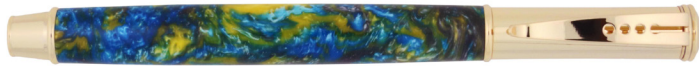


Budget Snap Cap pen



Needed:

Mandrel A; drill 8 mm; bushing 95A

Preparing the blank

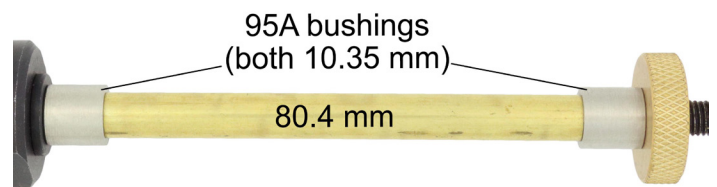
1. Cut the blank about $\frac{1}{4}$ " longer than the length of the brass tube.
2. Drill the blank through the centre, length-wise, with an 8 mm drill bit.
3. Scuff the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate 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 very important: glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in 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 the ends of the blank until you can see bright brass tube. STOP at

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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 95A bushings. Both bushings are the same size.
2. Tighten the tailstock before tightening the nut that holds the blank. DO NOT over-tighten as this may damage the mandrel.
3. Turn the pen blank to the desired shape using the bushings as a sizing guide.
4. After turning the blank, sand the surface in progressive steps until you get to 400 or 600 grit.
5. For a smooth finish, sand with Micro Mesh to 12,000 grit. Then use a finish of your choice and polish.
6. Remove the blank from the mandrel.

Assembling the pen

1. Press the tip coupler into one end of the brass tube, stopping once you reach the threads.
2. Press the end cap into the other end of the brass tube.
3. Drop the spring into the tube wide end first.
4. Remove the cap from the rollerball refill and insert the refill into the barrel of the pen.
5. Thread the writing tip onto the tip coupler.
6. Snap the clip/cap assembly over the writing tip to complete your pen.

