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Havana Pen

*For use with the following:*

050-1420, 050-0315, 050-0335

Blank Size and Cutting: The blank size is determined by the project you are working on. Please refer to the Assembly instructions for blank and drill sizes.

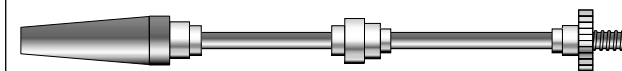
Drilling: Mark the center of the blank and drill to the required size. To help prevent blanks from overheating or splitting, clear the drill often and only drill deep enough for the tube length and trimming.

Gluing: The blank size is determined by the project you are working on. Please refer to the Assembly instructions for blank and drill sizes.

Trimming: Use a barrel trimmer to square the ends of the blank. This is the fastest and most accurate method. You may use a disc sander to sand the ends square with the tube. Note: Make sure you do not remove any of the brass tube as this may affect the finished item.

Mandrel Setup: Place the bushing(s) and barrel(s) onto the mandrel (see figure). Some projects and mandrels will require the use of a wood spacer, cut to length and drilled with a 7mm hole.

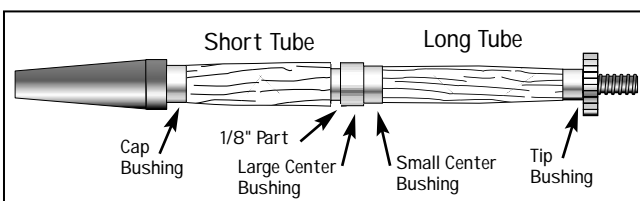
Figure 1



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Turning the Pen

1. Mount the bushings and the barrels onto a pen mandrel in the following sequence: cap bushing, short tube, large center bushing, small center bushing, long tube, tip bushing. Advance a cone live center into the dimpled end of the pen mandrel. Do not over tighten the tailstock or the mandrel nut as this may cause the mandrel to flex and produce an oval pen barrel.
2. Turn the short barrel round leaving the wood slightly larger than the center bushing. Make a 1/8" wide part in the short barrel all the way to the brass tube to accept the trim ring. Now turn the short barrel down to the size of the center and cap bushings.
3. Turn the long barrel down to the diameter of the bushings.
4. Sand the blanks using progressively finer grits then apply a finish such as friction polish or french polish.



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Assembling the Pen

Before Assembly:

Read the assembly instructions completely. Layout the pen parts according to the drawing. This will help familiarize yourself with the parts and how they will go together. We strongly recommend using a vice clamp with wooden jaws during assembly to avoid damaging the parts.

Assembly:

1. Press the plastic sleeve, unthreaded end first, into the larger diameter end of the short barrel.
2. Press the trim ring onto the exposed brass tube of the short barrel. If the fit is too loose, glue it into place.
3. Press the clip/cap into the top of the short tube.
4. Slide the large trim ring onto the end cap (internal step first). Press the end cap into the larger diameter end of the long tube.
5. Slide the small trim ring onto the coupler (internal step first). Press the coupler into the smaller diameter end of the long tube.
6. Drop the spring into the bottom of the long tube followed by the refill. Screw the writing tip into the coupler to finish.

Drills: 35/64" & 31/64"

Blank: 13/16" x 13/16" x 4 1/2"

Note: Stabilized blanks may not be large enough for this pen.