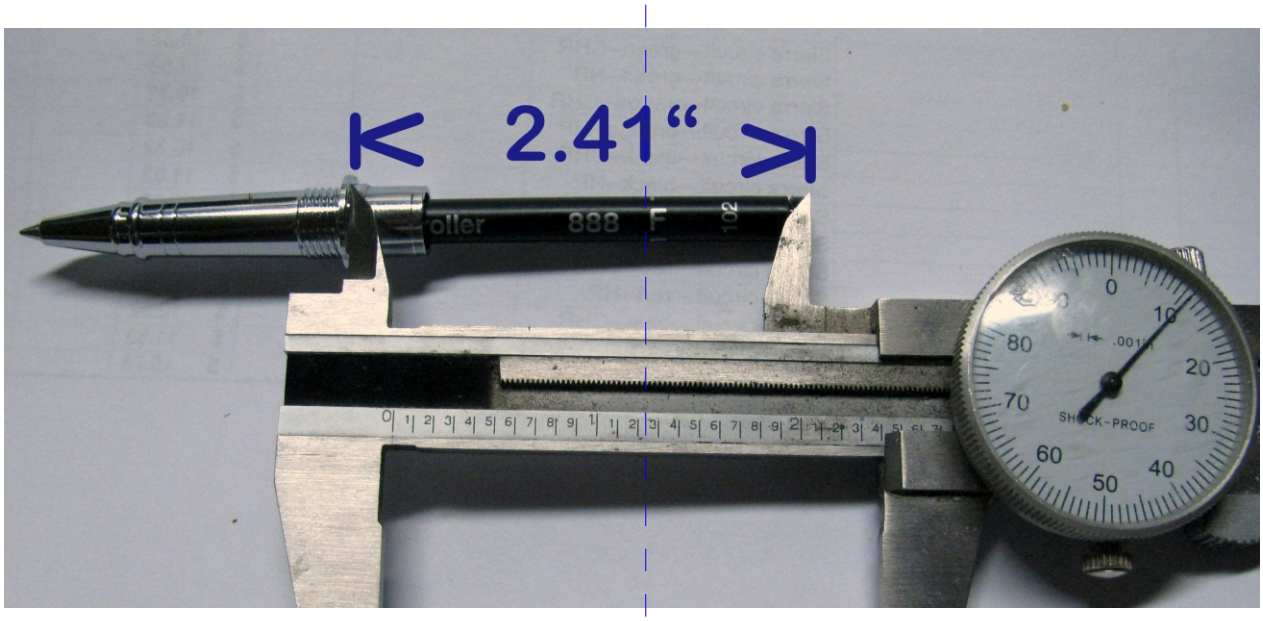
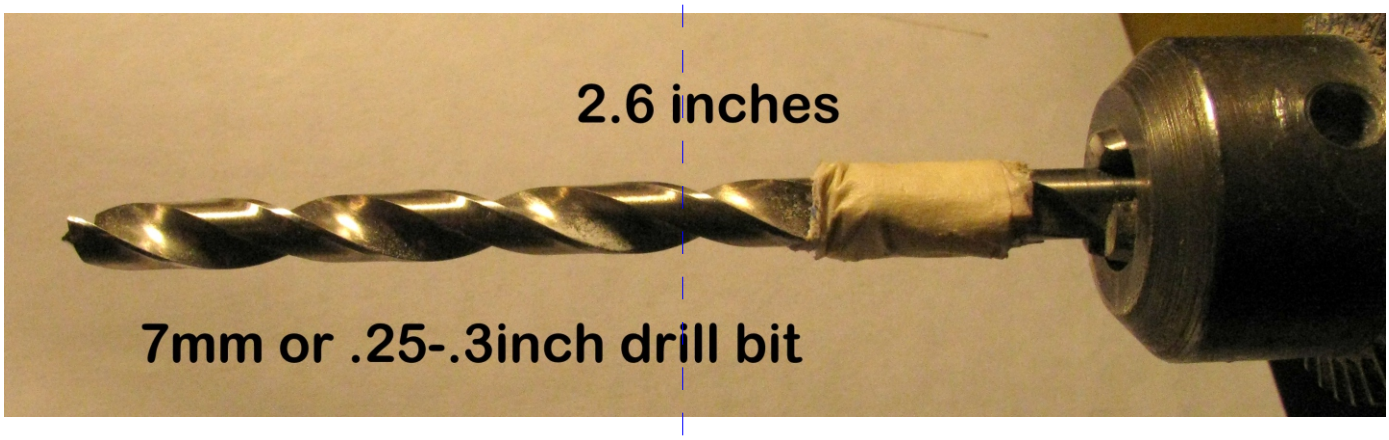
Making a closed end pen

presented by
Ed Brown



First: measure the distance from your rollerball “nib” end of threads to the end of the rollerball refill (2.41” for mine) Add spring (.2”)

