

Gallant Pen Kits Assembly Instructions

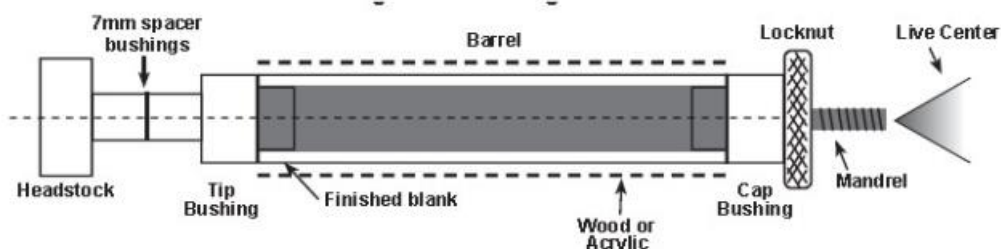
Required Accessories:

- 7mm, Pen Mandrel
- 3/8" Drill Bit RZ-DB3/8
- 2 piece Bushing Set RZ-BP182#-BU
- Universal Barrel Trimmer 3/8 shaft RZ-PM013
- Sandpaper/Finish
- Glue (Thick CA or Epoxy)

Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
 - Drill a 3/8" hole lengthwise through the blank.
 - Glue the brass tube in the blank. Spread the glue on the tube. Insert into the blank with a twisting motion to spread the glue evenly inside. Centre the tube lengthwise in the blank.
- Allow it to dry.
- After the glue dries, use a 3/8" Barrel Trimmer to square the ends of the blank to flush with the ends of the brass tube.

Diagram A



Turning the Blanks (see Diagram A)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first.
Insert the blank. Follow with the cap bushing; narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.