

Marchesa Pen Kit Assembly Instructions

**Required Materials**

* 7mm pen mandrel
* Set of Marchesa bushings
* 7mm 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 7mmhole 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 tube 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**

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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**

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1. Press Tip onto one end of the Tube
2. Press the Twist Mechanism (brass end first) until the indentation line onto the opposite end of the Tube
3. Insert the Refill through the Twist Mechanism and screw into place
	1. Test for extension, and press the Twist Mechanism further as needed (with the Refill removed)
4. Press the Cap onto the Twist Mechanism

**Other Info**

1. Refill may be replaced by pulling off the Cap

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