## **Nurse Pen Kit Instructions**

#### **Required Accessories**

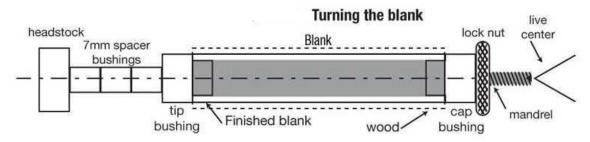
- 7mm Pen Mandrel
- Sierra Bushing set
- 27/64" Drill Bit
- Glue
- Pen Blank





### **Preparing the Blank**

- 1. Cut a blank to the length of the tube, adding 1.5mm for trimming.
- 2. Drill a 27/64" hole lengthwise through the blank.
- 3. Glue the tube into the blank. Coat the outside of the tube with glue and insert the tube into the blank with a twisting motion to spread the glue until flush. Allow it to dry.
- 4. Square the ends of the blank to the tube.



### **Turning the Blank**

- 1. Slide 7mm spacer bushings onto the mandrel shaft, followed by the tip bushing, wide end first. Slide on the blank followed by the cap bushing, narrow end first. Add additional spacer bushings as necessary to reach the mandrel threads.
- 2. Thread on the locknut hand tight. Bring the tailstock in snug to the mandrel, lock in place. Tighten the lock nut for turning. DO NOT over tighten the locknut it could damage the mandrel.
- 3. Turn the barrels close to the bushing diameter with sharp tools (straight or to a profile of your choice). Sand the barrels to match the bushing diameter.
- 4. Finish the wood with your choice of polish.

Assembly over page

# **Assembly**

- 1. Line up the parts according to the picture below.
- 2. Slide the spring onto the refill and slide into the tip assembly.
- 3. Screw on the twist mechanism into the tip assembly.
- 4. Press the Clip/Cap assembly into one end of the barrel.
- 5. Push the barrel onto the the completed lower assembly.
- 6. The pen is now complete, twist clockwise to operate.

