

Hart Pen Kit

Product: #145229, #828438

8/28/2015



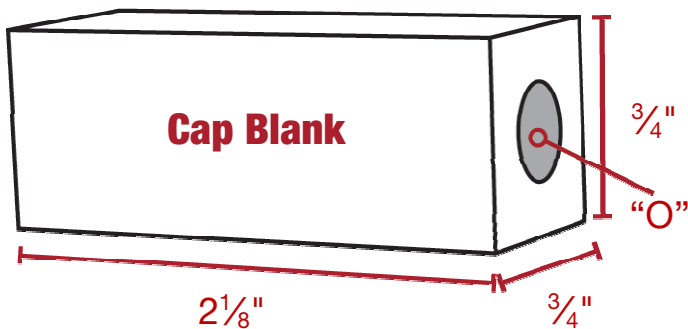
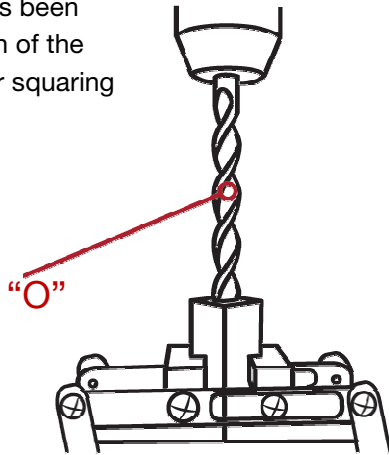
From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- Letter "O" Pen Maker's Bit
- 1 - $\frac{3}{4}$ " x $\frac{3}{4}$ " x $2\frac{1}{8}$ " Cap Blank
- 1 - $\frac{3}{4}$ " x $\frac{3}{4}$ " x $2\frac{3}{8}$ " Body Blank
- Pen Mandrel
- Hart Pen Bushings (145233)
- Thick CA or 5-Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- Barrel Trimmer
- Pen Press
- Eye & Ear Protection
- Dust Mask

Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.

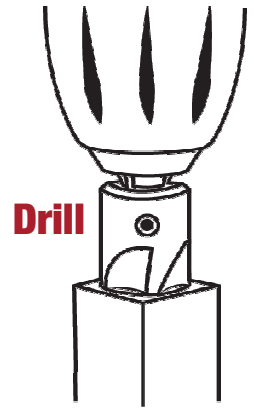
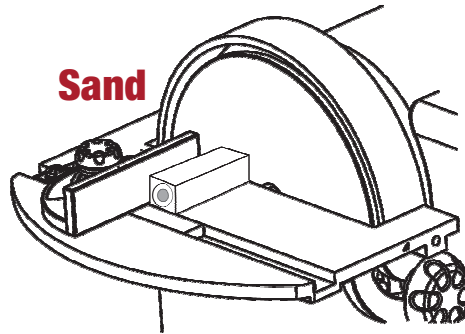


Gluing Blanks to Tubes:

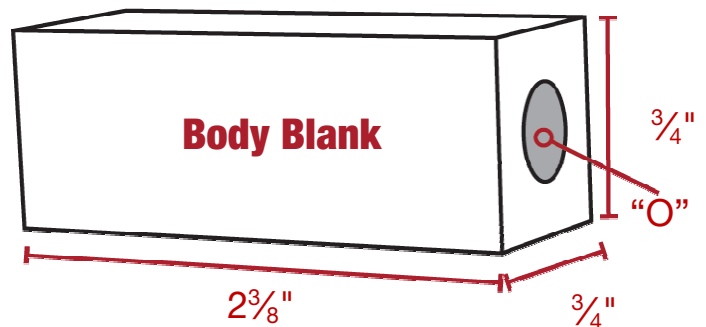
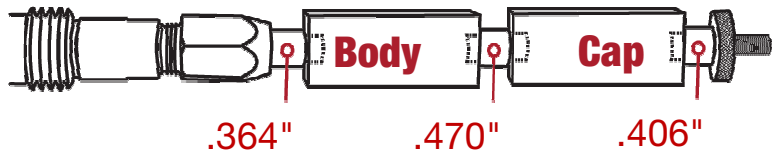
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5-Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.

Squaring the Blank to Length:

When squaring the blanks to length work only to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.



