

Reflector Ballpoint Pen Kit

Product : #164281, #164282

9/17/2018



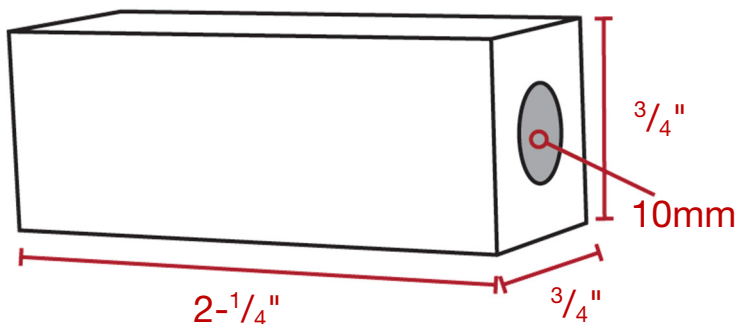
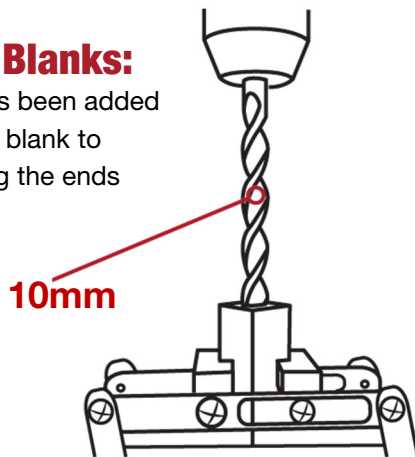
From Setup To Sanding:

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

- 10mm Pen Maker's Bit
- 3/4" x 3/4" x 2-1/4" Pen Blank
- Pen Mandrel
- Reflector Pen Kit Bushings (164283)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- Pen Mill Pilot Shaft 10mm (153195)
- 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.

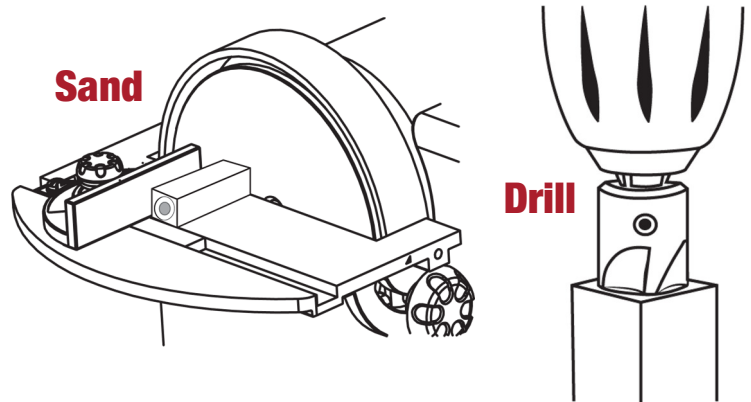


Gluing Blanks to Tubes:

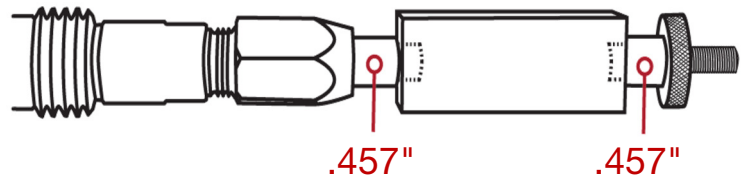
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive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

Squaring the Blank to Length:

When squaring the blanks 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:



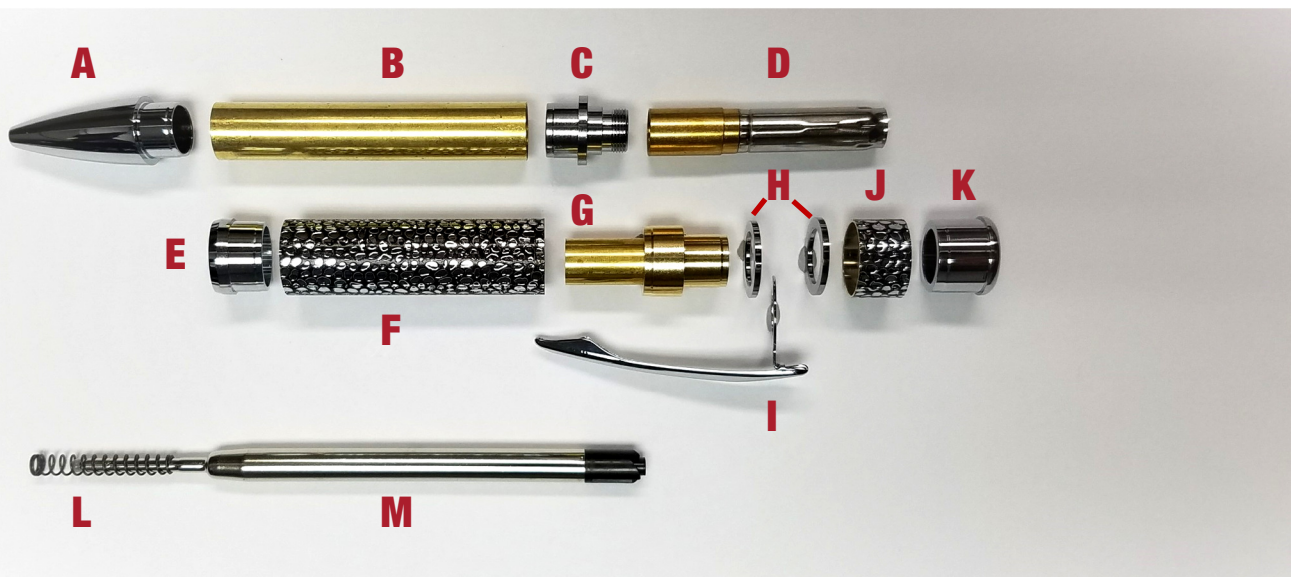
Turning & Finishing the Blanks:

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, progress through the finer grits, finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

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**Assembly:**

- ❑ Press Nib (A) into one end of Finished Barrel (B). Next press Twist Coupler (C) into open end of the Finished Barrel (B). Slide Spring (L) small end first over the Ink Refill (M) and insert into the Twist Coupler (C), thread Twist Mechanism (D) onto the threaded portion of the Twist Coupler (C). Set this portion of the pen aside.
- ❑ Next press the Finial Metal Tube (J) fully onto Finial Cap (K). Slide one of the two Clip Rings (H) onto the short end of the Clip Adapter (G) followed by Clip (I) and the remaining Clip Ring (H). Press Finial (J, K) onto Clip Assembly (G, H, I).
- ❑ Press the finished Clip Assembly (G, H, I, J, K) into one end of the Metal Barrel (F). Next press the Center Band (E) into the other end of the Metal Barrel (F).
- ❑ Finish the assembly pressing the Finished Cap Assembly onto the Finished Barrel by hand and test for proper operation.