

Pen Kit Instructions

Code: 104361 (Gunmetal) (D-RJPU-MB)



What's Required
• Pen Mandrel
• Bushings (code 104370)
• Suitable pen blank 3-5mm longer than your brass tube
• Drill Bit Size 9/32"
• Barrel Trimmer
• Z-Poxy 5 or 30 Minute Resin
• Abrasives 150g, 240g, 400g, 600g Wet & Dry
• 1/4" Bowl Gouge
• 1/2" Skew Chisel
• Parting Tool

Disc Stylus Ball Pen Kit



Bushings



(Pen Blank/s not included in kit)

Pen Blank 3-5mm longer than the brass tube/s

Drilling the Blanks on a Lathe

Note: If you have a 'Pillar Drill' you can drill the blank/s using the 'Quick Action Pen Blank Vise'



1. Mount the blank in the chuck jaws.



2. Turn a pilot hole in the centre of the blank.



3. Mount the drill bit in the lathes tail stock and slide the assembly so the end of the drill bit lines up with the pilot hole. Lock the tail stock in position.



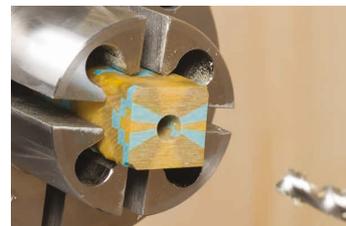
4. Start up your lathe and drill through the centre of the blank.



5. Remove any build up of material around the drill bit.



6. Once drilling is complete remove the drill from the blank by sliding the tail stock back then switch off the lathe. Remove the blank from the chuck.



Gluing the Blanks



1. Use Z-Poxy 5 or 30 Min Epoxy Resin or another of your choice.



2. Place equal amounts of resin and hardener on a scrap piece of wood.



3. Mix the two until the resin turns white.



4. Rotate the brass tube/s and spread the glue equally around.



5. Insert the brass tube into the pre-drilled hole in the blank.



6. Push the tube in using another brass tube or a piece of wood.



7. Remove any excess glue and place the blank down to harden off.



8. Leave the blanks for 30 minutes to fully harden.

Continues Over...

Barrel Trimming



1. Use a barrel trimmer to remove excess glue from the blanks



2. Insert the drill shaft down into the brass tube and power up the drill.



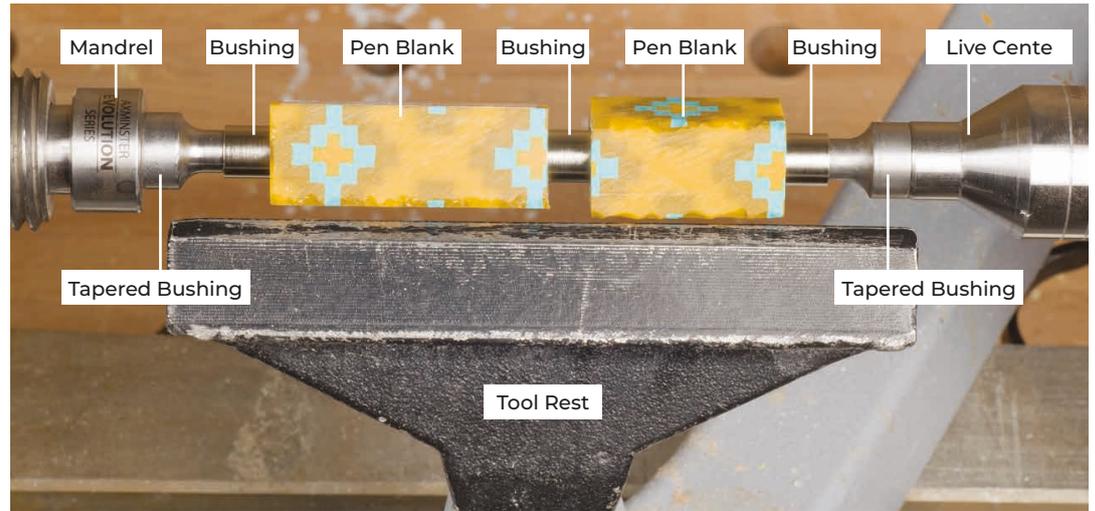
3. Remove the excess glue to square up the ends of the barrel.



