

MOGUL PEN Instructions

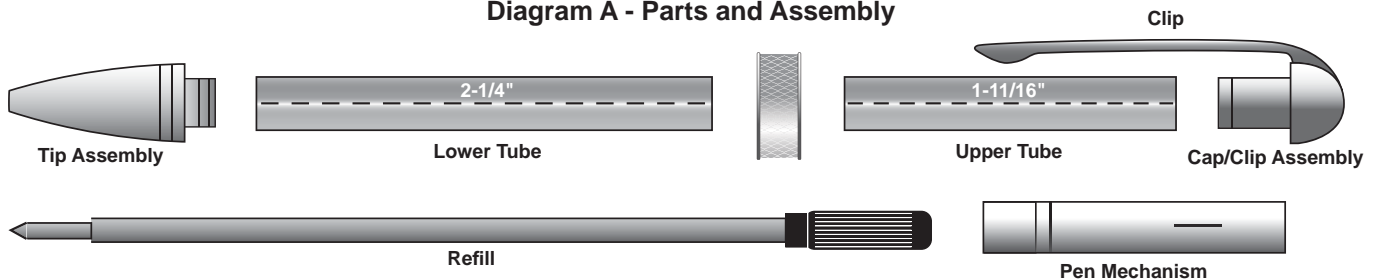
Kit Features

- Shows off the wood in a way a smaller pen cannot
- Elegant and distinctive
- Uses Cross® style ballpoint pen refill (RE-CROSS)

Required Accessories & Materials

- 7mm mandrel
- 3-pc. Designer bushing set (PKMOGULBU)
- 7mm drill bit (DB7MM or DB7MMCT)
- 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 - Parts and Assembly



BLANK PREPARATION

The tubes in a Mogul pen are of different lengths. The lower tube, which holds the pen tip and twist mechanism, is 2-1/4" long. The upper tube is 1-11/16" long. **Cut** your blanks approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. If using wood blanks, mark the blanks so it is easier to keep the grain running in the same direction when you place them on the mandrel for turning. Use a medium drill speed to **drill** the blanks. 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 blanks, **sand** the exterior of the brass tubes to roughen their surface and use CA **glue** to glue the tubes inside the blanks. Sand or barrel trim to **square** the ends of the blanks.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. Slide the tip bushing on the mandrel followed by the lower (longer) barrel, the center bushing, the smaller barrel, and then the cap bushing. **Turn** the blanks 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 tip into the narrow end of the lower barrel. Press the twist mechanism into the opposite end of the lower barrel. **Note:** The line on the mechanism is only a guide. Pressing it too far may cause your pen not to fully retract. Press the mechanism in, then screw the refill in and check it. Take the refill out, press a little more, and check it again. Repeat this until the refill extends a proper amount.
2. Insert the refill through the upper end of the twist mechanism and screw it in.
3. Slip the center band on.
4. Press the cap/clip assembly into the narrow end of upper barrel.
5. Push the barrels together.

Diagram B - Bushings

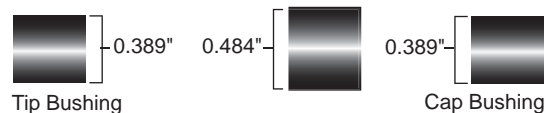


Diagram C - Turning the Pen

