

MAGNATE PEN

Instructions

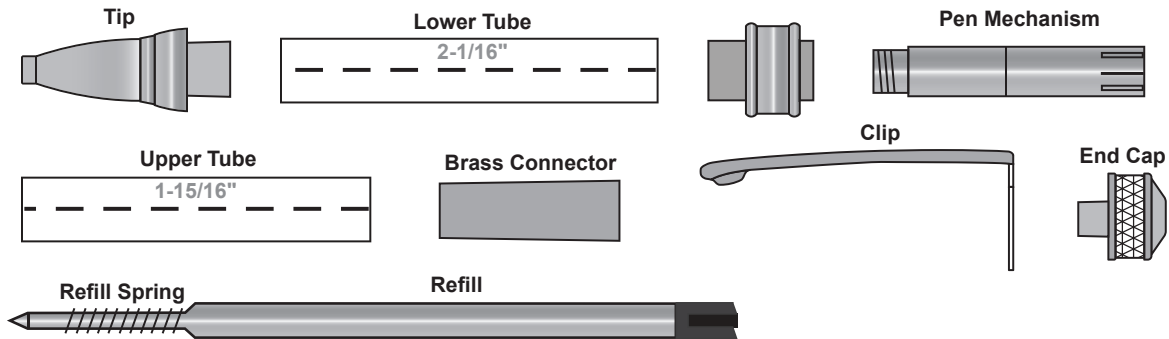
Kit Features

- Larger and more substantial than the Slimline pen
- Shows off the wood in a way a smaller pen cannot
- Uses smooth-writing Parker™ style refill (RE-PARK)
- Overall length: 5-5/8"

Required Accessories & Materials

- 7mm mandrel
- 3-pc. Magnate bushing set (PKMAGNATEBU)
- 3/8" drill bit (DB3/8)
- Universal trimming kit (BTRIMKIT8)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Pen Parts and Assembly



BLANK PREPARATION

The tubes in a Magnate pen kit are of different lengths. Make sure that as you cut the blanks for the tubes you orient them so that the longer 2" tube will be used as the lower pen barrel. The upper tube is a little shorter at 1.9" 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. In setting up your bushings, you will use the smallest of the three bushings (bushing 1) at the tip of the pen. The lower barrel goes on the mandrel followed next by the large combined bushing (bushing 2). Orient this middle bushing so the smaller end is toward the pen tip. Slide on the upper barrel, and then the last of the three bushings (bushing 3) will go at the top end of the pen. Keep in mind which pen barrel you are turning as the top and bottom. Remember, the upper tube is shorter than the lower tube. If you mistakenly get the short tube at the bottom of the pen, the refill will not retract properly. **Turn** the pen blank to the bushing diameter at the ends. **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 pen press or a vise with covered jaws.

1. Press the Tip into the lower end of the long pen barrel.
2. Press the twist holder into the opposite end of the lower pen barrel.
3. Drop the ink refill with the refill spring through the threaded twist holder and screw on the twist mechanism. Check for proper refill retraction. If it doesn't retract fully, the lower tube dimensions have most likely been shortened, or the upper and lower pen barrels have become switched.
4. Press the Brass Connector into the upper tube, with the thinner end inserted into the tube.
5. Fit the clip over post on End Cap. Press into Brass Connector.
6. Push the Upper Barrel over the Twist Mechanism.

Diagram B - Pen Bushings

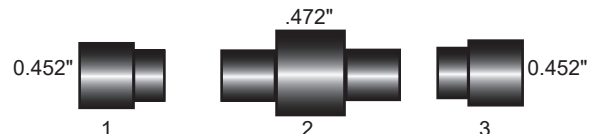


Diagram C - Turning the Pen

