

Magnetic Pen Kit Assembly Instructions

**Required Materials**

* 7mm pen mandrel
* Set of Magnetic Pen bushings
* 10.5mm 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 tube, plus an additional 1/16” on each end for squaring off
2. Drill 10.5mm hole lengthwise through blank
3. Rub the brass tube with low-grit sandpaper to roughen it
4. Apply a line of glue to the brass tube and insert into the middle of the blank with a twisting motion to spread the glue throughout the blank
	* Ensure the inside of the tube is 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 blank on the mandrel for turning

**Diagram A**



1. Turn down the blank to the desired shape using lathe chisels, ensuring each end is flush with the bushings
	1. Finish with sanding (wet or dry) and choice of polish



**Assembly**

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

**Diagram B**



1. Unscrew the Couplers from the Tip and the End Cap
2. Press each Coupler into opposite ends of the Tube
3. Screw the End Cap onto the Coupler
4. Pull the cover off the Refill. Insert the Spring then Refill into the Tube (the Spring should sit with the wider part near the End Cap)
5. Screw the Tip onto the other Coupler

Other Info

1. To replace Refill, simply unscrew the Tip from the Coupler

**Questions or issues? Email us at crookedmill@gmail.com**