4. End of blank barrel clean and square.

Lathe Assembly

If you are using the Deluxe Pen Mandrel, fit the tapered end into the headstock. Make sure the tapered bushings is in place to protect the collet using the correct bushing set. If you are using the Evolution Pen Mandrel insert the fixed tapered end into the headstock. Assemble the bushings and pen blank/s as illustrated. Bring the tail stock with the live centre into contact with the mandrel which will centre the whole assembly. Clamp the tail stock in position. Tighten the end collet and the end nut if using the Deluxe Pen Mandrel.



Turning the Blank



1. Rough down the pen blank/s using a 1/4" bowl gouge. The flute of the gouge should face 2 o'clock with the handle of the chisel held low and the tool presented at a 45° angle to the blank. Alternately you can use a 3/4" roughing gouge to rough down the pen blank/s.



Planing Cut



2. Adjust the rest to centre height and using the bottom half of the cutting edge of 1/2" skew chisel to take small, clean cuts. Start the cut with the bevel rubbing then lift the handle until you see dust or shavings appear. Continue this along the length of the pen blank/s until its slightly bigger than the diameter of the bushings.



Sanding and Finishes

Acrylic & polyester- Start by sanding with the 600g abrasive and then use the micro mesh (code 211364) wet. Keep wetting the micro mesh as we don't want to allow dust to melt back onto the pen blank. Finish with burnishing cream on the 1200g micro mesh and then use a rag to buff.

Timber- Sand up through the grades with the cloth backed abrasives starting at 150g to 240g to 400g and then 600g. Finish with the 1000g wet and dry abrasive and the friction polish.



1. Start with the 600g abrasive then using the micro mesh wet abrasives.

2. Finish with burnishing cream on the 1200g micro mesh and rag to buff.

Assembly



Axminster Deluxe Pen Press
Code 106069

Step 1



Fit end cap and clip into the shorter of the two turned blanks

Step 2



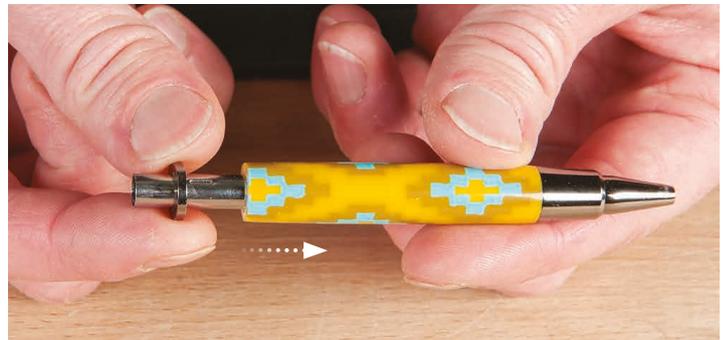
Fit nib into the longer of the two turned blanks

Step 3



Fit the twist mechanism into the opposite end of the nib on the longer blank.
(tip: make sure the twist mechanism doesn't go in too far or the pen refill will not retract)

Step 4



Place the decorative ring over the back of the twist mechanism

Step 5



Screw the refill into the twist mechanism checking to see if the nib comes out when twisted. You may need to carefully push the mechanism in a little further.

Step 6



Fit the back end of the pen onto the assembled pen





Pen Kit Tools



Axminster Evolution Series Compression Pen Mandrel 1MT or 2MT



Micro-Mesh Soft Touch Pad Abrasives



Axminster Woodturning Chuck Pen Jaws



Axminster Deluxe Adjustable Pen Mandrel 1MT or 2MT



Axminster Barrel Trimmer



Z-Poxy Epoxy Resin



1/4" Bowel Gouge

3/4" Roughing Gouge

1/2" Skew Chisel

Parting Tool



Pen Blanks



Quick Action Pen Blank Vice

Axminster Tools, Axminster, Devon, EX13 5PH

axminstertools.com