



## **Magnetic Rifle Pen Kits Assembly Instructions**

### **REQUIRED ACCESSORIES:**

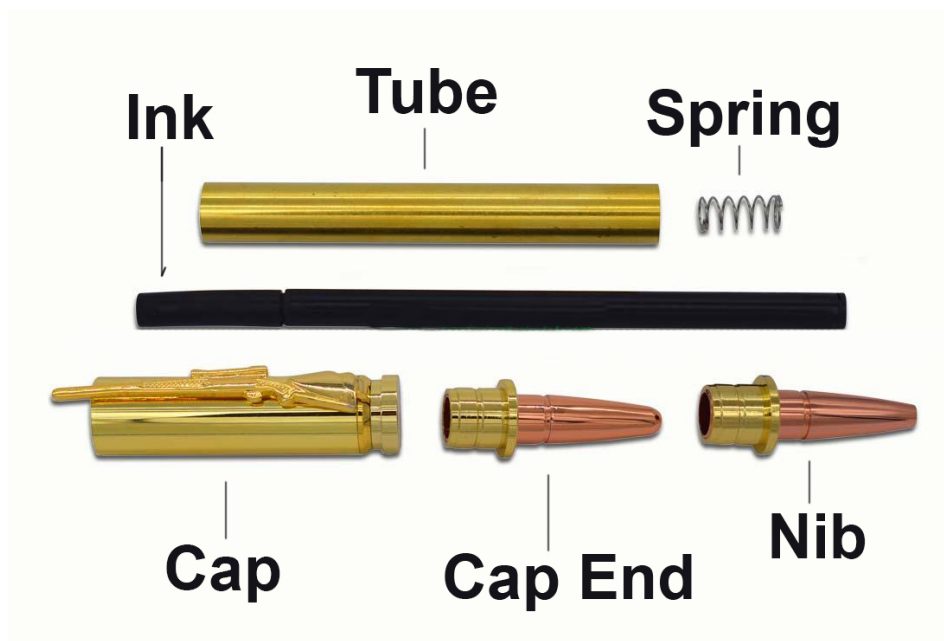
- 7mm Pen Mandrel
- 10 mm Drill Bit
- 2 pc Bushing Set #10150
- 10 mm Barrel Trimmer Set
- 2 part epoxy glue or insta-cure (cyanoacrylate)

### **PREPARING THE BLANKS:**

1. Cut 3/4" square or larger blanks to the length of the brass tubes (add 1/16" for squaring off).
2. Drill a 10mm-centered hole lengthwise through each blank.
3. Spread glue over the tubes; insert into the blanks with a twisting motion to spread the glue evenly inside. Center the tubes lengthwise inside the blanks.
4. When the glue dries, square the ends of the blank. Use a 10 mm barrel trimmer to take the wood down flush to the brass tubes.

### **TURNING THE BLANKS:**

1. Place spacer bushings onto the mandrel. Place the tip bushing on next, follow with the blank. Next place the cap bushing. Screw on the lock nut hand tight. Bring the tailstock into the mandrel. Lock into place. Tighten the lock nut (do not over-tighten, it may damage the mandrel).
2. Turn the wood down to the diameter of the bushings using chisels and abrasives. Taper the lower blank. Follow diagram 'B' for profile. Form a straight line between the bushings on the upper barrel. Test to be sure the filigree tube fits snug over the barrel. Finish the barrels.



## Assembly:

- 1) Begin by pressing the Nib into the proper end of the blank.

**You can unscrew the copper end from the bass coupler for more control while pressing the pieces together. Once complete screw copper end back onto coupler.**

- 2) Next press the Cap End into the other end of the blank.

**You can unscrew the copper end from the bass coupler for more control while pressing the pieces together.**

- 3) Remove (unscrew the copper end) of the endcap and insert the ink. Place the Spring on the flat end of the in and screw the copper part of the endcap back in place.
- 4) Place the cap on the desired end and you are done.

