

## Berea Hardwoods Cartridge Pen (Berea #0906/B-xx)



Needed: Mandrel-A  
Bushings-#5753  
Drill-10 MM

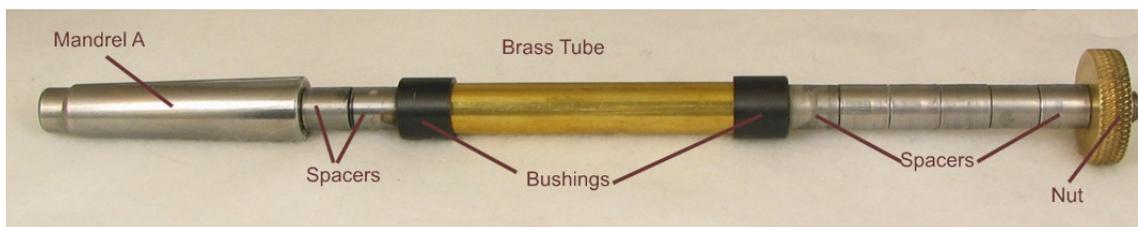
Material Size- 5/8" x 5/8" (Note: 3/4" x 3/4" is better)

### Preparing the Material Blank

1. Cut the material blank a little longer, approximately 1/4", than the tube.
2. Drill the blank through the center, lengthwise, with a 10 MM bit
3. Polish the brass tube with sandpaper. This can be done by hand or on a power machine such as a belt sander. The purpose of the sanding is to clean off the oxidation and roughen the tube so that the glue will have a better adhesion surface.
4. Plug the ends of the tube with the material of your choice. Some use base wax, a dental product, or Play Dough, or even a slice of potato. Just push the ends of the tube into a thin section of the material. This will form a plug to keep the glue from getting into the tube.
5. Clean the tube, after plugging, with acetone or alcohol on a rag.
6. Prepare your glue. We recommend two-part epoxy glue that is available in all hardware stores. Use a fast drying type, one hour or less. Be sure to mix it thoroughly. (A Post-it Note Pad makes an excellent mixing place. When you are finished just tear it off and throw it away.) Polyurethanes and thick flexible CA's can be used, but they each have their drawbacks.
7. Place some epoxy into the blank using a small piece of dowel or other small stick.
8. Roll the tube in the epoxy.
9. Insert the tube with a twisting motion until it is almost in the material blank. Then use the dowel to push it in until the end is flush with the blank. Use the stick to rake off the excess glue even with the blank and the tube.
10. Push the brass tube through the blank until the other end is flush with the blank. Then rake the glue flush with that end. Now push the tube back into the blank until the tube is equidistant between both ends of the blank.

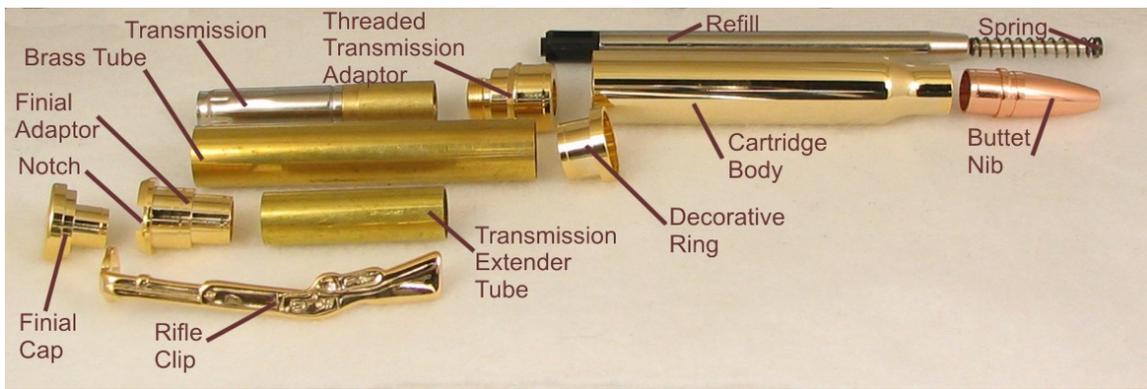
11. Move it aside for 60 minutes until the epoxy has had time to reach its maximum strength.
12. If you are using CA glue, the wait is only about 60 seconds. When using polyurethane the wait will be about 24 hours.
13. When the glue has cured use a hobby knife to remove the plugs from the ends. It is also a good idea to clean the tubes with a brass gun cleaning brush to remove any glue that may have gotten into the tubes.
14. Not cleaning out all glue from the tubes is the most common cause of pen failure. BE CERTAIN that all dried glue is removed from inside the tubes before proceeding.
15. Using a barrel trimmer of the proper size, face off the ends of the blank until you can just see the bright brass end of the tube. STOP facing at this point. Your Scoop's proper beauty is dependent on having the proper length tube. This facing operation can also be done with the proper jig and a disk or belt sander.
16. Not having the proper tube length is the #2 cause of pen failure. Sanding, on a disk sander, using a jig to hold the tube square with the disk, is a more sure way of getting the proper length. It should be tried if you have any doubt as to your abilities to square the material with the barrel trimmer.
17. Another good method of squaring the ends of the blank is to turn the blank until it is just round. Using a miter gauge to maintain the blank perpendicular to the sanding disk, just touch the ends to the disk. Once the blank is square and you can see the ends of the tube brighten, then return the blank to the mandrel and finish the turning until the desired contour is accomplished.

### **Turning the Material Blank**



Mandrel Setup

1. Assemble the blank on the mandrel using the 26A bushings. Place the bushings on either end as they are the same size.
2. Tighten the tailstock before tightening the blank on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blank.
3. Turn the blank to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
4. After turning the blank, sand the surface in progressive steps until you get to 400 or 500 grit.
5. If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
6. Apply the finish of your choice and polish.
7. Remove the blank from the mandrel.



Parts Diagram

### Assemble the Pen

Please refer to the Parts diagram

This pen has many parts, but don't be intimidated by the number of pieces. It is really very simple to assemble.

1. Press the threaded transmission adaptor into the large end of the cartridge body up to the boss.
2. Press the bullet nib into the other end of the cartridge body up to the boss.
3. Insert the refill, with the spring in place, and screw on the transmission. Check for proper operation of the transmission and refill.
4. Press the decorative ring into one end of your finished blank.
5. Press the transmission extender tube onto the small end of the finial adaptor.
6. Now, press this assembly into the other end of your blank. Be sure to place the notch in the finial adaptor where you want the clip to be located.
7. Place the finial cap through the hole in the rifle clip.
8. Align the clip with the notch in the finial adaptor and press the finial cap home.
9. Now your pen is finished!

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