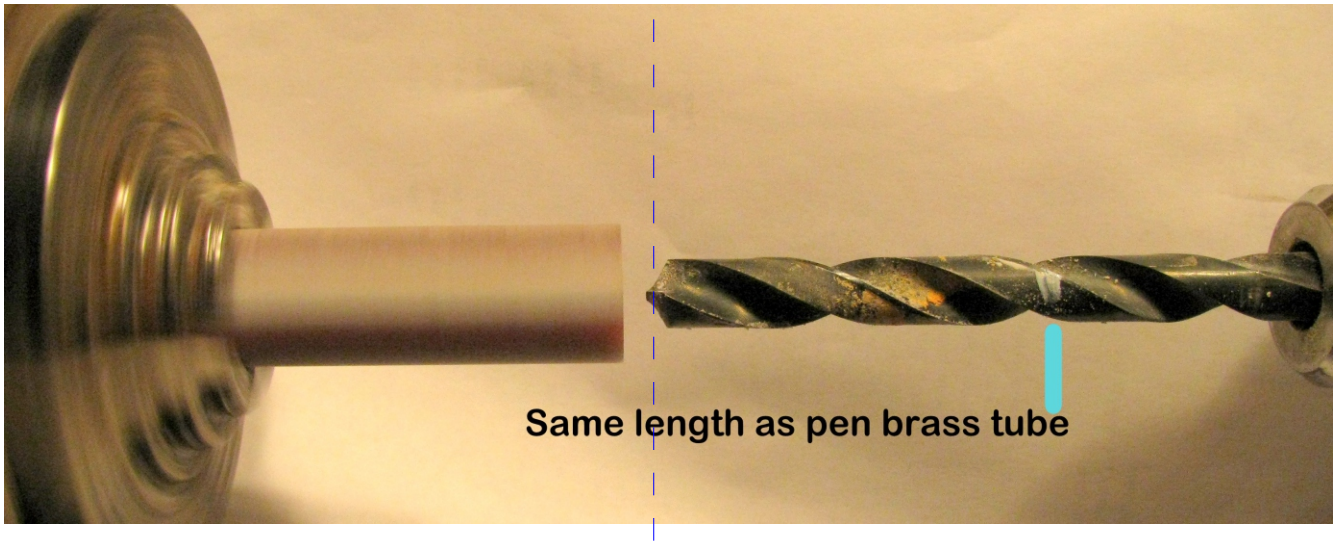
“Junior series, kit pen” overall length above nib: 2.8 to 3.0”



Put a piece of tape on your drill bit, to mark where it is 2.6” into the pen blank.

(2.6” is the length for THIS pen---the length you use will be the same as the length you measure in YOUR “seat on pen to back of refill, plus spring” measurement).

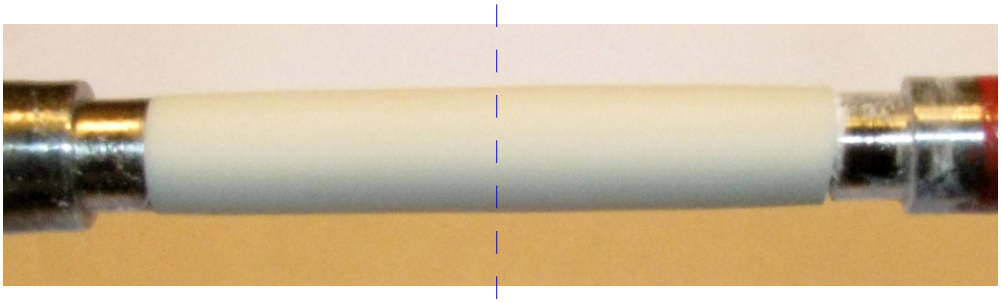
After drilling the hole for the refill and spring, you need to widen the hole to accept the brass tube. (I am doing a triton, so the hole is 10.5 millimeters in diameter--that is the bit shown below). I have marked the bit with a white mark, where the hole will be just as deep as the brass tube is long.



