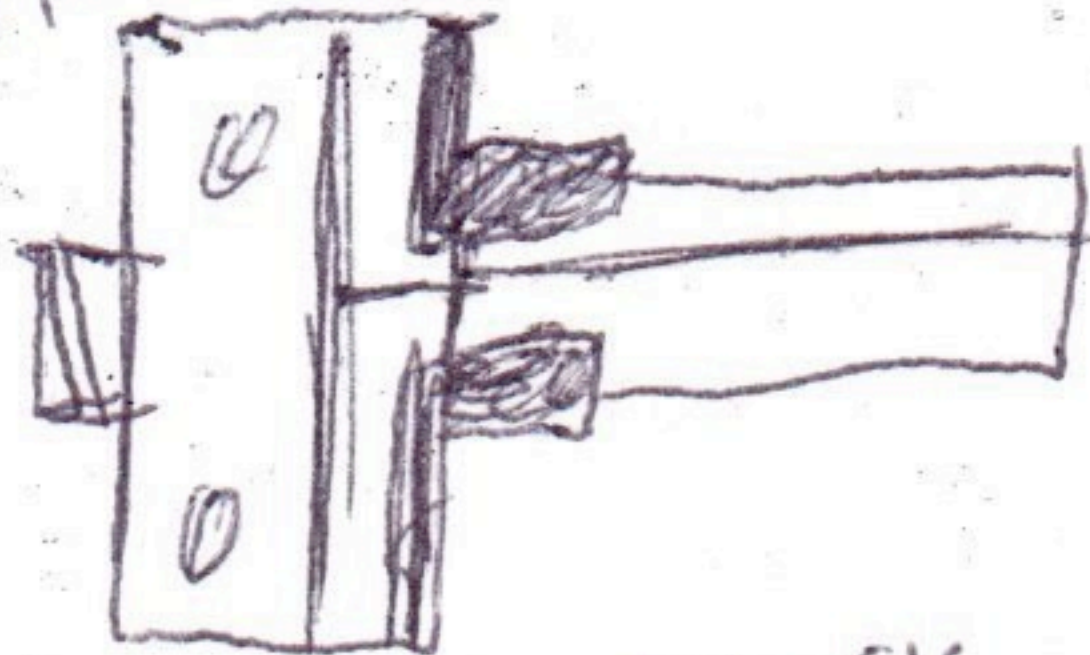


Tutorial uses a #6 Jowo nib unit.

