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Havana Ball Point Pen

*For use with the following:*

050-0350, 050-0360, 050-0361

Blank Size and Cutting: The long tube will be for the lower half of the pen and the short tube for the top. Please refer to the Assembly instructions for blank and drill sizes.

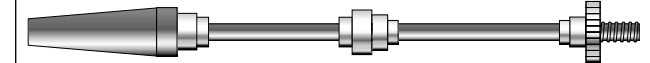
Drilling: Mark the center of the blank and drill to the required size. To help prevent blanks from overheating or splitting, clear the drill often and only drill deep enough for the tube length and trimming.

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

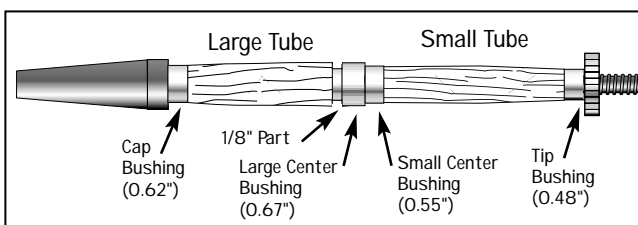
Turning the Pen

1. Mount the bushings and the barrels onto a pen mandrel in the following sequence: cap bushing (0.62"), large diameter brass tube, large center bushing (0.67"), small center bushing (0.55"), small diameter brass tube, and tip bushing (0.48"). 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 large barrel round leaving the wood slightly larger than the center bushing. Make a 1/8" wide part in the large barrel all the way to the brass tube to accept the center band. Now turn the large barrel down to the size of the center and cap bushings.

3. Turn the small 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.



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:

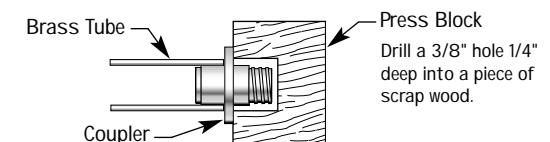
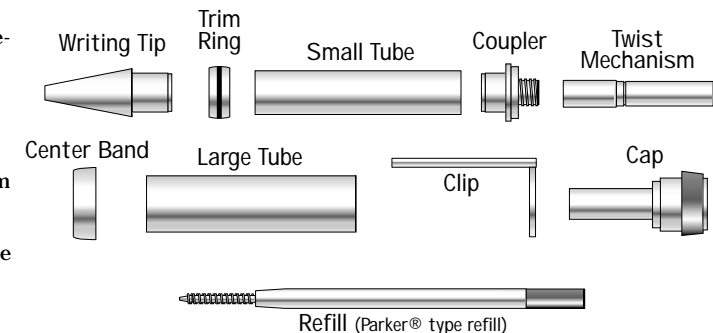
1. Press the clip and cap into the smallest end of the large diameter tube.

2. Press the trim ring onto the exposed brass tube of the large tube. If the fit is too loose, glue it into place.

3. Slide the writing tip trim ring onto the writing tip and press them into the smallest end of the small diameter tube.

4. Using a press block (see diagram) to protect the threads, press the coupler into the largest end of the small diameter tube. To make a press block, drill a 3/8" hole 1/4" deep into a piece of scrap wood.

5. Place the spring over the writing end of the refill and slide through the coupler into the smaller diameter tube. Screw the twist mechanism onto the threaded end of the coupler.



Drills: 27/64" & 35/64"

Blank: 13/16" x 13/16" x 5"

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