From Setup To Sanding:

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

- 10mm Pen Maker’s Bit
- 1 - ¾" x ¾" x 2 ⅛" Cap Blank
- 1 - ¾" x ¾" x 2 ⅛" Body Blank
- Pen Mandrel
- Cigar Bushings (147161)
- Thick CA or 5-Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- 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 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 to length work only to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pencil.
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, and progress through the finer grits, finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

Pen Assembly:

Cap:
- Slide Decorative Ring (H) onto Black Center Band (G) and press into the .576” diameter end of the Cap Assembly (I).
- Next slide Clip (K) over the Threaded Finial Holder (J), secure the clip by threading the Finial Cap (L) on until tight.
  Press the Clip Assembly (J, K, L) into the .474” end of the Cap Assembly (I).

Body:
- Thread the Decorative Ring (B) onto the Nib Adapter (C) ensuring that the taper of the Ring matches the taper of the Nib.
- Next thread the Nib (A) onto the Adapter and press into the .461” end of the Body Assembly (D).
- Next press the Clicker Mechanism Adapter (E) into the .531” end of the Body Assembly (D).
- Slip the Pencil Mechanism (M) in through the Clicker Mechanism Adapter (E).
- Screw the Clicker Mechanism (F) into Clicker Mechanism Adapter (E). Finish the assembly by pressing the Cap Assembly (G, H, I, J, K, L) by hand onto the completed Body Assembly (A, B, C, D, E, F).

To advance the pencil refill push on the Final Cap. To retract the pencil refill press and hold down on the Finial Cap and gently press the lead back inside the refill.