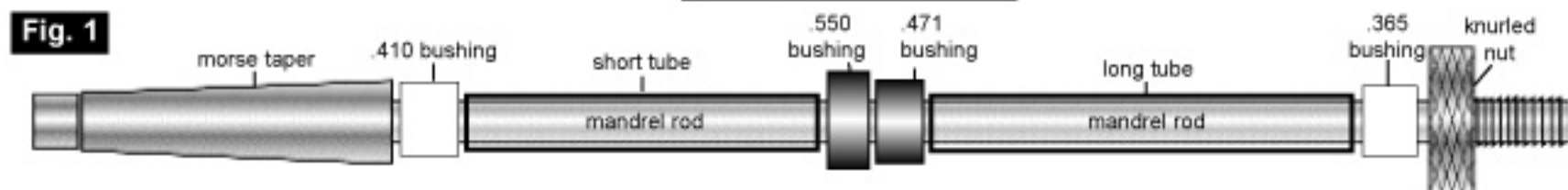
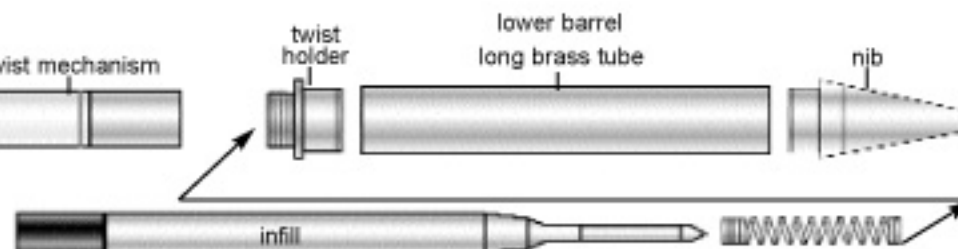


**Fig. 1****Fig. 2****Materials:**

- 1) Eurostyle Twist pen kit **540, 541, 550**
- 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) Amero-classic mandrel with bushing set **340**, which consists of 4 bushings. Arrange bushings and tubes as shown. (Fig. 1)
- 7) Sanding rolls, 4 pk **1120**
- 8) HUT PPP combo **109**

**Preparation:**

- 1) Mark blank using tubes as guides. Cut the 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.
- 5) Turn on an Amero-classic mandrel with bushing set **340**, which consists of 4 bushings. Arrange bushings and tubes as shown. (Fig. 1)

**Turning:**

- 1) Turn wood down to slightly above the sizes indicated by the 2-stage center bushing.
- 2) Using your favorite lathe tool, gently curve the outside of the blank to meet the smaller outside bushing.
- 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.

**Assembly 1:****Lower barrel assembly:**

- 1) Press nib into small end of lower barrel.
- 2) Thread twist mechanism onto twist holder. This will protect the tender threads of the twist holder from being crushed during assembly.
- 3) Press twist holder into open end of long tube, mechanism end out.
- 4) Place spring onto small end of infill, unscrew twist mechanism from twist holder, insert infill, and screw twist mechanism back on snugly.

**Assembly 2:****Cap assembly:**

- 1) Press center ring over exposed portion (Fig. 3) of short 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) Clip assembly: place finial ring on finial (note: outer edge of ring is tapered to match the finial's curve. Place clip on finial.
- 4) Press clip assembly into small end of cap barrel.
- 5) Rotate twist mechanism until pen tip retracts. Slide mechanism into finished cap rotating for best wood grain line up. Press together until gold band on twist holder seats completely into center ring.



Correct Eurostyle curvature (not to scale)

7-30-04