Head Stock

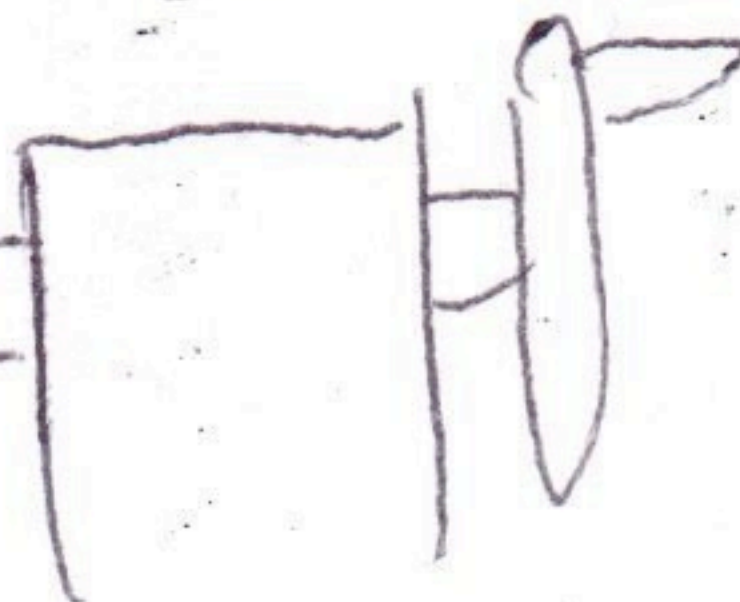


4 JAW CHUCK

DRILL
CHUCK



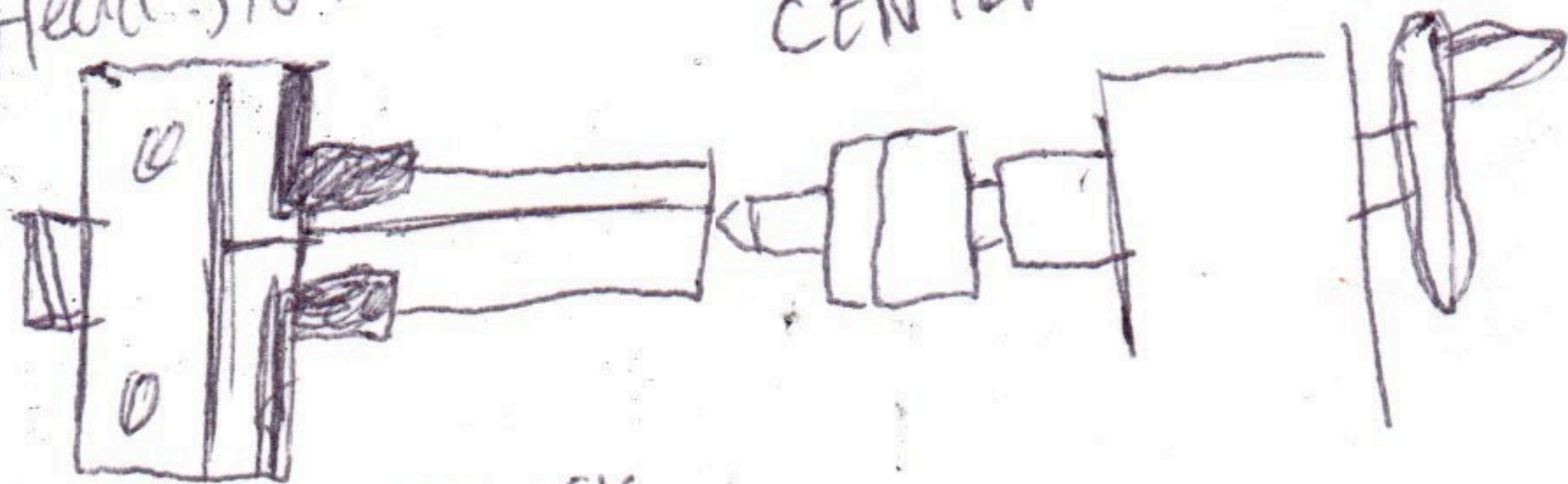
TAIL
STOCK



**Load and center your blank in the 4 jaw -
Square the end of the blank before drilling.
Drill out the blank 30mm deep with a J bit.
I always drill the blanks out first.**

