

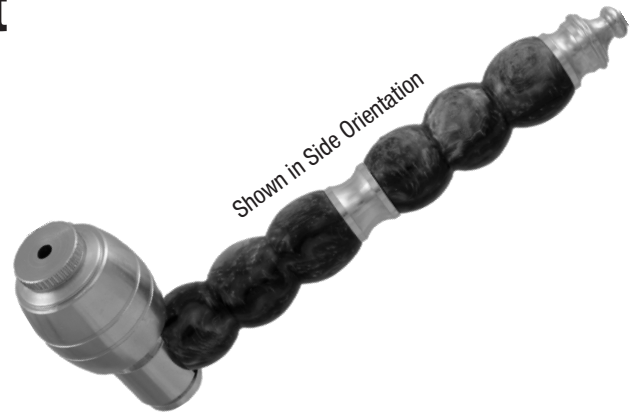
# Smoking Pipe XL Jumbo Bowl Kit

## Kit Features

- Made of durable, Food Safe Metal Components
- Two orientations available
- Standard 1/8" NPS Threading
- Easy to Turn
- Minimal Parts--easy to assemble
- Comes apart for easy cleaning
- Overall Length: 5-1/32"

## Required Accessories

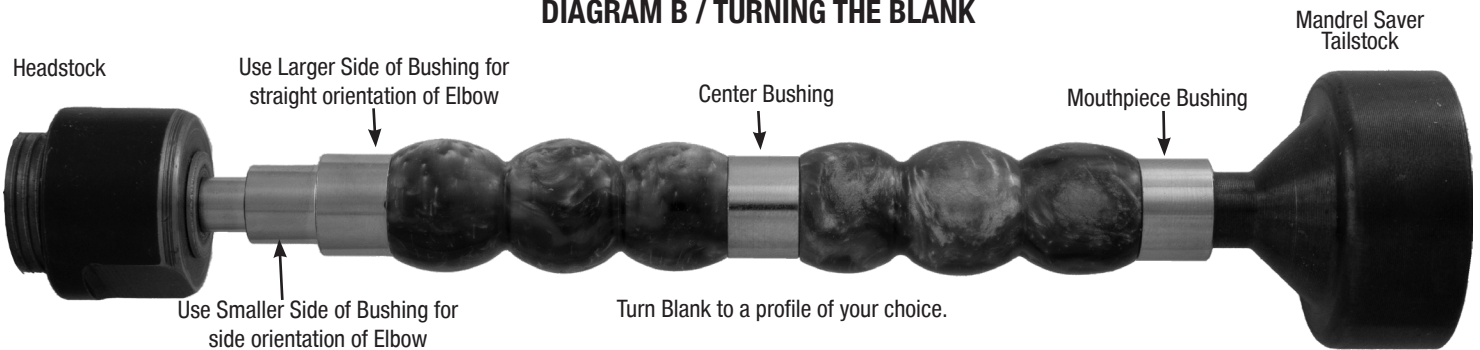
- 7mm Pen Mandrel
- Drill Bit: #PKPARK-8MM for Wood, #PK-8MMSG for Plastic
- Bushing Set(3pc): #PKSPIPE2BU
- Barrel Trimming: PKTRIM8 or use 8mm sleeve from #PKTRIMSET with #PKSQUARE jig and Disc Sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy (CA is NOT recommended)
- Pen Blank Minimum Size: 3/4" x 3/4" x 3-3/4"L



## Preparing the Blank:

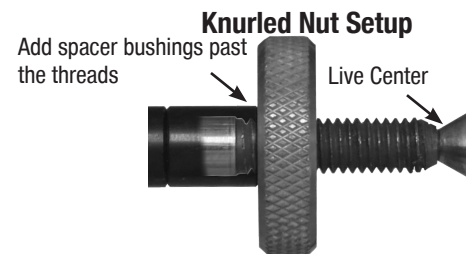
- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill an 8mm hole lengthwise through the blank.
- CA is not recommended for this project due to temperature sensitivity. Epoxy is preferred. Mix and spread glue over tube. Insert the tube into the blank with a twisting motion to spread the glue evenly. A stronger bond can be achieved by spreading a thin film of epoxy inside the hole before inserting tube.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use an 8mm Barrel Trimmer or a pen blank squaring jig with 8mm sleeve on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with assembly and the operation of the mechanism. Use a barrel trimmer to clean the inside of the tube.

