using a small piece of rolled-up sand paper, remove rough edges from inside of brass tube under center ring. Check clearance with brass portion of twist mechanism.
- 3) Press brass clip bushing, stud end first, into clip end of cap barrel until flush with wood.
- 4) Clip assembly: Insert finial through hole in clip and screw into brass clip bushing. To avoid possible clip rotation, place a small drop of glue between pen cap and clip.
- 5) Push nib tip into black center. Slide ring onto black center. Push into one end of lower barrel tube. Temporarily screw threaded coupler onto twist mechanism. This will protect delicate threads. Press non-threaded end of threaded coupler into open end of lower barrel, then remove twist mechanism. Place spring on infill and insert in lower barrel.
- 6) Screw twist mechanism snugly onto the twist holder. Test the rotation of twist mechanism, leaving tip in retracted position. Insert twist mechanism through center ring of cap assembly. Line up wood grain and press cap and lower barrel together.
- 7) To use: Hold lower barrel and turn the cap clockwise to expose and lock infill. Turn counter-clockwise to retract infill. Continue turning counter-clockwise to expose infill again and unscrew cap to replace infill. Re-attach cap



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