

Native Pens

Slimline Pro Pen Instructions

Required:

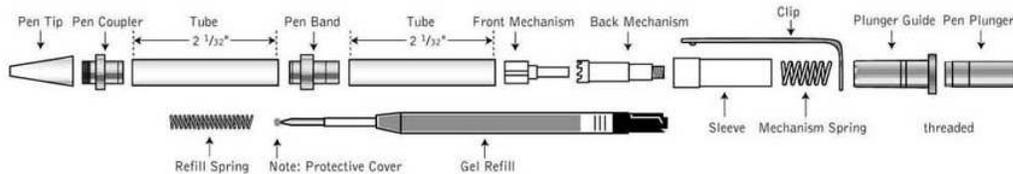
1/4" Mandrel

8mm Drill Bit

Pen Mill

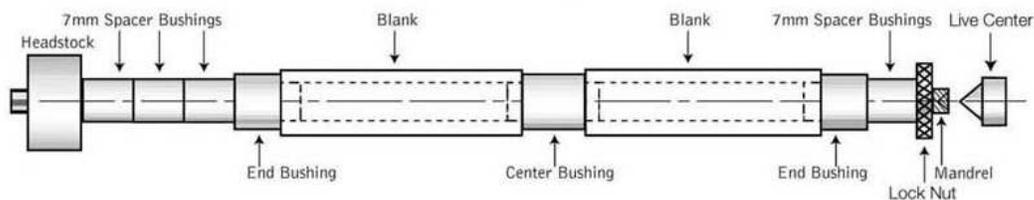
Slimline Pro Gel Bushings

Pen Parts



Turning the Pen Barrels.

1. Cut a pen blanks slightly longer than the brass tubes.
2. Drill the blank through the centre, lengthwise, with a 8mm 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 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 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.

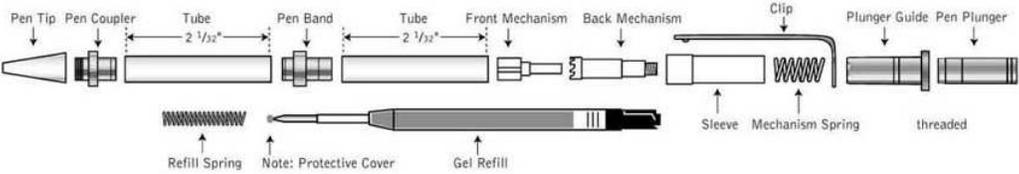


9. Finish the pen to your specifications. Remove the barrels from the mandrel and it is ready for assembly.

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Assembly of the pen.



1. Press the Pen Coupler, wide end first, into the Tip end of the Lower Tube.



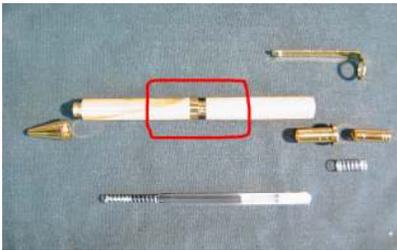
2. Press the Pen Centre Band, short end first, into the opposite end of the Lower Tube.



3. Insert the three (3) part plastic mechanism (Front Mechanism, Back Mechanism, Sleeve aligned as per picture), into the Upper Tube narrow end of the sleeve first, into the Centre Band end of the Tube.



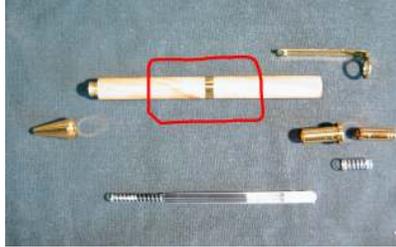
4. Offer up the Lower Tube with the long extension of the Centre Band protruding, slide the Centre Band into the Upper Tube. This will push the plastic mechanism further into the Upper Tube.



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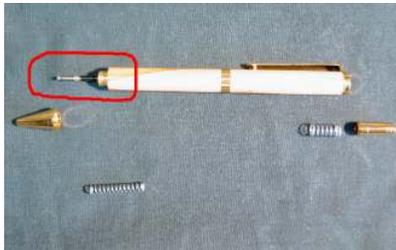
5. Press the Lower Tube and Centre Band into the Upper Tube.



6. Slide the Plunger Guide, narrow end first, into the Clip hole. Press the clip and guide assembly into the remaining end of the Upper Tube.



7. Insert the refill through the Pen Coupler and push the plastic mechanism towards the clip end until the threaded end of the back mechanism is close to the end of the plunger guide.



8. Drop the Mechanism Spring over the threaded stem of the Back Mechanism and screw the Pen Plunger onto the thread and tighten.



9. Slide the refill spring over the tip of the refill and screw on the Pen Tip.
10. The refill works with a click of the Pen Plunger
11. You pen is finished.