When you complete this procedure, your blank is ready to make the closed end pen. (Do note that the end of the blank should be turning “true”---if it is “wobbly”, true the end with a parting tool.)

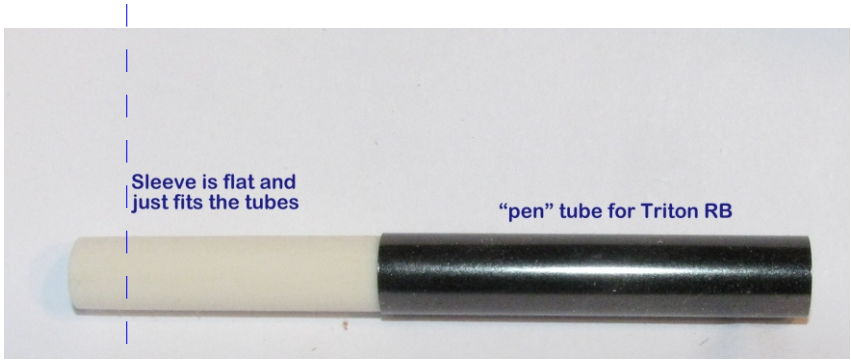
MAKE a MANDREL “Sleeve”

Use a piece of corian or resin to make a mandrel for turning closed end pens. This mandrel will be specific for each model of pen you intend to make. Drill the corian or resin with a 7mm bit, just like you were going to make a “slimline” pen. Insert a 7 mm brass tube and glue in place. After the glue is “set”, turn this piece to the inside diameter of your pen’s brass tube. When you are very close to the proper diameter, use 240-400 grit sandpaper to make the sleeve snug but not “tight”.



Here the sleeve is very close to the proper diameter to fit inside my pen tubes. The LENGTH of this should be about the same as the tube, minus the length of the bushing that will be inserted to turn the pen. So, how to make it “flat” and a nice fit??

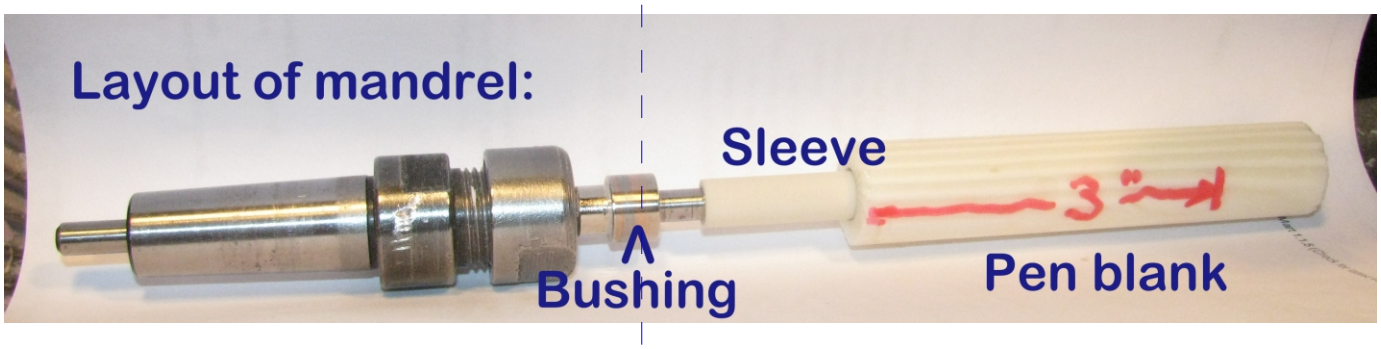
Sand the “sleeve” flat



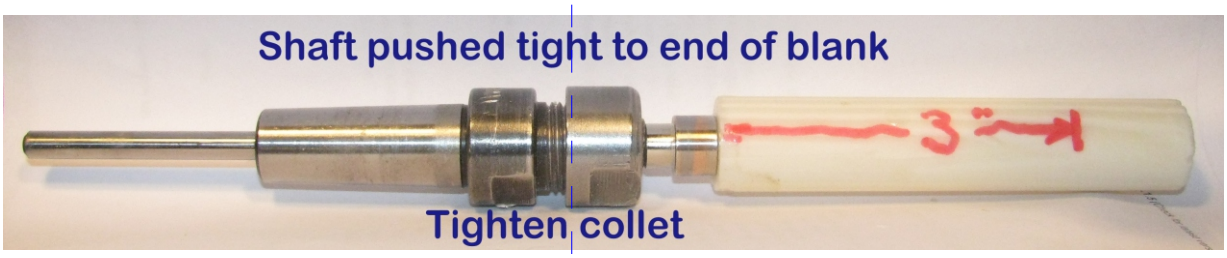
Until it just fits in the brass tube (nickle)

