

Beaufort Aquilo Ballpoint Pen Kit

william wood-write

penblanks.ca



Needed:

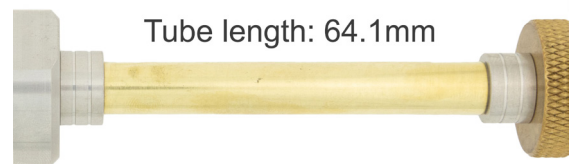
Mandrel A, drill 11/32, bushings HW-SOL-BP-BU

Preparing the blank

1. Cut the blank the length of the brass tube, giving a little extra length for the facing of the blank after the tube has been glued in.
2. Drill the blank lengthwise with the 11/32 drill bit.
3. Scuff the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the tube ends with a material of your choice – we recommend baseplate wax – 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 tube is a common cause of kit failure.
5. Roll the tube in glue and insert it into the blank with 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.

7. When the glue has cured, use a hobby knife to remove the plugs from the ends.
8. Using barrel trimmers of the proper size or the proper jigs and a disk sander, square off the ends of the blank until you can see bright brass tube. Not having the proper tube length is another common cause of pen failure.

Turning the blank



1. The nib and the clip assembly have the same diameter. Therefore both bushings are identical and can be used in either position.
2. Turn the pen blank to the desired shape using the bushings as a sizing guide.
3. After turning the blank, sand the surface in progressive steps until you get to 400 or 600 grit.
4. If a higher gloss finish is desired, continue sanding with Micro Mesh through to 12,000 grit. Then apply a

finish of your choice and polish.

5. Remove the blank from the mandrel.

Assembling the pen

1. Press the clip assembly into one end of the tube.
2. Press the nib coupler into the other end of the tube.
3. Screw the mechanism firmly into the clip assembly.
4. Place the spring on the refill and insert the refill through the nib coupler.
5. Screw the nib onto the nib coupler.
6. After testing for correct operation, the finial can be pushed onto the mechanism so that it meets the clip assembly. If you have strong thumbs, this can be done by hand. Otherwise, use a pen press.
7. The refill extends and retracts by

twisting the finial.

8. The refill is accessed either by unscrewing the nib from the nib coupler or by twisting the finial counterclockwise to unscrew the mechanism.

