

Beaufort Sirocco Ballpoint Pen Kit

william wood-write

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Needed:

Mandrel A, drill 27/64, bushings SIR-BP-BU

Preparing the blanks

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 27/64 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 blanks



1. Bushings are the same size and can go on either end of the tube.
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. Insert the refill, with the spring, through the nib coupler. Once the refill is fully seated into the mechanism, screw the nib on over the refill.
5. After testing for correct operation, the finial can be pushed onto the mechanism until it meets the clip assembly. This will be a tight fit.

