



## Jr Milton Pen Kit Instructions

### Required Materials

- 7mm pen mandrel
- Set of Jr Milton Pen Kit bushings
- 10.5mm and 12.5mm drill bits
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank (2 may be necessary depending on length of blanks)
- Pen press, vise, or clamp
- Sanding supplies and finish



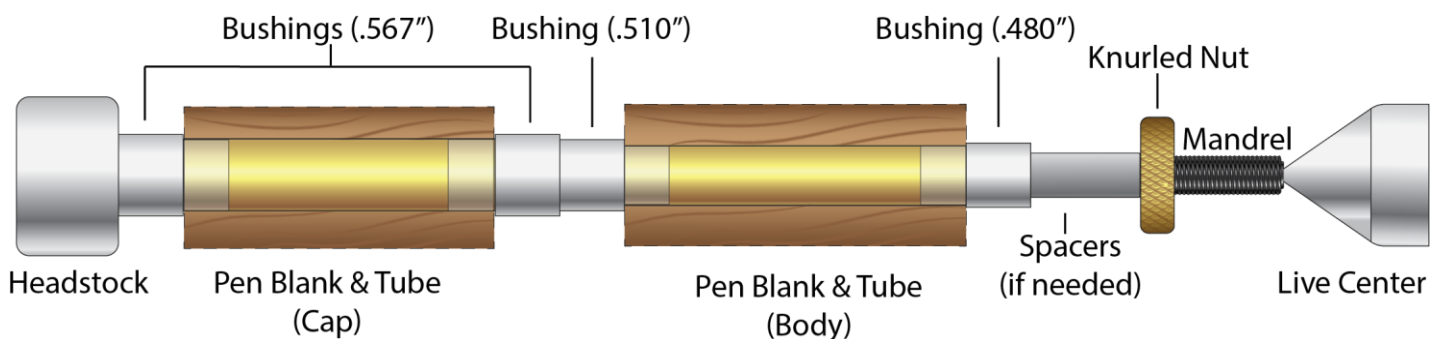
### Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 10.5mm hole lengthwise through longer blank and a 12.5mm hole lengthwise 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 respective blank with a twisting motion to spread the glue throughout the blank
  - 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 tubes

### Turning the Blank

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

Diagram A



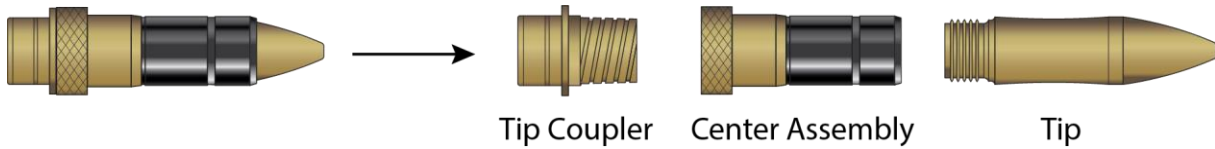
1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish



## Assembly

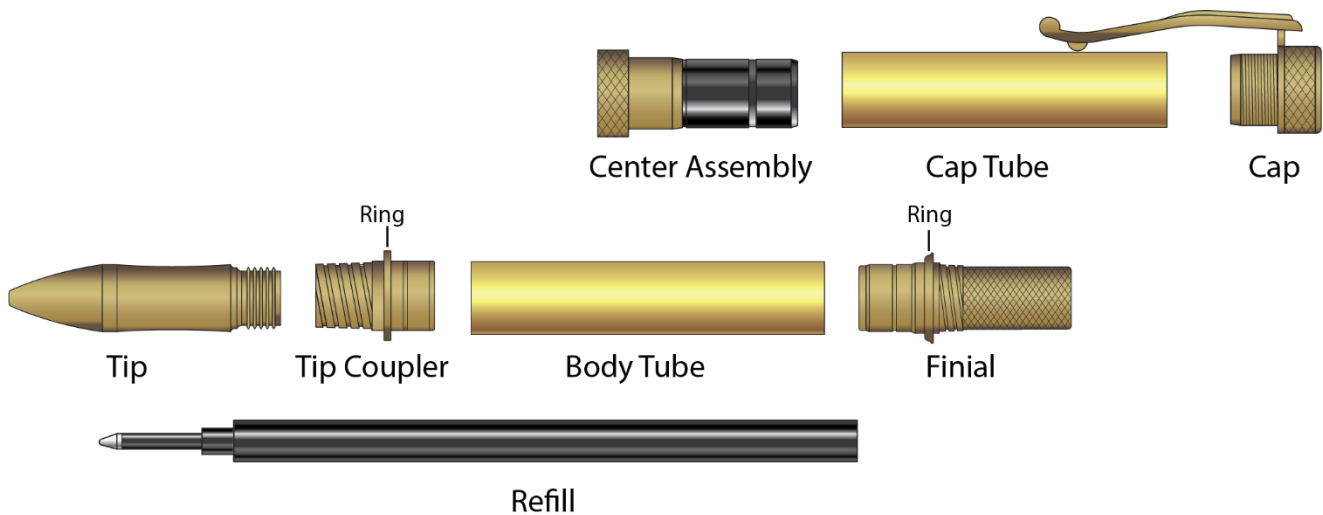
Follow diagrams B and C below for assembly. Press parts using a pen press, vise, or clamp.

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 with Ring onto the slightly narrower end (.480") of the blank/Body Tube (longer tube)
3. Press the Tip Coupler with Ring onto the slightly thicker end (.510") of the blank/Body Tube
4. Insert the 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 (shorter tube)
7. Press the Cap with clip onto the opposite end of the Cap Tube

## Additional Information

- Pen uses a standard rollerball refill (such as the Schmidt 888)
  - To replace refill, unscrew the Tip
- The cap will post to both ends of the pen