

THE MONÉT PEN KIT INSTRUCTION SHEET

This is a very elegant pen that is easy to turn, requires no tenons and is a snap to assemble.

KIT FEATURES

- Smooth twist mechanism
- Parker™ style refills - PARK-R5
- Overall length: 5-1/4"

REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 2-pc bushing set MONBU
- Drill bit – 27/64"
- Barrel trimming sleeve PKGABTS
- 7mm Barrel Trimmer
- 2-part epoxy glue, Gorilla Glue or CA glue

PREPARING THE BLANK:

- Prepare a blank of at least 5/8" square stock. Cut to the length of the brass tube (add 1/16" for trimming)
- Drill a 27/64" center hole through the blank. NOTE: Sand the tube with 220 grit abrasive for better adhesion of the glue.
- Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Center the tube inside the blank.
- Square the ends of the blank using a 7mm barrel trimmer with the adapter sleeve (#PKGABTS). Mount the sleeve over the shank. Trim the blank down flush with the brass tube. **DO NOT OVERTRIM OR YOUR PEN WILL NOT FUNCTION PROPERLY**

TURNING THE BLANK:

- Mount 7mm spacer bushings on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing, narrow end first (both bushings are the same size). Mount spacer bushing to fill the space to the threads on the mandrel.

Screw on the lock-nut hand tight. Bring the tailstock in snug to the mandrel and tighten the lock-nut for turning. Do not over tighten the lock nut, it may damage the mandrel or will cause your blank to be egg shaped. Turn the blank down close to the bushings; leave about the thickness of a fingernail above the bushings. Follow with abrasives until the barrel diameters are smooth to the feel with the bushings. For the best finish results, use Micro-Mesh and sand to the 12,000 grit.

- Finish with your choice of polish.



ASSEMBLY:

NOTE: Line up finished parts according to the picture above.

- To avoid damage to components when assembling, use an arbor press or PSI #PENPRESS3.
- Press cap assembly into the tube.
- Thread the mechanism (without the refill) into the back of the tip assembly.
- Insert the upper cap assembly over the mechanism; place the entire pen into the pen press. Press in to close the gap to the center band. Be sure to protect the gold parts from being scratched.
- Unscrew the upper barrel assembly; insert the refill with screw mounted into the lower end. Screw back the upper end to engage and close the gap.
- The pen is now ready for use; twist to open and close.