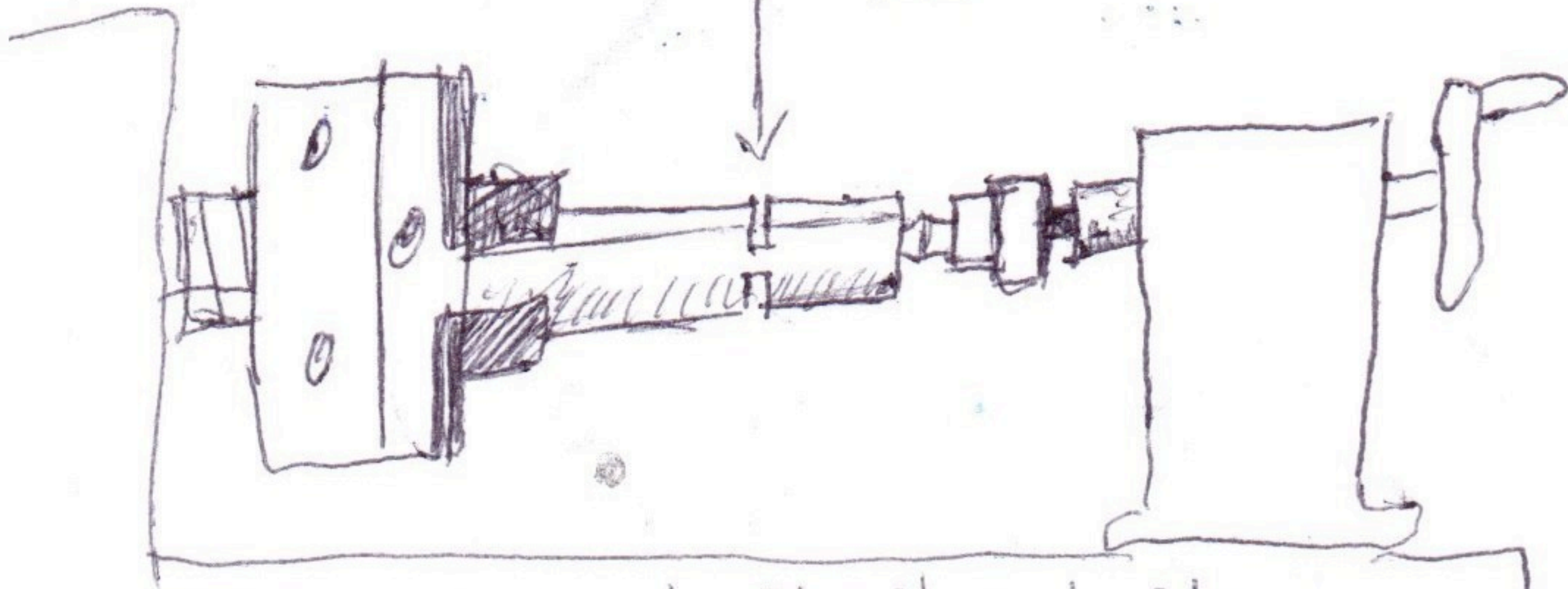
Head Stock

LIVE
CENTER



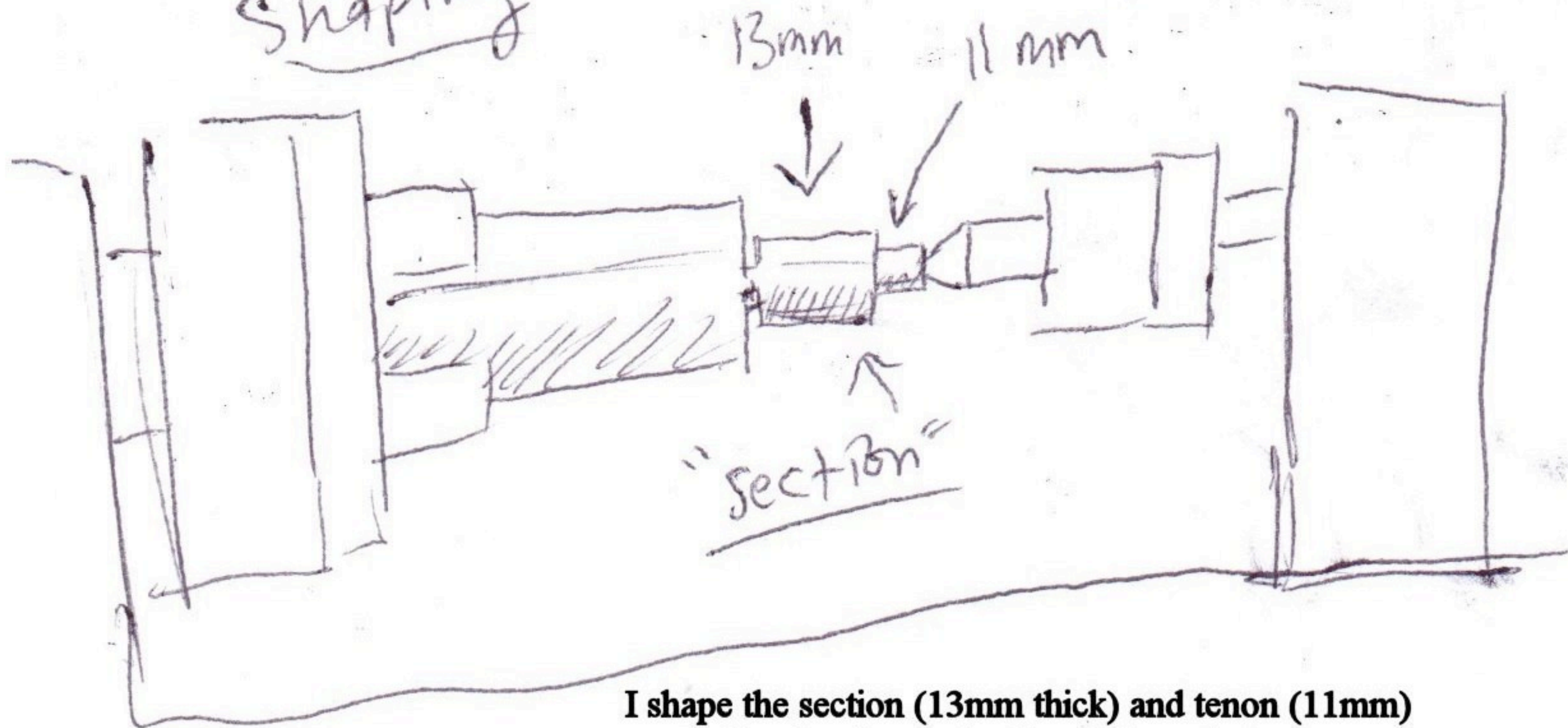
**Shove the live center up against the blank.
I use the LC w/ the replaceable tips and use
the smallest tip that will fit this hole.**

