Elegant American Pen Kit Instructions

Required Materials

- 7mm pen mandrel
- Set of Elegant American Pen Kit bushings
- 8mm drill bit
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
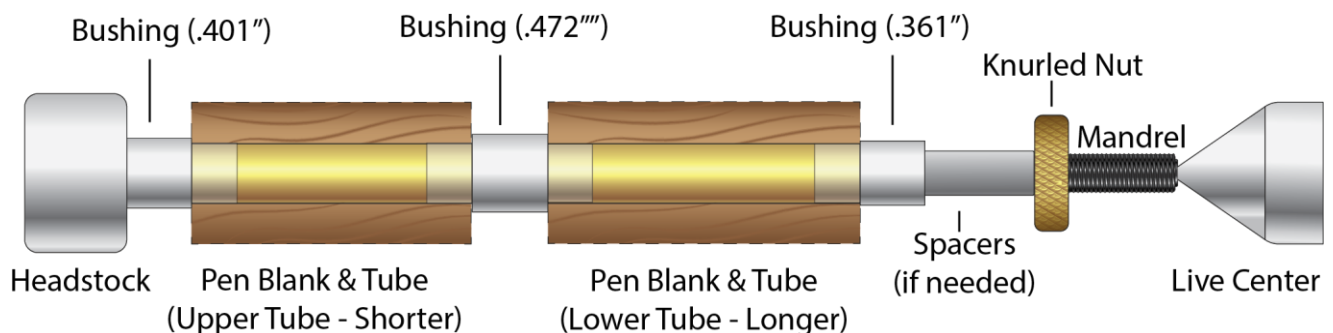- Sanding supplies and finish

Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 8mm hole lengthwise through each 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

Bushing (.401") Bushing (.472"") Bushing (.361") Knurled Nut Mandrel

Headstock | Pen Blank & Tube (Upper Tube - Shorter) | Pen Blank & Tube (Lower Tube - Longer) | Spacers (if needed) | Live Center
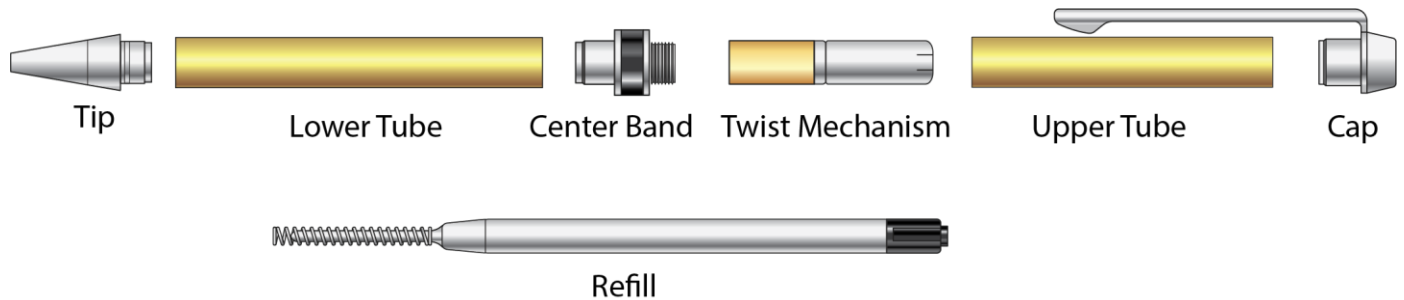
1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish

Assembly

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

Diagram B

Tip   Lower Tube   Center Band   Twist Mechanism   Upper Tube   Cap

Refill

1. Unthread the Center Band from the Twist Mechanism
2. Press the unthreaded end of the Center Band onto the thicker end (.472") of the Lower Tube (longer tube)
3. Press the Tip onto the thinner end (.361") of the Lower Tube
4. Place the spring over the Refill and insert through the Center Band
5. Thread the Twist Mechanism onto the Center Band
6. Press the Cap onto the narrower end (.401") of the Upper Tube (shorter tube)
7. Press the Upper Tube onto the exposed Mechanism. This can be done by hand, but a pen press or vise may also be used

Additional Information

- Pen uses a Parker-style ballpoint refill
  - To replace refill, pull off the Upper Tube and unthread the Twist Mechanism