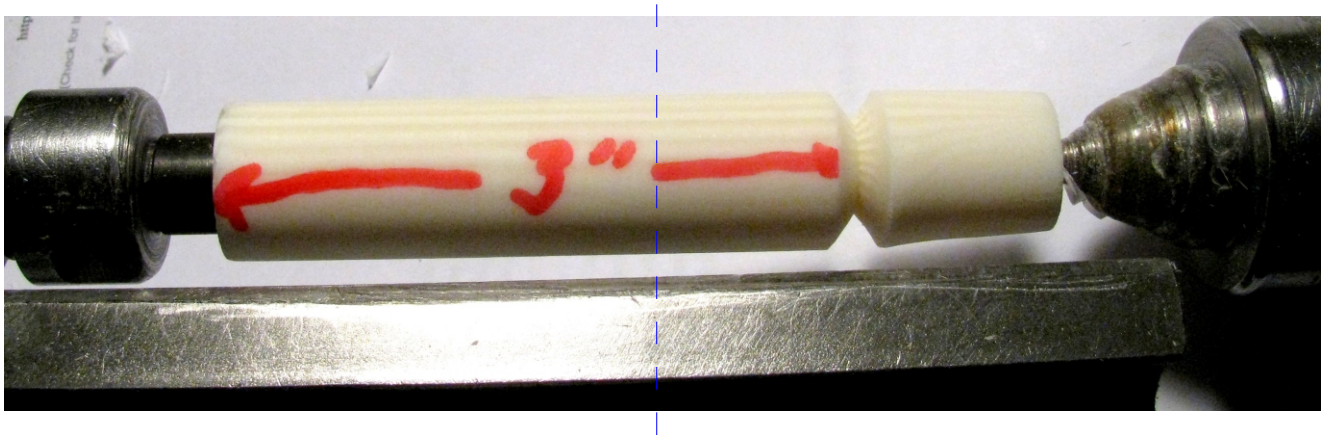
We are now ready to mount the blank on the lathe.

Position pieces as shown:



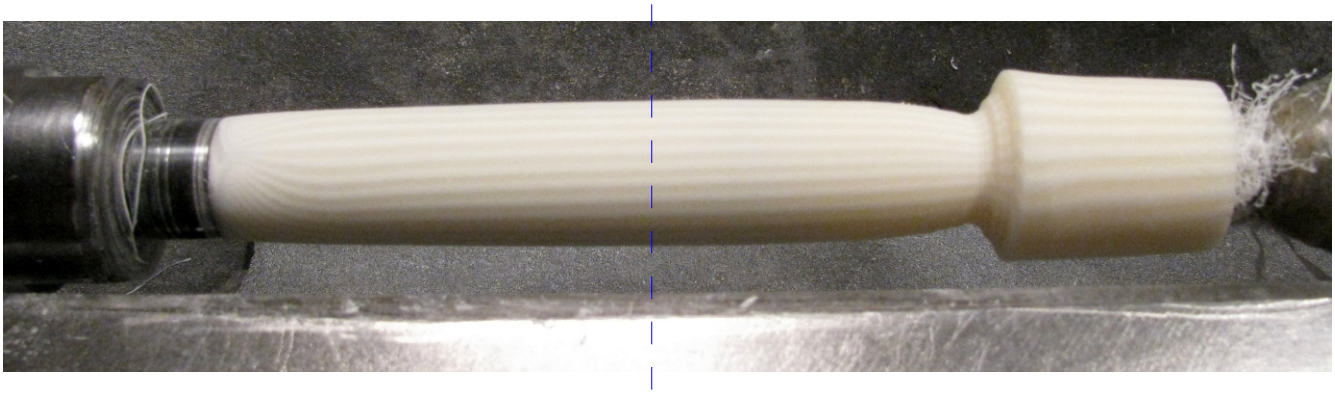
This shows everything in place, now just “push it together” to tighten and you get this:





READY TO TURN!!!

