

Native Pens

Prox Pen Instructions

Required:

1/4" Mandrel

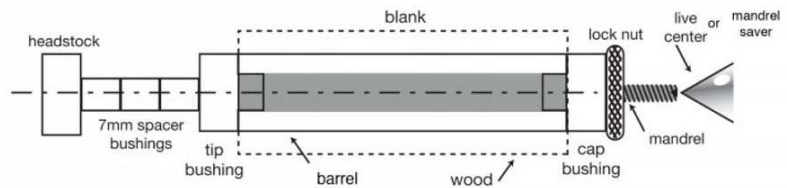
Ø9.5mm Brad Point Drill Bit

Pen Mill

ProX - Spiritual Bushings

Turning the Pen Barrels.

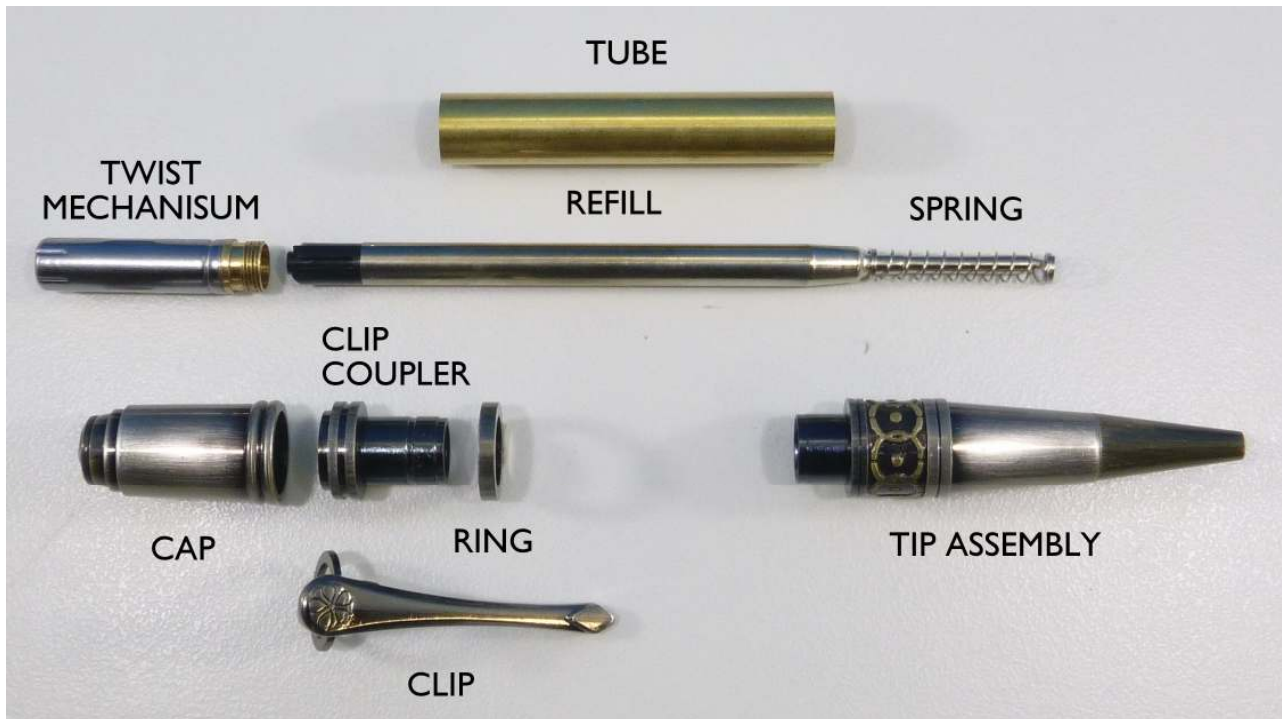
1. Cut a pen blanks slightly longer than the brass tube.
2. Drill the blank through the centre, lengthwise, with an Ø9.5mm brad point drill bit.
3. Sand the surface of the brass tube. This can be done by hand or mounted in the bushes on the lathe. This will clean off any oxidation and roughen the surface for a better glue bond.
4. Bond the tubes 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 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 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 blanks are square and you can see the ends of the tube brighten you can mount the blanks to the mandrel and finish the turning until the desired shape is reached.
9. Finish the pen to your specifications. Remove the barrel from the mandrel and it is ready for assembly.



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Assembly of the pen.



1. Lay out the parts as shown.
2. Press the Tip Assembly into one end of the Barrel.
3. Slide the Clip then Ring onto the Clip Coupler.
4. Press the Clip Coupler into the opposite end of the Barrel.
5. Place the Spring on the Refill then insert into the pen from the Clip Couple end.
6. Screw the Twist Mechanism into the Clip Coupler.
7. Place the Cap over the exposed end of the Twist Mechanism.
8. Your pen is finished.