## DIAGRAM B / TURNING THE BLANK

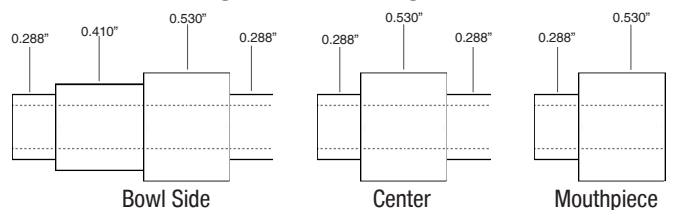


## Turning the Blank:

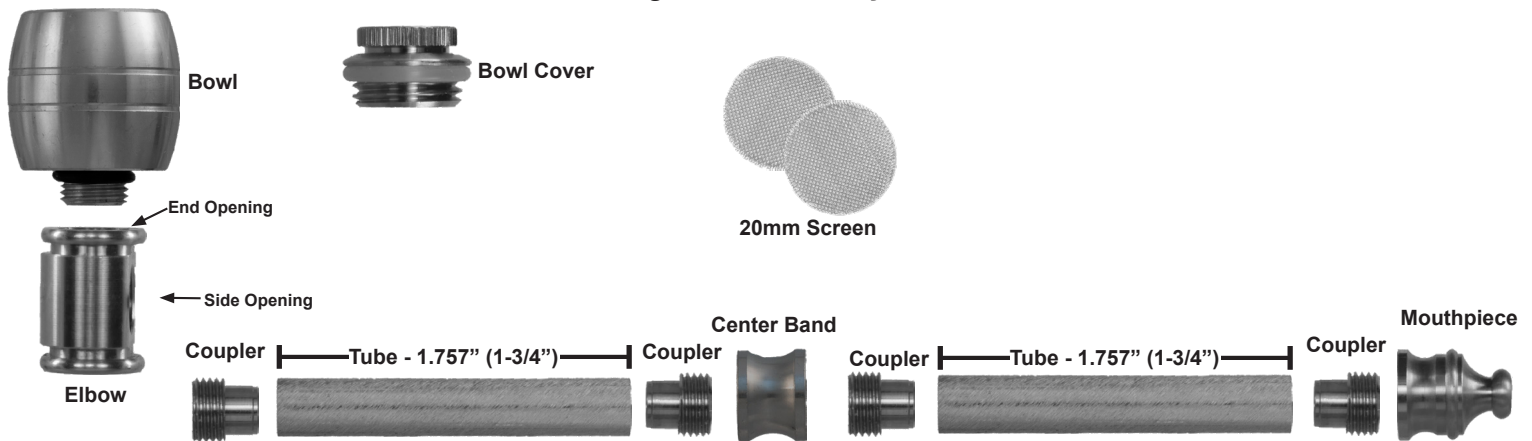
- Mount the bushings and blanks according to Diagram B. See Assembly (back page) for the difference between straight or side orientation of Elbow. Use correct side of bushing for preferred configuration.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock Tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To Used Knurled Nut setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- Thread on the Knurled Nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple.
- Lock Tailstock and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- Using sharp tools, turn the blank. Turn the barrel straight or to a profile of your choice. A wide diameter is recommended to insulate against heat. Because the side face of the elbow is narrow, we recommend a profile that is larger for most of the length with a rounded end to match the bushings.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish instructions.



## Diagram C / Bushing #PKSPIPE2BU



## Diagram D / Parts Layout



## Assembly:

- Press Couplers into both ends of the of both Barrels.
- Thread Coupler of other Barrel into the into Side or End opening of Elbow per your chosen orientation (see below)
- Thread Mouth Piece onto Coupler at end of either Barrel.
- Thread remaining Couplers into both ends of the Centerband.
- Thread the Bowl into the remaining opening in the Elbow.
- Push Bowl Cover into the top of the Bowl; the O-ring will hold it in place.
- Prior to use, remove cover and push screen into the opening of the Bowl. This will help prevent smoking material and ash from being inhaled. Replace screen as needed.
- Pipe can be used with Cover in place. This will help promote a controlled, even burning of the smoking material. Hold flame over hole in top of Cover and it can be drawn into the hole when igniting the pipe.

### Diagram E Side Orientation



- Able to rest on tabletop with Bowl upright.
- Uses **small** side of bushing for Bowl end.

### Diagram F Straight Orientation



- Thin profile; ends are interchangeable.
- Uses **large** side of bushing for Bowl end.