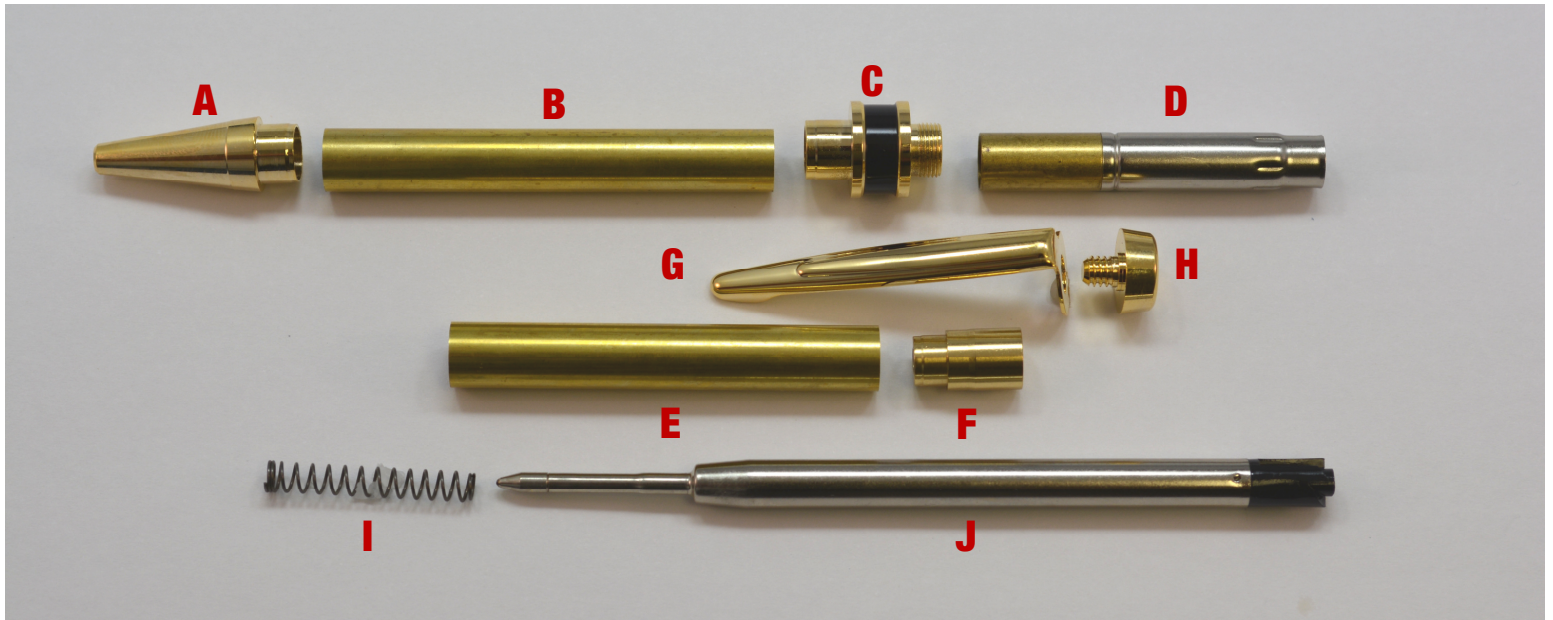
Mandrel Preparation:



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Turning & Finishing the Blanks:

Turn the blank to your desired profile, leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120-grit paper, and progress through the finer grits, finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

Pen Assembly:

Cap:

- Press the Finial Clip Bushing (F) tapered end first, flush into the .406" diameter end of the Finished Cap (E).
- Insert the threaded post of the Finial (H) through the hole in Clip (G) and thread into the Finial Clip Bushing (F).
- Insert the Twist Mechanism (D) steel end first, into the .470" diameter end of the Finished Cap (E) and press into place until flush with the end of the barrel of the Finished Cap (E).

Body:

- Press Nib (A) into the .364" diameter end of the Finished Body (B).
- Next press the Twist Mechanism Holder /Center Band (C)

non-threaded end first, into the .470" diameter end of the Finished Body (B).

- Install Spring (I) small end first onto Ink Refill (J).
- Insert Ink Refill (J) into the open end of the Finished Barrel (B).
- Finish the assembly by sliding the Finished Cap (E) over the Ink Refill (J) and thread onto the end of the Twist Mechanism Holder/Center Band (C) until seated firmly.

To advance the ink refill turn the body clockwise, to retract the ink refill turn the body counter clockwise.