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# Easy Grip Pen



For use with the following:

050-0401, 050-0402, 050-0403

**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.

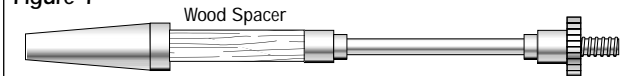
**Drilling:** Mark the center of the blank and drill to the required size. To help prevent blanks from overheating or splitting, clear the drill often and only drill deep enough for the tube length and trimming.

**Gluing:** We recommend cyanoacrylate glue for fast drying and epoxy for slow drying. Apply a coat of glue to the tube and rotate the tube as you push it into the drilled blank.

**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



## 2

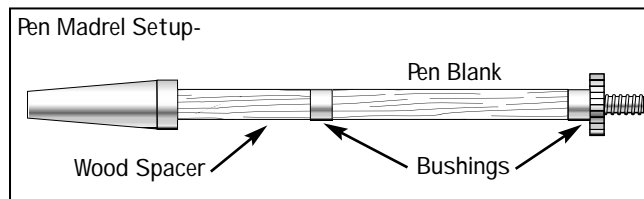
## Turning the Pen

**STEP 1**

Mount the bushings and the barrel onto a pen mandrel. 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.

**STEP 2**

Turn the barrel down to the same diameters as the pen bushings. Sand the barrel smooth using progressively finer grits, then apply a finish such as friction polish or french polish.



## 3

## 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:**

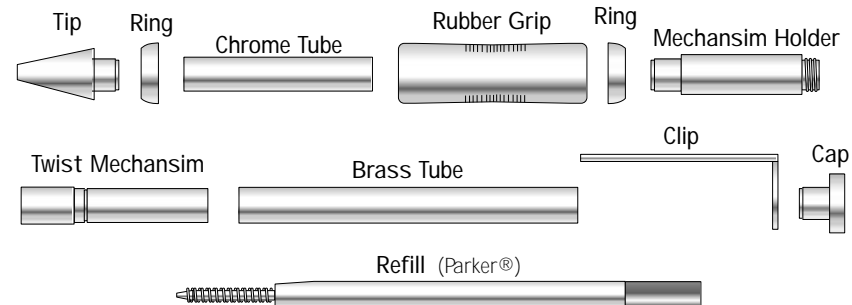
1. Slide the chrome plated tube into the rubber grip.
2. Slide a collar ring over the writing tip, then press the writing tip and collar ring into one end of the rubber grip tube.
3. Slide the other collar ring over the opposite end of the rubber grip tube, then press the mechanism holder into the tube until the stepped end sits flush with the collar ring.

4. Insert the refill through the mechanism holder.

5. Slide the twist mechanism over the refill, then screw the twist mechanism onto the mechanism holder.

6. Slide the clip over the cap (do not force), then press the clip/cap into the end of the turned tube.

7. Slide the turned tube onto the twist mechanism to complete.



Drill: 11/32" Drill Bit  
Blank: 5/8" x 5/8" x 3"