

# Native Pens

## Comfort Pen Instructions

### Required:

¼" Mandrel

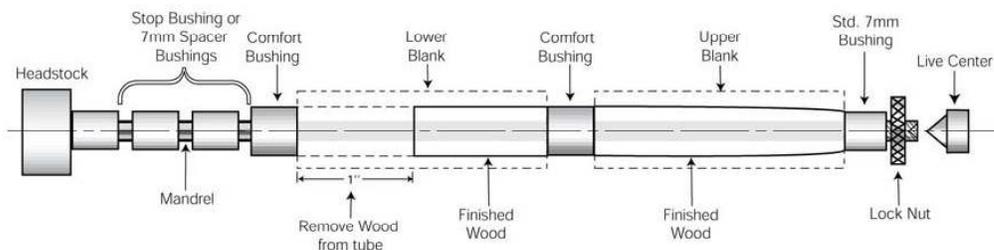
7mm Drill Bit

Pen Mill

Comfort Bushings

### Turning the Pen Barrels.

1. Cut a pen blanks slightly longer than the brass tubes.
2. Drill the blanks through the centre, lengthwise, with a 7mm bit.
3. Sand the surface of the brass tubes. 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 tubes into the timber blanks. 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 tubes. Not cleaning out all the glue from the tubes is the most common cause of pen failure.
7. Using a Pen Mill, face off the ends of the blanks until you can just see the bright brass end of the tubes. 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 blanks are square and you can see the ends of the tube brighten you can mount the blanks to the mandrel.

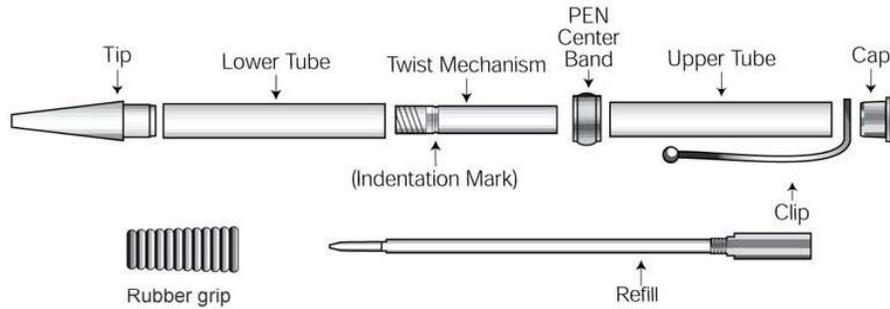


9. It is recommended that the wood to be removed is done once the blanks are turned and sanded down to the bushings, this way the shoulder of the blank can be kept square and not rounded off by sanding.
10. Mark the lower blank where the wood must be removed the using a very fine parting tool, approx 1mm wide, to make the first cut at the 25mm or 1" mark. Then remove the rest of the timber with a parting tool down to the brass tube. Be sure to remove any glue from the tube also. Ensure the blank shoulder is kept square to match against the
11. Finish the pen to your specifications. Remove the barrels from the mandrel and it is ready for assembly.

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### Assembly of the pen.



1. Slip the Rubber grip, wide end first, over the exposed brass tube.
2. Press the Tip into the Lower Barrel tube against the rubber grip..
3. Press the transmission into the thick end of the Lower Barrel tube. Take care to press this in gradually, at stages screw in the refill to check the position of the exposed refill tip.
4. Slip the centre band over the transmission.
5. Press the Cap into the clip, then press the clip assembly into the clip end of the Upper Barrel tube.
6. With a twisting motion, slide the Upper Barrel onto the transmission.
7. You pen is finished.