

Jr pen kit instructions

Needed:

Mandrel A, drills 10.5 mm and 12.5 mm, bushing 89A

Preparing the blanks

1. Cut the blanks the length of each brass tube, giving a little extra length for the facing of the blank after the tubes have been glued in.
2. Drill the blank that will use the shorter, thicker tube lengthwise with the 12.5 mm drill bit.
3. Drill the blank that will use the longer, thinner tube lengthwise with the 10.5 mm drill bit.
4. Scuff the brass tubes with sandpaper to clean and give the glue a better adhesion surface.
5. Plug the tube ends with a material of your choice – we recommend baseplate wax – to keep the glue from getting into the tube. Just push the ends of the tubes into a thin section of the material to form a plug. *This is important: glue inside the tubes is a common cause of kit failure.*
6. Apply glue to one of the tubes and insert it into the blank with a twisting motion until the tube is completely inserted into the blank with equal distance of blank material both ends of the tube. Repeat with the other tube.
7. Set aside until the glue has had time to reach its maximum strength.
8. When the glue has cured, use a hobby knife to remove the plugs from the ends.
9. Using a barrel trimmer of the proper size (or a rotary sander), square off the ends of the blanks until you can *JUST* see bright brass tube. STOP at this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another common cause of pen failure.*

Turning the Blanks



1. Assemble the blanks on the mandrel referring to the diagram above.
 2. Tighten the tailstock before tightening the nut on the mandrel. Don't over-tighten as this may bend the mandrel and cause your pen to come out oval.
 3. Turn the pen blanks to the desired shape using the bushings as a sizing guide.
 4. After turning the blanks, sand the surface in progressive steps until you get to 400 or 600 grit.
 5. If a higher gloss finish is desired, continue sanding with Micro Mesh through to 12,000 grit. Then apply a finish of your choice and polish.
 6. Remove the blanks from the mandrel.
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Assembling the pen



1. Lay out the parts as shown in parts diagram above. Use a pen press, vise or clamp with wood or plastic jaws to avoid damaging parts during assembly.
2. Press the end cap coupler into the smaller end of the long (pen body) tube. Then screw the end cap onto the end cap coupler.
3. Slide the trim ring over the unthreaded end of the nib coupler and press both together into the larger end of the long tube.

Rollerball: Insert the spring, then the ink cartridge in the long tube. Thread the rollerball nib into the nib coupler.

Fountain: Attach the ink cartridge to the back of the fountain nib, and then thread the fountain nib into the nib coupler.

4. Press the center band coupler, black end first, into the opposite end of the short (cap) tube.
5. Slide the clip onto the cap, and then press them into the top of the short tube.