



# Houtdraaiwerken-penkits

## BP39 Streamline Pen Kits Assembly Instructions

### Required Accessories

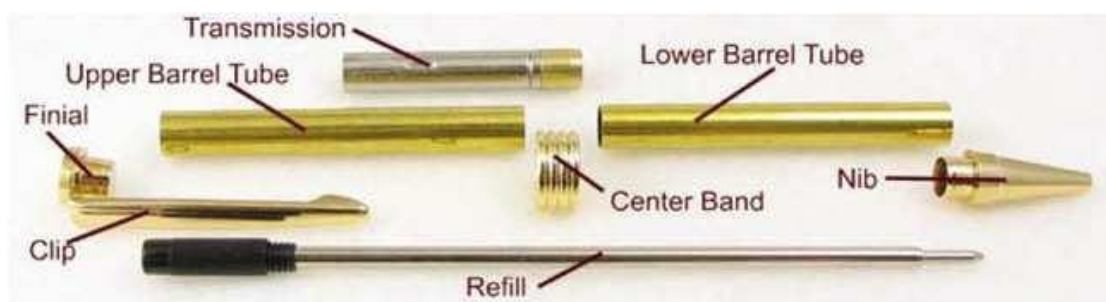
- 7mm, Pen Mandrel
- bushing set BU39
- 7mm drill bit DB007 or TSDB007

### Preparing the Blanks:

- Use a 5/8" square stock. Cut blanks to the length of the tube, adding 1/16" for trim.
- Drill a 7mm hole lengthwise through each blank.
- Use epoxy or a gap filling cyanoacrylate (super glue), to glue the tube into the blank. Coat the outside of the tube with epoxy and insert the tube into the blank with a twisting motion to spread the glue until flush. Allow it to dry.
- With a barrel trimmer, square the ends of the blanks to the tubes.

### Turning the Blanks:

- Slide 7mm spacer bushings onto the mandrel shaft, followed by the end bushing. Slide on one blank. Next, add the center bushing. Place the upper blank followed by the end bushing. Add additional spacer bushings as necessary to reach the mandrel threads.
- Thread on the locknut hand tight. Bring the tailstock in snug to the mandrel, lock in place. Tighten the lock nut for turning.
- DO NOT over tighten the locknut, it could damage the mandrel.
- Turn the barrels close to the bushing diameter with sharp tools; sand the barrels to match the bushing diameter.
- Finish the wood with your choice of polish



## **Assembly**

1. Press the nib into the smallest end of the longest blank
2. Press the twist mechanism into the other end of this same blank up to the notch in the transmission. It is best to "creep up" on this pressing operation by pressing to near the right dimension ,inserting the refill ,twisting the transmission open, and checking the exposed tip at the nib. You want about 1/8" of the refill tip exposed ,but make sure the tip is fully enclosed in the nib when it is retracted . This method can make up for slight errors made in trimming the barrel to the proper length.
3. Place the center band on the exposed transmission.
4. Press the final into the clip
5. Now press the assembly into one end of the other blank
6. Align any grain or pattern with the pen retracted , finish the pen