Cut w/ parting tool to
mark end of part.



Cut to ~~the left~~ the left
of ~~30~~ 30 mm for the section -
or to the left of 75-85mm
for the barrel -
or to the left of 60-70
for the cap.

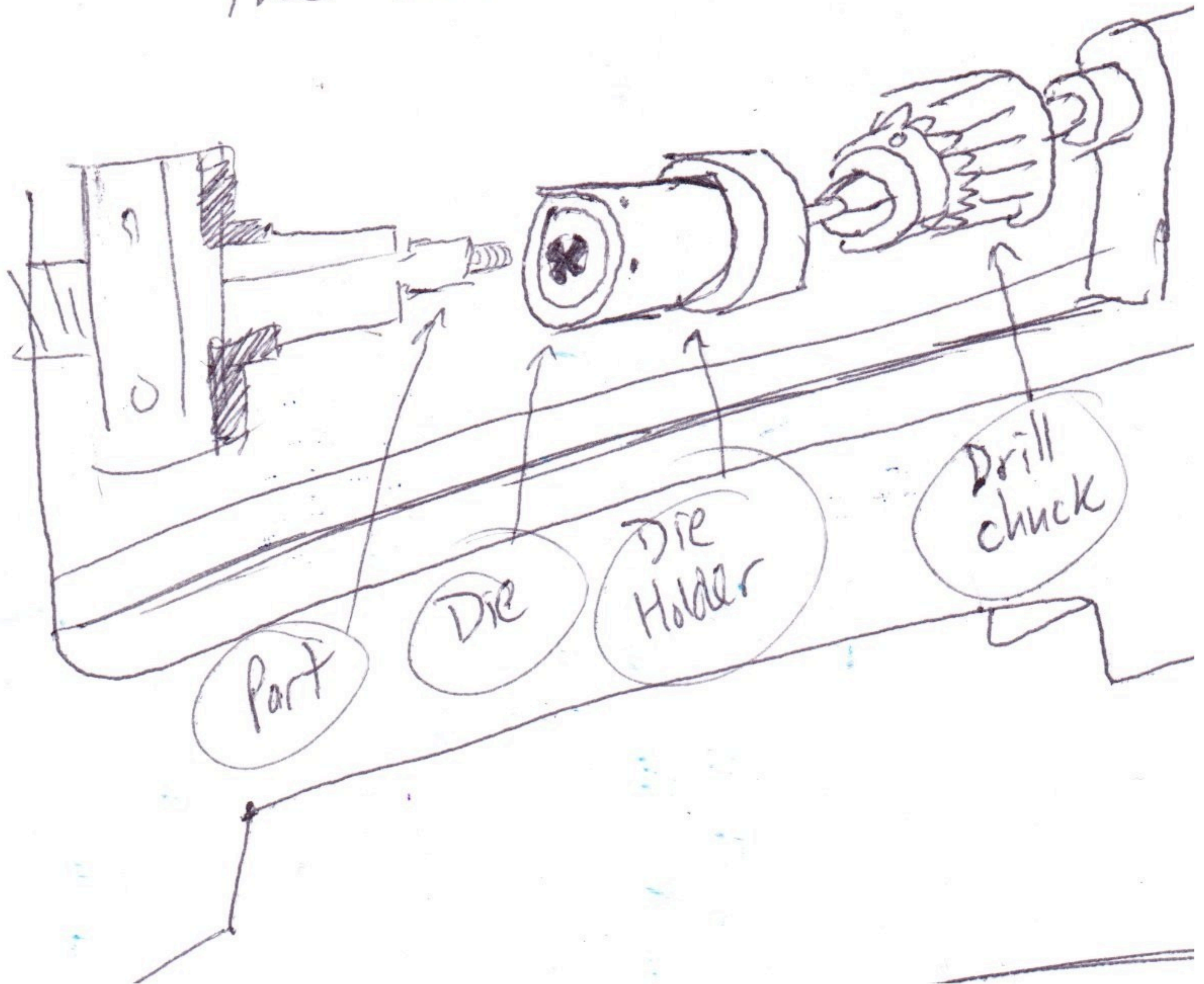
Shaping



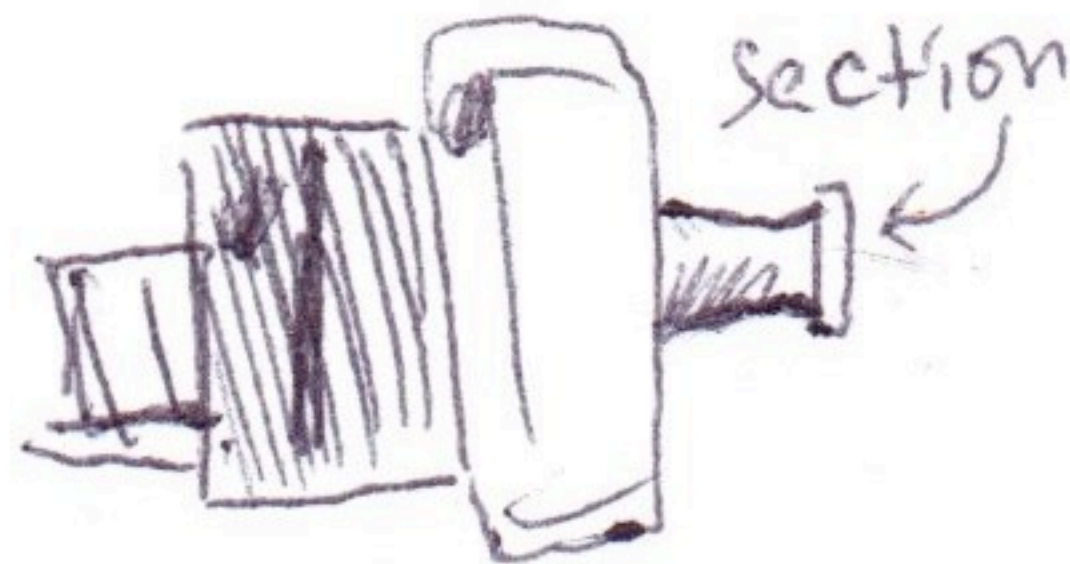
I shape the section (13mm thick) and tenon (11mm) next. Go ahead and give the section whatever shape you like. Pinched - lipped - tapered - whatever. Sand and polish and make it pretty.

Threading

I Always thread outside parts LAST
but while still attached to
the blank in headstock.



