

European Style Pen Kits

Product #: 06S45, 06S46, 06U90, 124962, 124963, 125268, 126454, 128260, 128262, 141658, 141659, 141660, 142509, 142510, 145652, 147072, 147073, 839366

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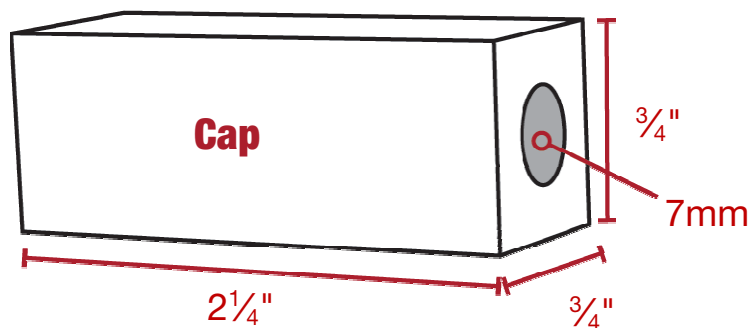
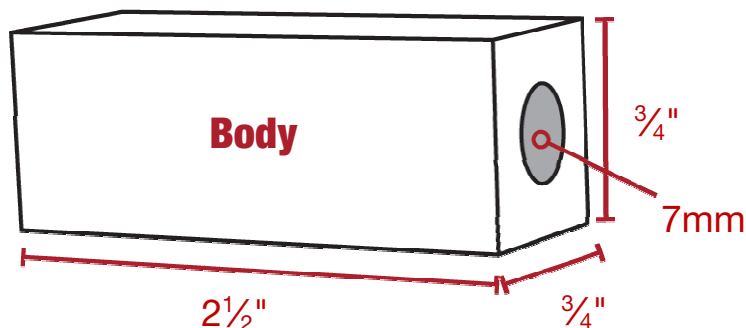
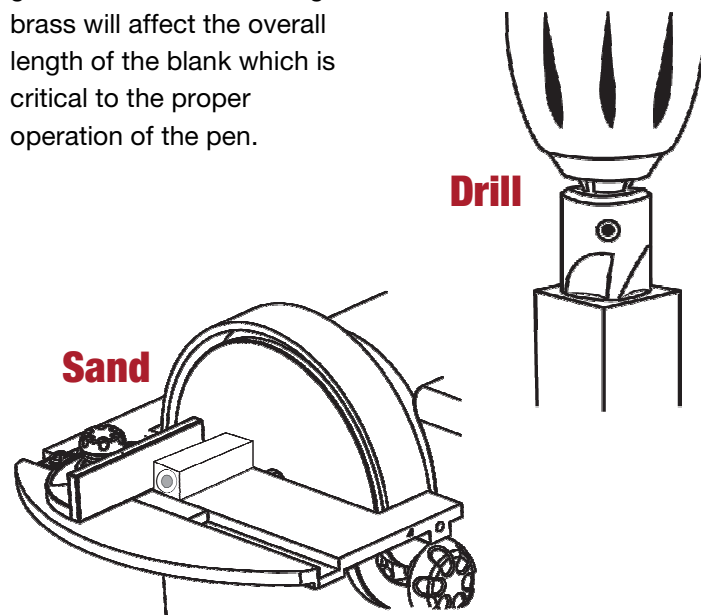
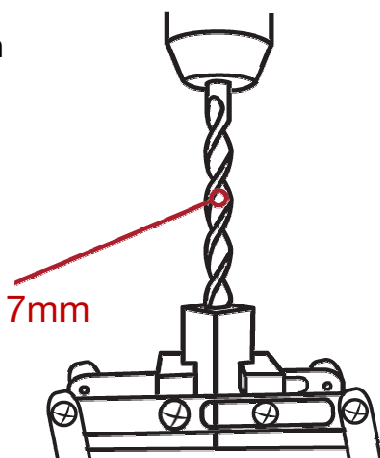
From Setup To Sanding:

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

- 7mm Pen Maker's Bit
- 1 - $\frac{3}{4}$ " x $\frac{3}{4}$ " x $2\frac{1}{4}$ " Cap Blank
- 1 - $\frac{3}{4}$ " x $\frac{3}{4}$ " x $2\frac{1}{2}$ " Body Blank
- Pen Mandrel
- European Style Bushings (06S62)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/MicroMesh
- 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 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.

