General Pen Kit Turning Instructions

9/8/2015

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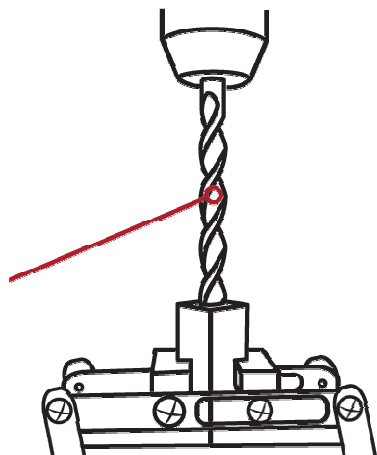
These are the supplies we suggest you have on hand to complete this pen kit:

- ❑ Pen Maker's Bit
- ❑ ¾" x ¾" x 5" Pen Blank
- ❑ Pen Mandrel
- ❑ Pen Kit Bushings
- ❑ Thick CA or 5 Minute Epoxy
- ❑ Drill or Drill Press
- ❑ Sandpaper/MicroMesh
- ❑ Barrel Trimmer
- ❑ Pen Press
- ❑ Eye & Ear Protection
- ❑ Dust Mask

Cutting & Drilling Blanks:

Cut blanks $1/8$" longer than the brass tubes provided in the kit. For your safety, be sure that the blanks are solid and have no voids, checks or other defects. To drill the pen blanks, mark centers on one end using either a pen blank center finder or ruler. Install the correct size Pen Maker's bit into the drill press, using a pen vise , clamp the blank and align the center point of the bit with the center mark on the blank. Drill through the entire length of the blank.
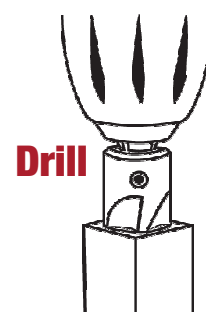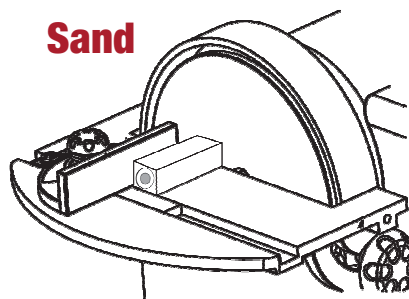
Correct size for specific kit
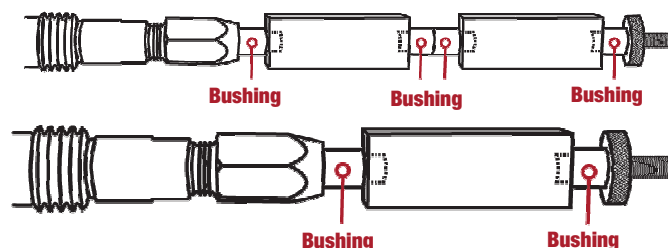
Gluing Blanks to Tubes:

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 into the inside of the blank make 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 only go to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.

Sand

Drill

Mandrel Preparation:

Bushing Bushing Bushing

Bushing Bushing

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 progressing to 320-grit. Once finished with sanding apply a finish of your choice.

Assembly:

- ❑ Assembly varies by kit, see specific kit instructions for assembly detail and specifications.