



Pirate Pen Kit Instructions

Required Materials

- 7mm pen mandrel
- Set of Pirate Pen Kit bushings
- 3/8" drill bit
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
- Sanding supplies and finish



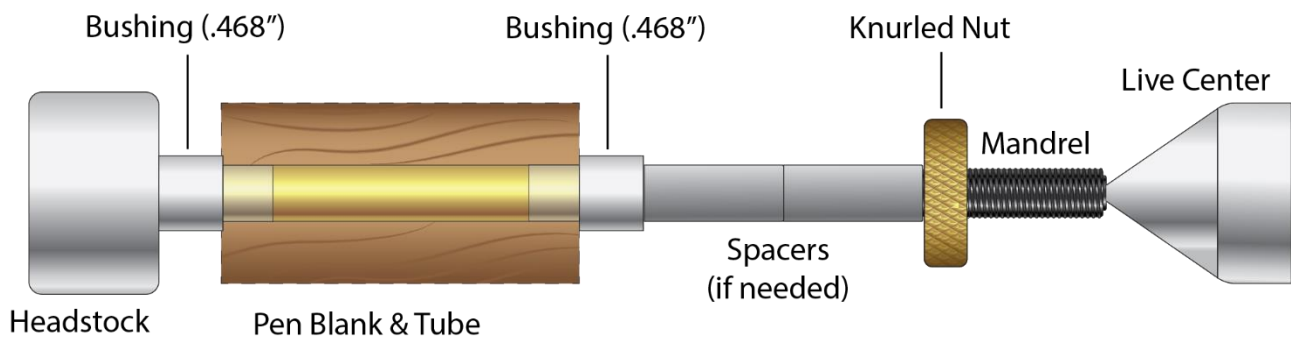
Blank Preparation

1. Cut blank to length of brass tube, plus an additional 1/16" on each end for squaring off
2. Drill 3/8" 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 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 the 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



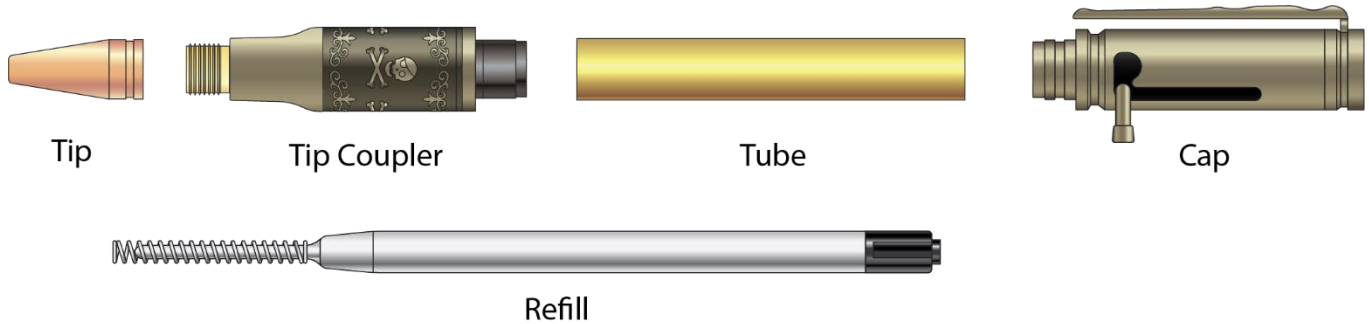
1. Turn down the blank to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blank, progressing from coarser to finer grits
3. Finish blank with choice of polish



Assembly

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

Diagram B



1. Unthread the Tip from the Tip Coupler
2. Press the Cap onto the Tube
3. Press the Tip Coupler onto the opposite end of the Tube
4. Insert the Refill with spring through the Tip Coupler and thread the Tip back into place

Additional Information

- Pen uses a Parker-style ballpoint refill
 - To replace refill, unscrew the Tip