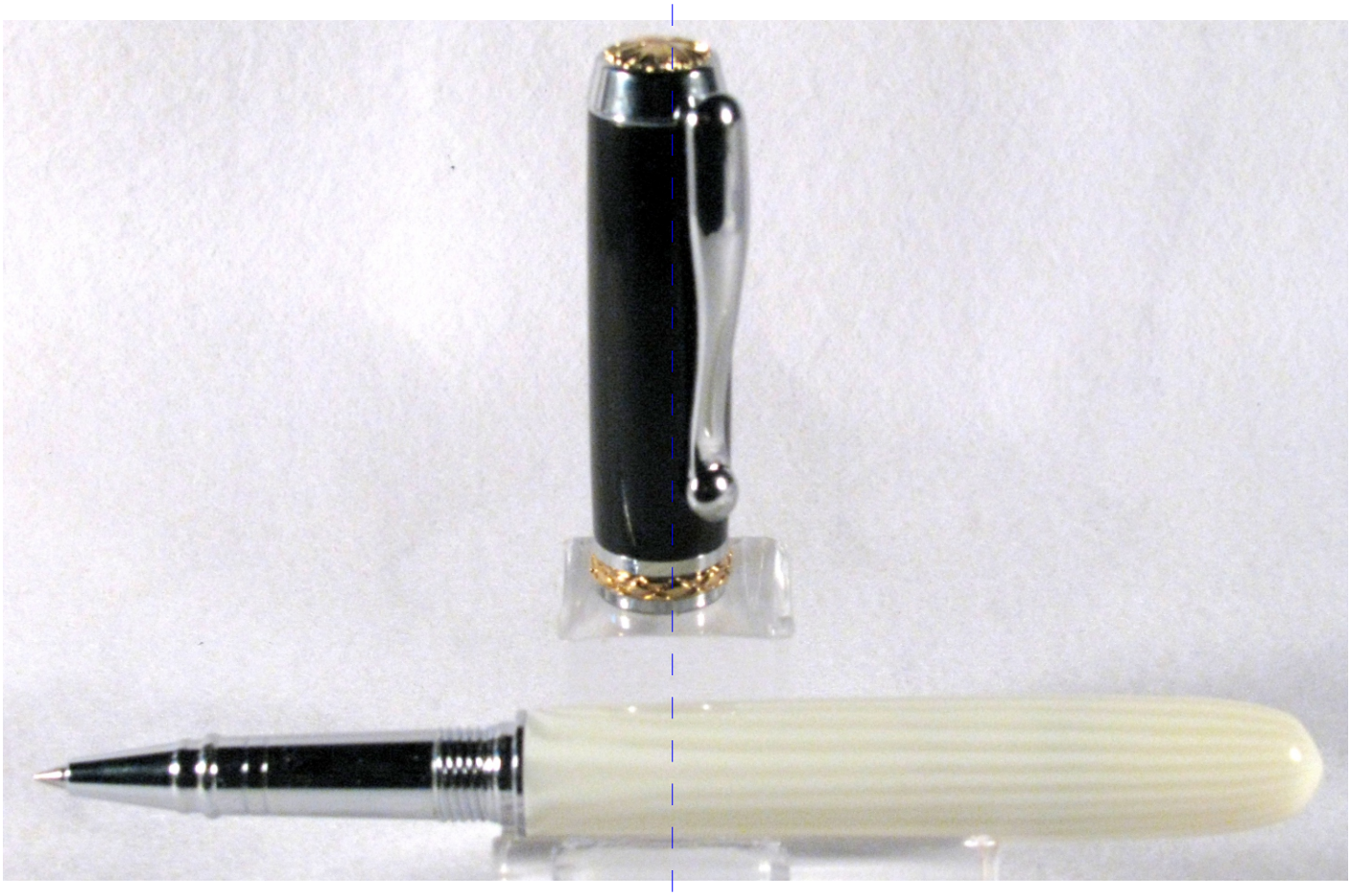
Start by establishing the end of the pen as shown Then, turn to shape, until it is ready to sand, as shown below.



From here, sand while the end is still connected. After sanding, part off the end and sand the end to complete the pen. IF you are going to polish on the lathe, do that BEFORE disconnecting the waste piece.

Once the waste is “cut off” you need to keep pressure on the back of the pen (where the waste was) to keep it “turning”.

Voila!!



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