

## Pluma Pen Kit



Product: #158627, #158628, #158629

4/27/201

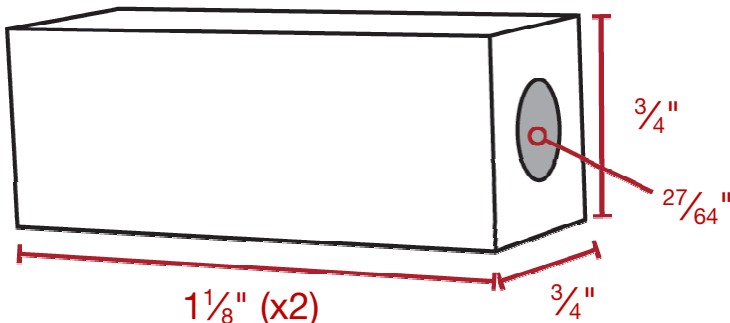
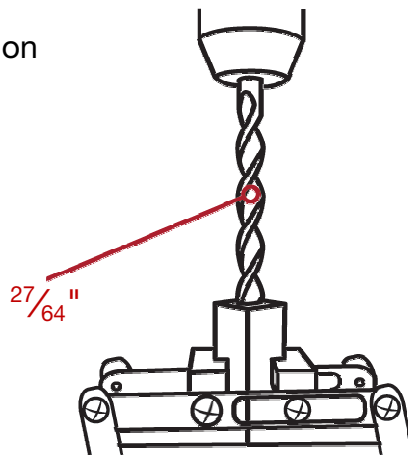
### From Setup To Sanding:

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

- $27/64$ " Pen Maker's Bit
- $3/4$ " x  $3/4$ " x  $1 1/8$ " (x2) Pen Blank
- Pen Mandrel
- Wall Street II Pluma Bushings (146597)
- 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.

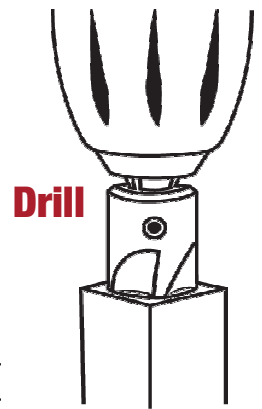
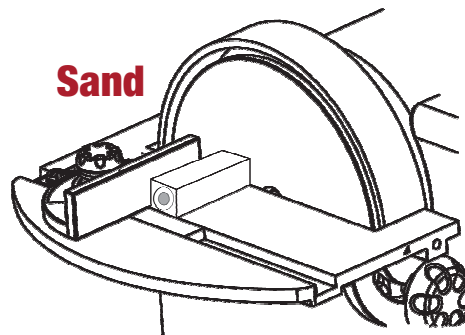


### Gluing Blanks to Tubes:

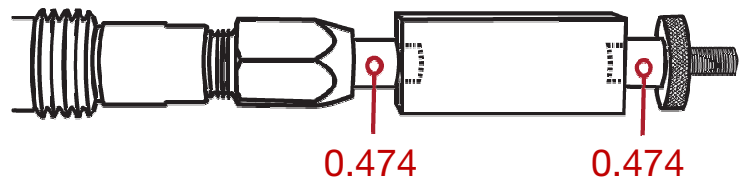
Rough the entire surface of the tube using 180 grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube into the inside of the blank make sure to rotate the tube as you insert it into the blank. This will help ensure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



### 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 progressing through the finer grits finishing at 320 grit. Once finished with sanding apply a finish of your choice.

**Pluma Pen Kit**

Product: #158627, #158628, #158629

4/27/201

**Assembly:**

- ❑ Press Threaded Coupler (B) tapered end first, flush into one end of either of the Blank/Tubes (C). Next press the Center Band Coupling (D) into the other end of the Blank/Tubes (C) that just received the Threaded Coupler (B), once completed press the remaining Blank/Tube (C) onto the other end of the Center Band Coupler (D).
- ❑ Press the Clip Assembly Coupler (E) flush, tapered end first into the open end of the Blank/Tube (C) assembly.
- ❑ Next slide Clip (F) onto Transmission Coupler (H) followed by the Trim Ring (G) and press the assembly into the open end of the Blank/Tube Assembly (C).
- ❑ Thread Transmission (I) into the end of the Transmission Coupler Assembly. Next, by hand press the Knurled Cap (J) onto the end of the Transmission (I).
- ❑ Unthread Nib (A) and insert Ink Refill (K) black end first into the assembled pen, ensure that the spring has been inserted onto the Ink Refill. To finish the assembly thread Nib (A) onto the pen assembly.

To advance the ink refill turn the body clockwise, to retract the ink refill turn the body counter clockwise.