



Satin Finish Classic American Style Twist Pen

Product #142408, 142409, 142410

General Instructions

Whether you're a novice turner or a pro, you'll find these projects are all quick and easy to make. Using cut-offs and shorts, the type everyone saves but doesn't know what to do with, you'll find yourself making handsome, custom woodturning projects which are great for gifts or for sale. The following is general in nature, please refer to the instruction sheet on the opposite side for specific dimensions and sizes for your project.

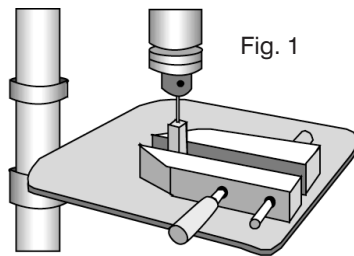
1. Cutting Blanks

Cut wooden blanks to the size specified in the enclosed instructions. For your safety, be sure that the blanks are solid and have no holes, checks or other defects.

2. Drilling Blanks

Center and bore a hole through your stock as specified in the Project Instructions on the opposite side. The center of the blank can be located at the intersection of diagonal lines, drawn from opposite corners. All holes

are easily drilled using a clamp and a drill press (**FIG. 1**). Before you start to drill be sure that your blank is at 90° to the drill press table. You may also chuck and drill the stock on your lathe.

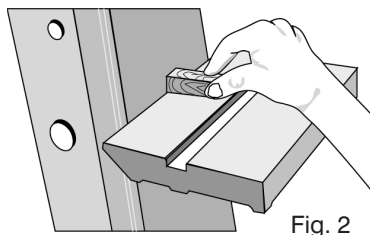


3. Gluing Blanks to Tubes

Rough the brass tube's surface with a fine grit sandpaper and use a quick drying CA type glue to secure the brass tubes into the blanks. Rotate the tube as you insert it to ensure maximum surface coverage of glue. If you find that CA glue is not providing adequate bonding, an alternative is any two part epoxy type glue.

4. Sanding Blanks to Length

Using a belt or disc sander, square the ends of the brass tube/wood blank. The blank should be flush with the brass tube on both ends. Care should be taken to not sand into the tubes (**FIG. 2**). If any excess glue remains inside the tubes it should be gently scraped out.



5. Mandrel Preparation

Woodcraft's new Pen and Pencil Makers Mandrel system allows you to turn a variety of small projects without requiring the purchase of a unique, special mandrel each time. The only item you will need to purchase to turn new projects is the specially designed bushing set for the project of your choice. The mandrel is provided with either a #1 Morse Taper (141468) or a #2 Morse Taper (141469). If you prefer to use the mandrel in a three jaw chuck, simply loosen the Morse Taper set screw and slide the Morse Taper off of the shaft. Now the mandrel shaft may be mounted directly in your three jaw chuck. With the bushing sets specified on the project instruction sheet, mount your wood blanks and bushings as depicted for each project. With the mandrel mounted in your lathe, slide a bushing onto the mandrel, followed by a wood blank and a second bushing or spacer as required, followed by the second wood blank if required. With the wood blanks installed on the mandrel secure the wood blank/bushing assembly using the washer and retaining nut provided. Bring up a live center in the tailstock to support the threaded end of the mandrel. Do not over tighten the tailstock or the mandrel will flex and bend causing oval shaped turnings.

6. Turning Blanks

Place your tool rest parallel and as close as possible to the blank. Rotate the blank by hand to ensure it will not touch the tool rest when the lathe is turned on. Using a turning speed of approximately 1,000 RPM begin turning the blank to a diameter slightly larger than the bushings. You can work the stock down to just short of the desired design or diameter by carefully scraping or sanding.

7. Finishing the Blanks

Blanks can be finished like any other wood project. Using a fine grit sandpaper, sand the blank until it is flush with the bushing for parallel sided projects or until the desired profile is obtained for custom projects. Use a wood filler, if desired, to fill any grain openings in the blank. Final sanding with a wet/dry paper will create a blank which is glass smooth. *Tip: We have found that use of Micro Mesh sanding paper (11L61) after wet/dry sanding creates a perfect, glass smooth finish.*

8. Assembly

All parts should fit together as depicted in the parts diagram for each project. In some cases a pen press or machinists vise will be needed to completely press the parts together. Protect all plated parts from scratching by covering them with a cloth or thin pad before placing them in a vise. Proceed carefully, many of the kit components are delicate and uneven or excessive pressure will cause permanent damage.



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1. Cutting Blanks

Cut 2 wood blanks $\frac{5}{8}$ " x $\frac{5}{8}$ " x $2\frac{3}{8}$ " long.

2. Drilling Blanks

Using a letter "O" brad point drill bit, drill a hole lengthwise through the center of each blank.

3. Gluing Blanks to Tubes

See General Instructions for details.

4. Sanding Blanks to Length

See General Instructions for details.

