



## Aston Pen Kit Instructions

### Required Materials

- 7mm pen mandrel
- Set of Aston Pen Kit bushings
- 10mm and 15/32" drill bit
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
- Sanding supplies and finish



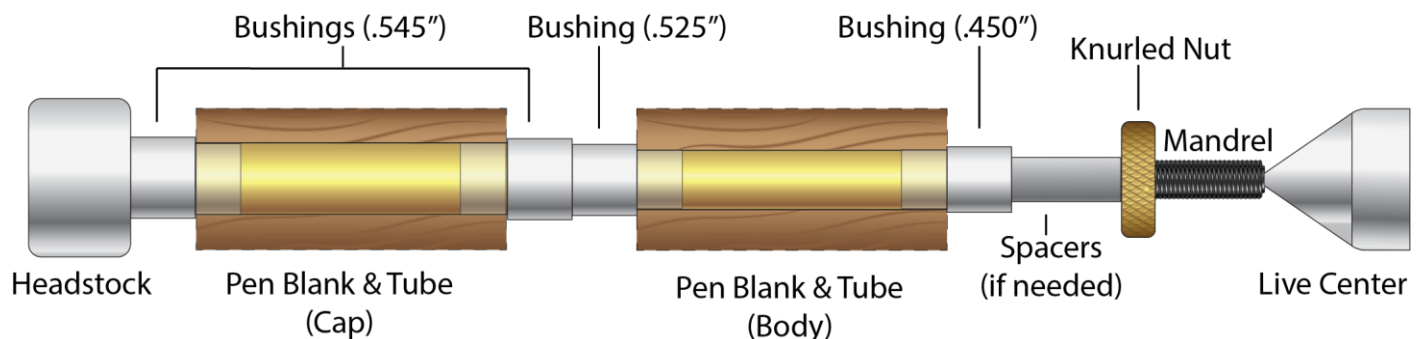
### Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill a 10mm hole lengthwise through the longer blank and a 15/32" hole through the shorter blank
3. Rub the brass tubes with low-grit sandpaper to roughen them
4. Apply a line of glue to the brass tubes and insert each tube into the middle of the blanks with a twisting motion to spread the glue throughout the blanks
  - Ensure the inside of the tubes are free of any glue
5. Square off the ends of each blank with a barrel trimmer or sander to be flush with the brass tube

### Turning the Blank

Follow diagram A below to set up the blanks on the mandrel for turning.

Diagram A



1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish



## Assembly

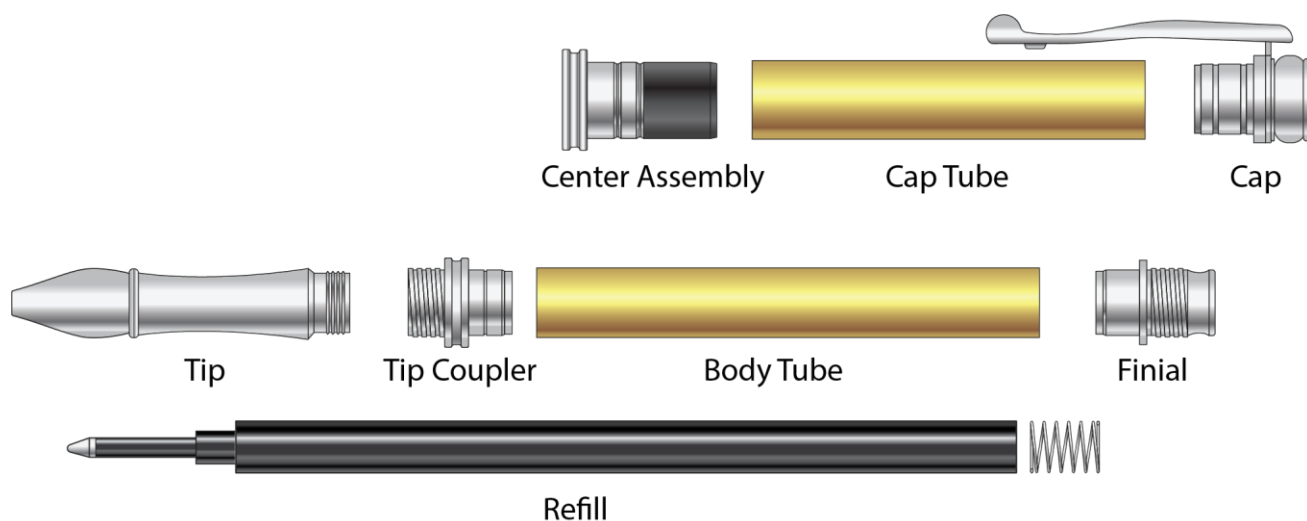
Follow diagrams B and C below for assembly. Press parts using a pen press, vise, or clamp.

Diagram B



1. Unthread the Tip Coupler, Tip, and Center Assembly from each other as shown in diagram B

Diagram C



2. Press the Finial onto the thinner (.450") end of the Body Tube (longer tube)
3. Press the Tip Coupler onto the thicker end (.525") of the Body Tube
4. Insert the spring then Refill through the Tip Coupler
5. Thread the Tip back onto the Tip Coupler
6. Press the Center Assembly onto one end of the Cap Tube (larger diameter tube)
7. Press the Cap with clip onto the opposite end of the Cap Tube

## Additional Information

- The cap will thread onto both ends of the pen
- Pen uses a standard rollerball refill (such as the Schmidt 5888)
  - To replace refill, unthread the Tip