



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.

Assembly

- Layout parts according to diagram A
- Press the cap nut into either end of the barrel using a pressing block as described below.
- Do not press the cap nut directly over the threads. Cut a block to about 1/2" to 5/8" Long. Drill an 8mm hole through the block. Place the block over the threads and press against the block.
- Remove the tip protector of the refill, slide the spring onto the refill and drop the refill into the opening at the front end assembly and engage the mechanism. Place the mechanism over the refill. Screw the mechanism into the front end assembly.
- Attach the clip over the exposed cap nut threads and screw the cap over the clip.
- Press the barrel over the front end assembly and engage the mechanism.
- The pen is ready to use by twisting the ends to extend or retract the refill.

Diagram C / Bushings # (only use the 2 end bushings)

