

## DESKTOP GOLF PEN

### Instructions

#### Kit Features

- Affordable
- Easy to turn and assemble

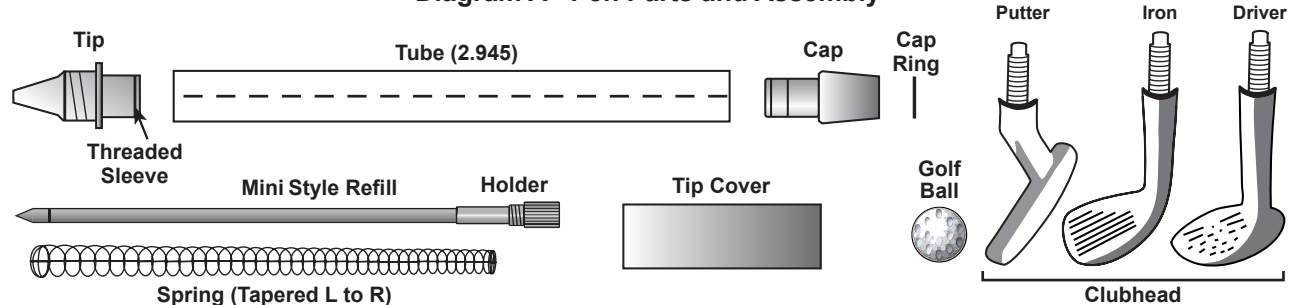
#### Accessories

- Black Golf Pen Box (BOX-GOLF)
- Golf Bag Pen Holder (PKSTANDGOLF)

#### Required Accessories & Materials

- 7mm mandrel
- 2-pc. Desktop Golf bushing set (PKDG-BU)
- 7mm drill bit (DB7MM)
- 7mm barrel trimmer or belt sander to square the ends of the blanks to the tubes
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Pen Parts and Assembly



#### BLANK PREPARATION

**Cut** your blank approximately 1/16" longer than the tube to allow for squaring with barrel trimmer or sander. Use a medium drill speed to **drill** the blank. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blank, **sand** the exterior of the brass tube to roughen its surface and use CA glue to **glue** the tube inside the blank. Sand or barrel trim to **square** the ends of the blank.

#### TURNING THE PEN

**Set up** the mandrel as shown in Diagram C. The Desktop Golf pen bushings are both the same size. **Turn** the blank down to the bushings, then **sand** with abrasives and **finish** with your choice of polish.

#### ASSEMBLY

(Line up finished parts according to Diagram A)

*To avoid damage to components when assembling, use a vise with covered jaws or one of WoodTurningz' pen presses.*

1. Press the Cap into one end of the Barrel.
2. Unthread the Threaded Sleeve from the Tip prior to pressing.
3. Press the Threaded Sleeve into the remaining open end of the Barrel. **Note:** that one end of the Threaded Sleeve has a slightly smaller diameter than the other end. The smaller end gets pressed into the Barrel first. It is important to do this, otherwise the tip will not thread into the Threaded Sleeve.
4. The spring slides over the refill. The narrower end of the spring goes on first and will be next to the Mini Refill Holder.
5. Insert the refill with the spring into the tip end of the Barrel.
6. Thread the Tip into the Threaded Sleeve. Careful not to cross thread.
7. Thread the Clubhead into the Cap with Cap Ring in place.
8. Thread the Tip Cover on to the Tip.
9. Remove the Tip Cover to write with the pen.
10. The Refill can be replaced by simply unscrewing the tip and replacing the refill. Be sure to retain the Mini Refill Holder.

Diagram B - Bushings

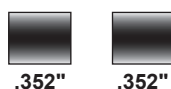


Diagram C - Turning the Pen