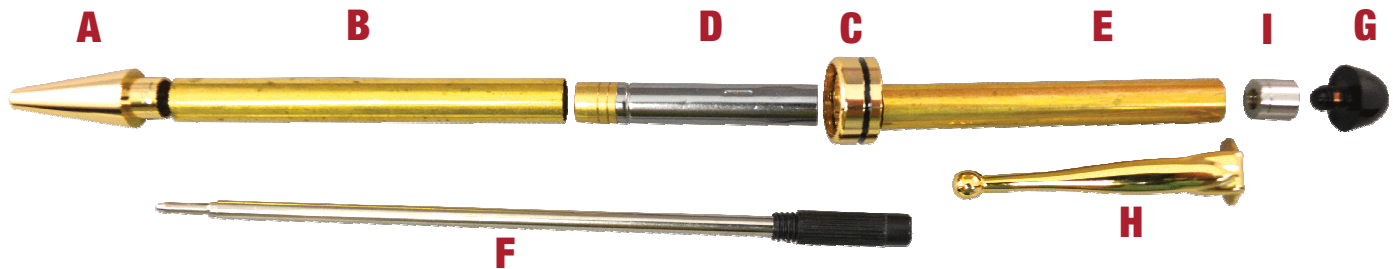
Squaring the Blank to Length:

When squaring the blanks to length ensure to 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.

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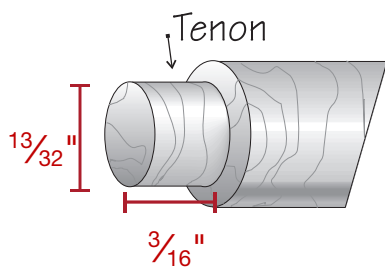
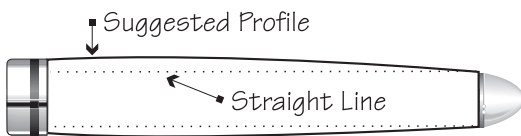


Mandrel Preparation:

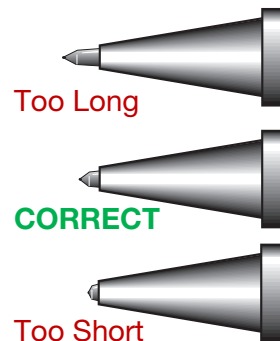


Turning & Finishing the Blanks:

Turn the blank to your desired profile leaving the blank slightly proud of the bushings refer Suggested Profile image below for suggestions. A tenon will be required to be turned for the Cap portion of this kit, refer to tenon image for specifications. Use the center ring bushing to check your progress, once the ring slides over the tenon proceed turning the remaining portion of the cap end to the diameters of the bushings. With the lathe spinning, begin sanding with 120 grit paper progressing through the finer grits finishing with 320 grit. Once finished with sanding apply a finish of your choice.



Fully Twisted Position



Pen Assembly:

Cap:

- Using a drop of CA glue, secure the Center Ring (C) onto the tenon of the Cap/Tube Assembly (E).
- Press the Finial Cap Bushing (I) flush into the open end of the Cap/Tube Assembly (E).
- Next place Clip (H) onto the threads of the Finial Cap (G) and attach to the Finial Cap Bushing (I).

Body:

- Press Tip (A) into the smaller diameter end of the Body/Tube Assembly (B).
- Next press the Twist Mechanism (D) brass end first into the other end of the Body Tube Assembly (B) leaving approximately $\frac{7}{8}$ " of the chrome portion of the mechanism exposed.
- While pressing the Twist Mechanism into place, test the position by extending the pen tip and noting its location with respect to the nib. Refer to the image for the correct position. To test the extension/retraction of the refill tip, install Ink Refill (F) and rotate the twist mechanism and note the position of the Ink Refill in the extended/retracted position. This is a trial and error process so take your time.
- Once completed join the two sections together by pressing together by hand.