Houtdraaiwerken-penkits

BP142 Annular Twist Pen Kits Assembly Instructions

Required Accessories:

Drill Bit: 3/8"

Bushing BU142

Preparing the Blank:

Cut 1 blank to the length of the tube and add 1/16" for squaring off.

Drill a 3/8" hole lengthwise through the blank.

Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise inside the blank.

When the glue is dry, square the end of the blank. Use a 3/8" barrel trimmer or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly). Use a barrel trimmer to clean the inside of the tube.

Turning the Blank

Mount the bushings and blanks according to diagram B.

Thread on the knurled nut and hand tighten to hold all components in place.

Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.

Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel)

Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)

Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.

Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.
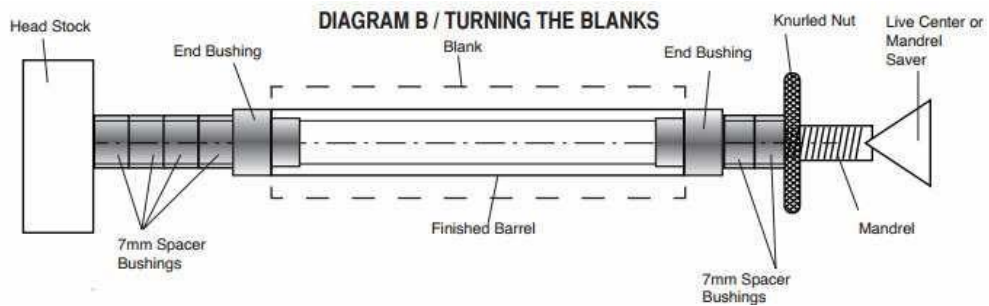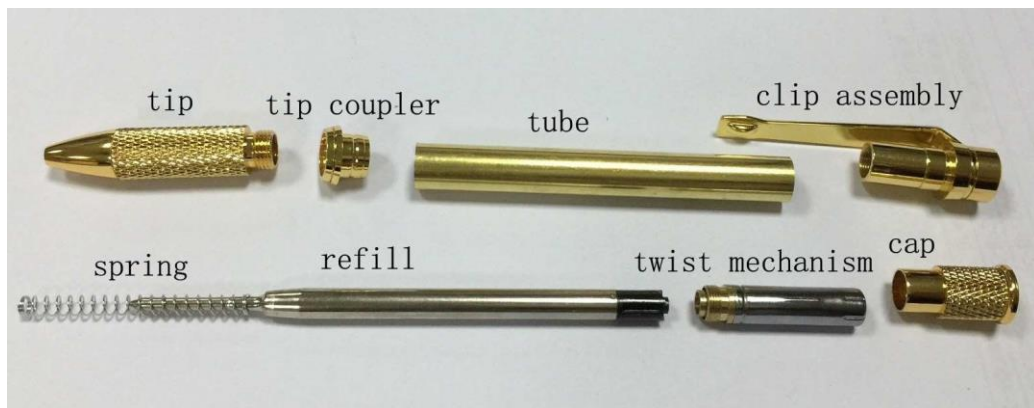
Refer to polish instructions

Diagram A

Assembly

Layout parts according to diagram A

Press the tip coupler into either end of the barrel.

Press the clip assembly into the opposite end of the barrel.

Screw the tip into the tip coupler.

Slide the spring onto the refill, drop in through the opening at the upper barrel.

Insert and screw in the mechanism, following the refill to bottom.

Press the cap over the extended end of the mechanism, push into bottom.

The pen is ready to use by turning the knurled twist cap to extend or retract the refill.