

Curtis Twist pen



Needed:

Mandrel A; Curtis pen bushings CUR-BU;
Drill 3/8

Preparing the blank

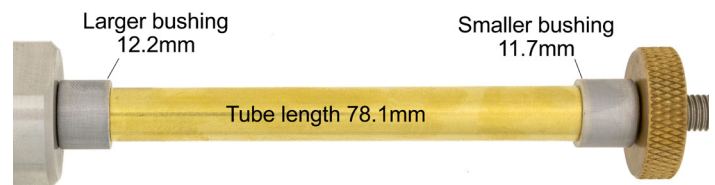
1. Cut the blank about 1/4" longer than the length of the brass tube.
2. Drill the blank through the center, lengthwise, with a 3/8" bit.
3. Scuff the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your 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 glue. We recommend thick CA glue.
6. Insert the tube into the blank with a twisting motion.
7. When the glue has cured, use a hobby knife to remove the plugs from the ends. Using a barrel trimmer of the proper size, square off

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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 common cause of pen failure.*

Turning the blank



1. Assemble the blank on the mandrel using the CUR-BU bushings 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.

Assembling the pen

1. Press the nib assembly into the smaller end of your finished barrel.
2. Unscrew the top finial with the twist mechanism from the clip assembly. Then, press the clip assembly into the larger end of the barrel, being careful not to press directly on the clip.
3. Screw the top finial with the twist mechanism back into the clip assembly.
4. Unscrew the nib and insert the refill with the spring until it seats into the twist mechanism, located inside the finial.
5. Screw the nib back on over the refill and spring.
6. Twist the top finial of the pen to extend and retract the refill.

