



# Houtdraaiwerken-penkits

## BP133 Damping Pen Kits Assembly Instructions

### Required Accessories:

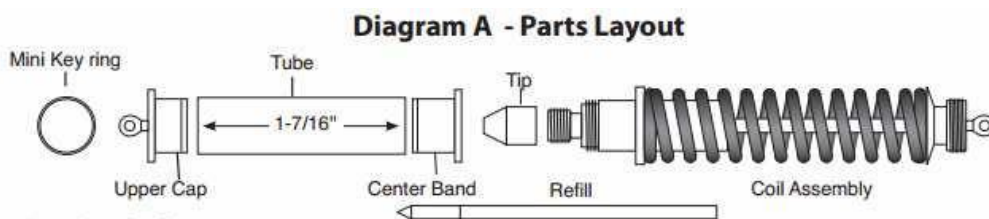
- 7mm, Pen Mandrel
- Drill bit 27/64 DB27/64
- 2 pc Bushing Set BU133

### Preparing the Blank:

- Cut 3/4" or larger square blank to the length of the brass tube (add 1/16" for trimming off)
- Drill a 27/64" hole through the blank
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank
- When the glue dries, square off the blanks.
- You can use a 7mm barrel trimmer with the proper sleeve or a universal pen blank squaring jig with a power disc sander. Take the wood down flush with the ends of the brass tube.

### Turning the Blank:

- Mount the blank and bushings on a pen mandrel.
- Thread on the knurled nut and hand tighten to hold all items in place.
- Slide the tailstock snug to the mandrel shaft. (do not over tighten, it could damage the mandrel). Lock in place.
- Turn down the wood, flush with the bushings using lathe tools and gradual higher grits of sand paper.
- Finish the barrel with your choice of polish



### Assembly:

- Layout parts according to diagram A.
- Press the center band into the larger dia. of the barrel.
- Press the upper cap into the opposite side of the barrel.
- Slide the mini key ring through the hole in the upper cap.
- Unscrew the tip and insert the refill into the opening of the coil assembly.

Push in until refill is seated tight. Replace the tip.

- The pen is ready to use. Post the top end of the pen when in use.