

Native Pens

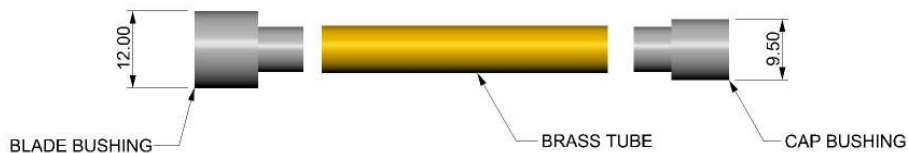
7.5mm Letter Opener Instructions

Required:

¼" Mandrel 7.5mm Drill Bit Pen Mill 7.5mm Letter Opener Bushings

Turning the Letter Opener Barrel.

1. Cut a blank slightly longer than the brass tube.
2. Drill the blank through the centre, lengthwise, with a 7.5mm bit.
3. Sand the surface of the brass tube. This can be done by hand or mounted in the bushes on the lathe. This will clean off any oxidation and roughen the surface for a better glue bond.
4. Bond the tube into the timber blank. This can be done with CA or two-part epoxy glue. Insert the tube with a twisting motion then push it in until slightly under flush. About equal distance in from each end of the timber blank.
5. Allow glue to cure as required by glue manufacturer.
6. Clean all the dried glue from inside the brass tube. Not cleaning out all the glue from the tube is the most common cause of assembly failure.
7. Using a Pen Mill, face off the ends of the blank until you can just see the bright brass end of the tube. STOP facing at this point. Another method to square the ends is sanding on a disc sander against a square fence or using a jig to hold the tube square to the disc then lightly touching the end with the Pen Mill to finish them.
8. Once the blank is square and you can see the ends of the tube brighten you can mount the blank to the mandrel.



9. Once the basic shape is reached, remove approx 3mm of the blank at the Blade Bushing end. It is recommended that the wood to be removed is done once the blank is turned and sanded down to the bushings, this way the shoulder of the blank can be kept square and not rounded off by sanding.



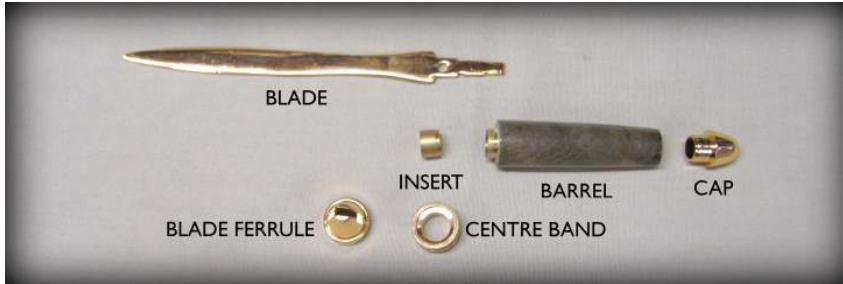
10. Finish the Opener Barrel to your specifications. Remove the barrel from the mandrel and it is ready for assembly.

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Assembly of the Letter Opener.

1. Lay out the parts as shown below.



2. Press the Cap into the upper end of the barrel.



3. Press the Centre Band over the protruding end of the brass tube.



4. Press the Insert, rebated end first, into the brass tube. Use a small socket or short piece of 6mm rod when pressing. NOTE: this press is quite hard as this also locks the Centre Band in place. It is recommended that the press be done in small steps and alignment checked with each step.



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5. Slip the Blade Ferrule onto the Blade.



6. Screw the Blade into the Insert and tighten until the Blade Ferrule is firm against the Centre Band.



7. Your Letter Opener is complete and ready for use!