Native Pens

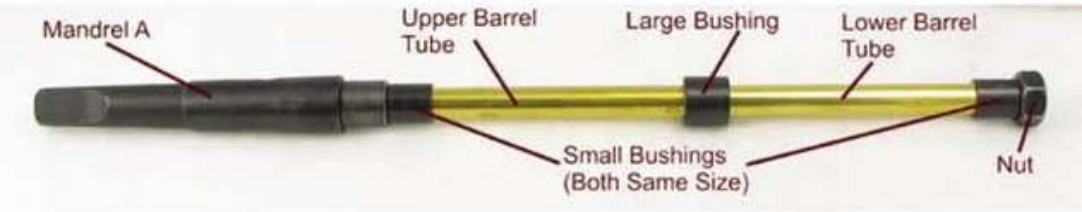
Streamline Pen Instructions

Required:

¼" Mandrel 7mm Drill Bit Pen Mill Streamline Bushings

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 7mm 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 a 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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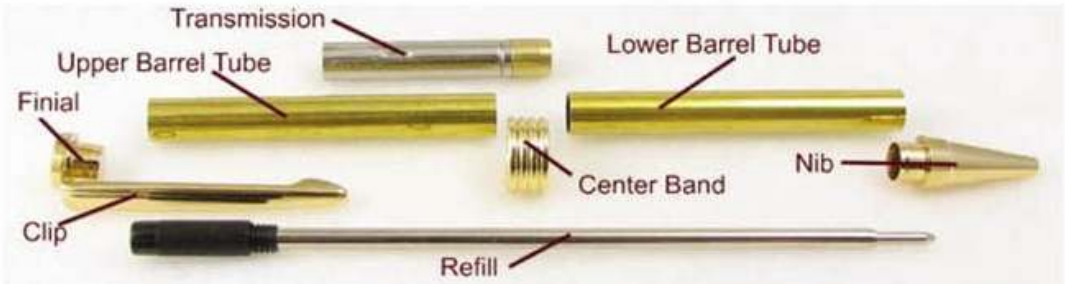
Assembly of the pen.



1. Press the nib into the smallest end of the Lower Barrel tube.
2. Press the transmission into the thick end of the lower tube. Take care to press this in gradually, at stages screw in the refill to check the position of the exposed refill tip.
3. Slip the centre band over the transmission.
4. Press the Finial into the clip, then press the clip assembly into the small end of the upper barrel.
5. With a twisting motion, slide the upper barrel onto the transmission.
6. You pen is finished.