

Aurora Finial Twist pen



Needed:

Mandrel A/7mm; bushing 104A; drill 27/64

Preparing the blank

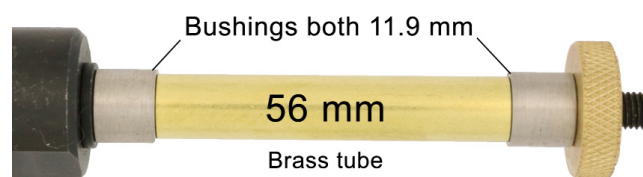
1. Only one blank (half of a standard length pen blank) is required for this pen. Cut the material blank 1/4" longer than the brass tube so you can square the ends off once the tube is glued in.
2. Drill the blank through the center, lengthwise, with a 27/64" bit.
3. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate wax – to keep the glue from getting into the tube. Push the tube ends into a thin section of the material to form a plug. *This is important – glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in the glue then insert it into the blank using a twisting motion until the tube is equidistant between both ends of the blank.
6. Set aside until the glue has had time to reach its maximum strength.

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7. When the glue has cured, remove the plugs from the ends.
8. Using a barrel trimmer of the proper size, square off the ends of the blank until you can see bright brass tube. STOP at this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another major cause of kit failure.*

Turning the blank



1. Assemble the blank on the mandrel using the 104A bushings and following the diagram above.
2. Lightly tighten the mandrel and secure. Do not over-tighten the brass nut – this can bend the mandrel which will result in an oval pen.
3. Turn the pen blank to the desired shape using the bushings as a sizing guide.
4. After turning, sand the surface in progressive steps until you get to 400 or 600 grit. For a smooth finish, continue

sanding with Micro Mesh from 1,500 to 12,000 grit.

5. Apply a finish of your choice and remove the blank from the mandrel.

7. Screw the nib assembly back on over the refill.

8. The pen twists from the top to extend and retract the refill.

Assembling the pen

1. Press the nib assembly into one end of the finished blank.
2. Slide the clip onto the nib coupler and press this assembly into the other end of the blank (the clip may come already attached to the nib coupler).
3. Screw the transmission fully into the nib coupler.
4. Press the finial over the transmission. It can be pressed on by hand.
5. Unscrew the nib assembly (the joint is at the bottom of the center band).
6. Insert the refill with spring into the barrel until seated.

