

Corporate pen



Needed:

Mandrel A, bushing 101A, drill 3/8

Preparing the blank

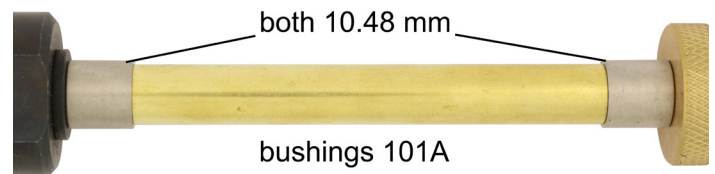
1. Cut the blank about ¼" longer than the pen tube for facing the blank after the tube is glued in.
2. Drill the blank through the centre, lengthwise, with the 3/8 drill bit.
3. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice to keep the glue from getting into the tube. Just push the ends of the tube into a thin section of the material to form a plug. *This is important: glue inside the tubes is a common cause of pen failure.*
5. Roll the tube in glue and insert it into the blank with a twisting motion until it is equidistant between both ends of the blank.
6. Set aside until the glue has had time to reach its maximum strength.
7. When the glue has cured, use a hobby knife to remove the plugs from the ends.

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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. Improper tube length is another common cause of pen failure.

Turning the blank



1. Assemble the blank on the mandrel using the 101A bushings. Both bushings are the same size.
2. Turn the blank to the desired contour, making sure that the area next to the bushing is turned to the size of the adjacent bushing.
3. After turning the blank, sand the surface in progressive steps until you get to 400 or 600 grit. For a high polish finish, continue sanding with Micro Mesh through 12,000 grit.
4. Apply the finish of your choice and polish, and then remove the blank from the mandrel.

Assembling the pen

1. Line up the parts according to the image below.
2. Press the clip/coupler assembly into one end of the barrel.
3. Carefully press the tip assembly into the other end of the barrel
4. Insert the refill with the spring into the barrel.
5. Screw the twist mechanism into the coupler until it stops.
6. Push the cap onto the twist mechanism by hand.

