

Slimline pen



Needed:

Mandrel A, drill 7 mm, bushing 1A

Preparing the blanks

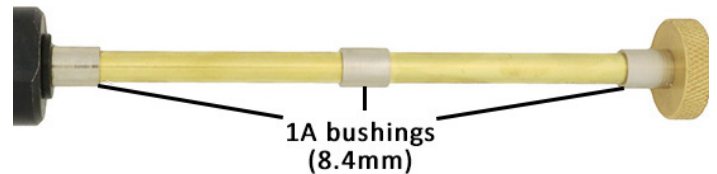
1. Cut the blanks 1/4" longer than each brass tube so you can square off the blanks after the tubes have been glued in.
2. Drill lengthwise through each blank using a 7 mm drill bit.
3. Scuff the brass tubes with sand paper to clean off oxidation and give the glue a better adhesion surface.
4. Plug the 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 one of the tubes in glue and insert it into the blank with a twisting motion until it is equidistant between both ends of the blank. Repeat with the other tube.
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 blanks 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 blanks



1. Assemble the bushings and barrels onto the mandrel referring to the image above.
2. Tighten the tailstock before tightening the blanks on the mandrel. Then tighten the nut that holds the blanks. Do not over tighten or you may bend your mandrel, which will cause your pens to come out oval.
3. Turn the blanks to the desired contour, making sure that the area next to the bushing is turned to the size of the adjacent bushing.
4. Sand to 400 or 600 grit. For a smooth finish, continue sanding with Micro Mesh through to 12,000 grit.

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

Assembling the pen

1. Press the nib into one end of one of the finished blanks
2. Press the twist mechanism into the other end of the same blank. Press this in up to the indentation on the mechanism. It is wise to stop just a little short of the indentation and then test the pen by inserting the refill and extending the point. The point should extend about 3.2mm. Adjust the mechanism accordingly. Make sure you do not go too far. If you do, the pen point will not retract fully.
3. Slide the clip and the finial together.
4. Press the clip/finial assembly into one end of the other tube. Observe pattern and grain matching techniques when doing this operation.
5. Slip the center band over the twist mechanism.
6. Slide the upper barrel onto the pen.