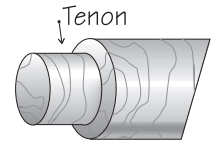
5. Mandrel Preparation

Mount the tube blanks on your lathe mandrel and turn to bushing dimensions. All three bushings are identical, but proper placement will enable you to turn to the dimensions required for the pen top and bottom. Place the first bushing on the mandrel with the "large" diameter on the headstock side of the mandrel. Slide a blank onto the mandrel and over the lip of the first bushing. Place the second bushing on the mandrel with the "small" diameter oriented toward the headstock and slip the bushing lip into the first blank. Place the second blank on the mandrel, followed by the third bushing with the "large" diameter oriented toward the headstock. In this configuration, the blank closest to the headstock is Tube #1 (the pen bottom) and the blank closest to the tailstock is Tube #2 (the pen top). The smaller washer provided with the bushing set should replace the large washer supplied with your mandrel when turning Classic American Pens to prevent possible damage to the "lip" of the bushings.

Tip: Mark or identify your bushings so that you can use them in the same mandrel position each time and avoid damaging the bushing lip when the washer and nut are tightened.

6. Turning the Blanks

The diameter of Tube #1 must exactly match the bushing diameter. If this diameter is not precisely obtained, the wood of Tube #1 will rub or bind on the pen's center ring (H) when assembled, and your pen will not operate properly. Turn a tenon (a projection of wood) on the center ring end of the pen top (Tube #2) to accept the center ring. The center ring will ultimately be glued into place on this tenon. For a snug fit the tenon should be approx. $\frac{13}{32}$ " (10.5mm) in diameter and $\frac{1}{4}$ " in length.

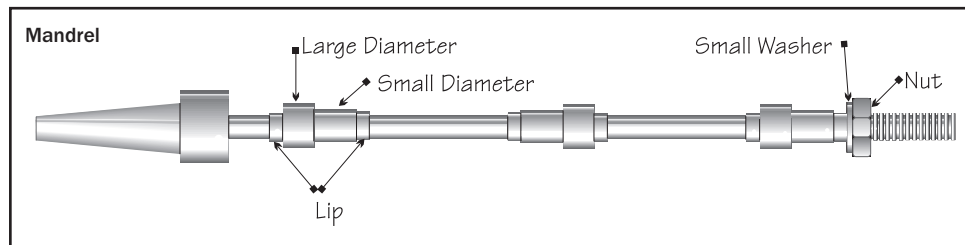


7. Finishing the Blanks

See General Instructions for details.

8. Assembly

1. Push fit the gold tip (A) into the black tip center (B). Slide the gold ring (C) over the opposite end of the black tip center (B). Press this entire assembly into one end of tube #1 (D).
2. Press the smooth end of the twist holder (E) into the other end of tube #1 (D).
3. Place the spring (L) over the narrow end of the ink refill (M) and insert the refill and spring into Tube #1.
4. Screw the twist mechanism (F) onto the twist holder (now pressed into Tube #1) and secure tightly.
5. The Center Ring, part (H), goes onto the tenon, turned on the top tube assembly, so that the flat side of the Center Ring goes against the shoulder of the wood tenon. Carefully glue the Center Ring in place with CA glue.
6. Slip the partially assembled cap, center ring first, on and off of the twist mechanism (F). The cap should freely slip on and off of the twist mechanism (F), with **NO** rubbing or binding whatsoever. If you feel any resistance, use a small round file and carefully file the interior of the brass Tube #2 (I) on the center ring end.





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In some cases, pressing the center ring onto the brass tube results in a fit which is too tight and this slight filing will be required to create interior clearance necessary for proper pen operation. You should also check the area where the center ring (H) rubs against the pen bottom. Any interference here will cause the pen to bind and not operate properly. With proper clearance, you should be able to see a slight gap around the entire circumference of the pen where top and bottom meet in the center ring (H). We have found that a careful scraping action can be used to "shave" some wood from the end of the pen bottom and create this clearance if necessary. Extreme care must be taken to avoid scratching/damaging the twist holder.

7. Once proper clearance is obtained, press the Brass Clip Bushing (J) into the top of tube #2, opposite the center ring. Press the Bushing (J) flush with the top of the tube. Slip the top tube assembly over the twist mechanism and align the wood grain. Using a clamp or vise (the vise must open approximately 6"), press the upper tube assembly onto the lower assembly. This procedure presses the stud end of the Brass Clip Bushing (J) into the nipple of the twist mechanism (F), securing the pen top to the bottom. If your pen top has not been secured to the bottom by this process, place the stud of the Finial (K) through the Clip (G) and screw into the top of the Brass Clip Bushing (J). Do not completely tighten the finial, but leave approximately 1/16" of space between the top Tube #2 and Finial (K). Place the pen in a clamp or vise and press the Finial (K) flush with the top of Tube #2. This action will further seat the Brass Clip Bushing (J) and engage the nipple of the twist mechanism.

9. Pen Operation

1. Turn the top of the pen clockwise or counter clockwise while holding the bottom and the ink refill will rotate out and lock. This is the double twist action of this pen.
2. To remove the pen top for ink refill replacement, turn the top counter clockwise past the point where the ink refill is extended and screw the top off of the pen.

Additional Parts:

06S28 replacement tubes (5 pair)

