

# *Making a Parker Style Bullet Pen Nib*

*Les R. Elm © 2008*

This tutorial is for a Parker style refill using a 30 Caliber Copper Full Metal Jacket Bullet which has a lead core.

Due to environmental and health issues associated with lead, a lot of bullet manufactures are now making Solid Copper Bullets.

Set lathe at 250 - 300 RPM to do the drilling. When drilling either a bullet containing lead or a solid copper bullet, go slow and drill shallow using Rapid Tap Cutting Fluid, cleaning the drill bits frequently to avoid plugging the hole. Drilling too fast will cause the lead will get hot, melt and cause problems.

**Step 1.** Install a 1/2" drill chuck in the headstock. Install the bullet into the drill chuck with the point facing in. *Do not over tighten and always ensure the bullet is tightened on the surface that will not be seen when the bullet is seated into the cartridge neck.*

**Step 2.** Install a 1/2" drill chuck c/w a 1/4" bit into the tail stock and place a piece of tape on the bit at 3/4" to use as a depth gauge. Using Rapid Tap Cutting Fluid drill to a depth of 3/4". With the lathe still running use a flat file to de-burr and square up the bullet end surface. Use a piece of extra fine steel wool pressed onto the hole to de-burr the inside of the nib hole.



*Bullet Drilled to a Depth of 3/4" with a 1/4" Bit*

**Step 3.** Reverse the bullet in the head stock drill chuck and install with the point facing out. File 1/8" from the point to get a square flat surface. *Don't over tighten and always ensure the bullet is tightened on the surface that will not be seen when the bullet is seated into the cartridge neck.*



*Bullet Installed In Drill Chuck*



*Bullet Tip Filed Square and Flat*

**Step 4.** Install a #36 drill in the tail stock drill chuck and using Rapid Tap Cutting Fluid drill all the way thorough into the previously drilled 1/4" hole. With the lathe still running use a flat file to de-burr and lightly round over the tip. Use a piece of extra fine steel wool pressed onto the hole to de-burr the inside of the nib hole.

**Step 5.** Remove the bullet nib from the drill chuck and check the #36 nib hole to ensure the refill c/w spring slides in freely and that there is enough 1/4" hole depth to get enough refill tip reveal through the nib hole with the spring full compressed.



*Drilled #36 Nib Hole*



*Check Nib Refill Hole For Reveal*