**Part the section off and stick it in your 11mm collet.
Clean up the front of the section.**



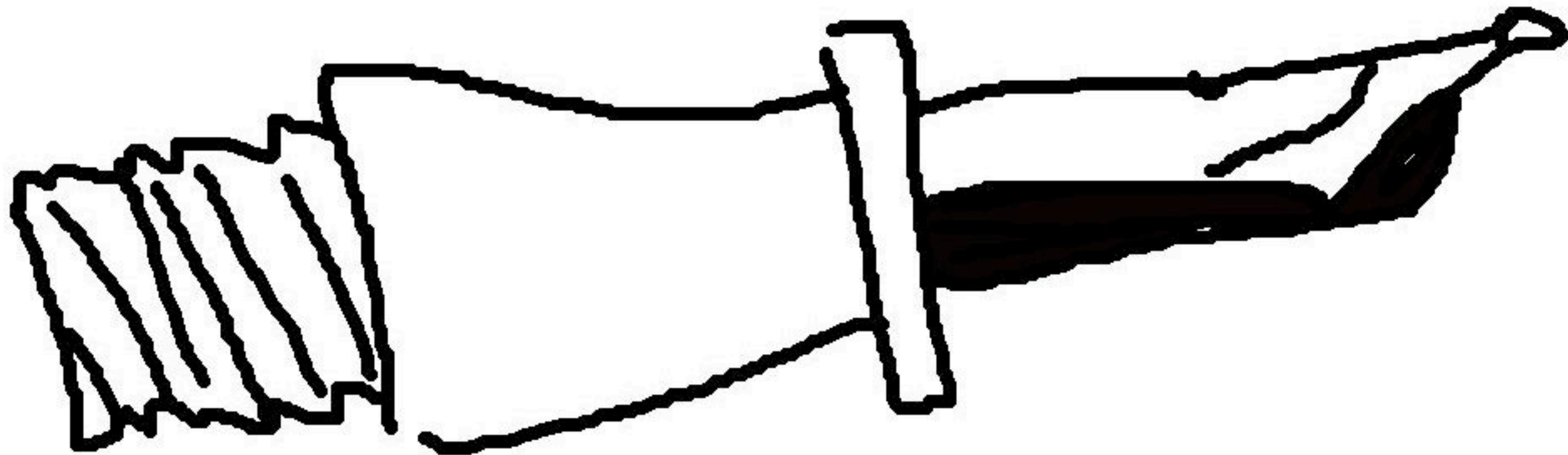
COLLET CHUCK



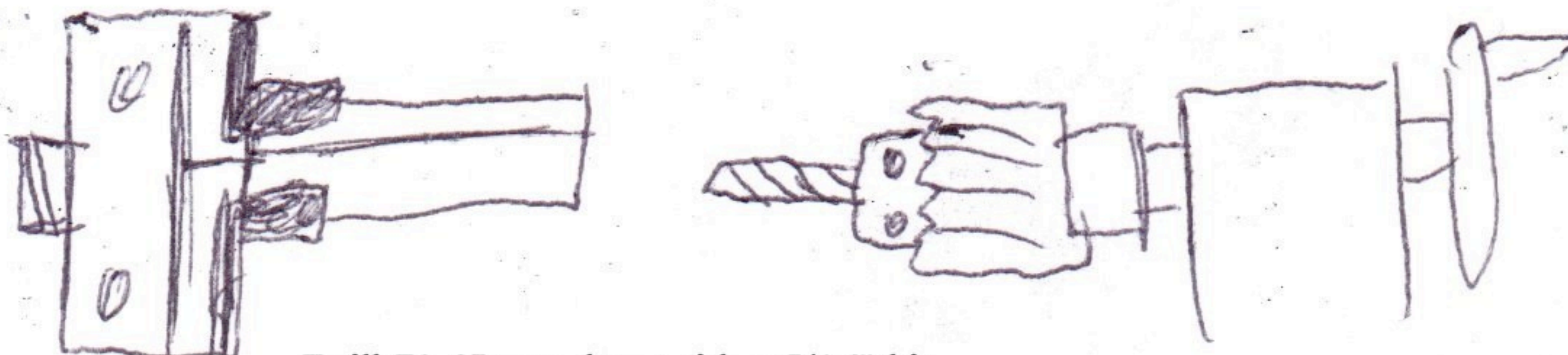
COLLET CHUCK

**Use a V bit and drill 13.5mm deep.
Then an 8.5mm bit and drill 2mm deep.
This will give room for nib unit housing and collar.
Then tap with the special tap for your nib unit.
This tutorial is for a #6 Jowo.**

You're done! Stick a nib in it.



Make the barrel next.



Drill 70-80mm deep with a 5/16" bit.

This will give room for a converter to fit in there.

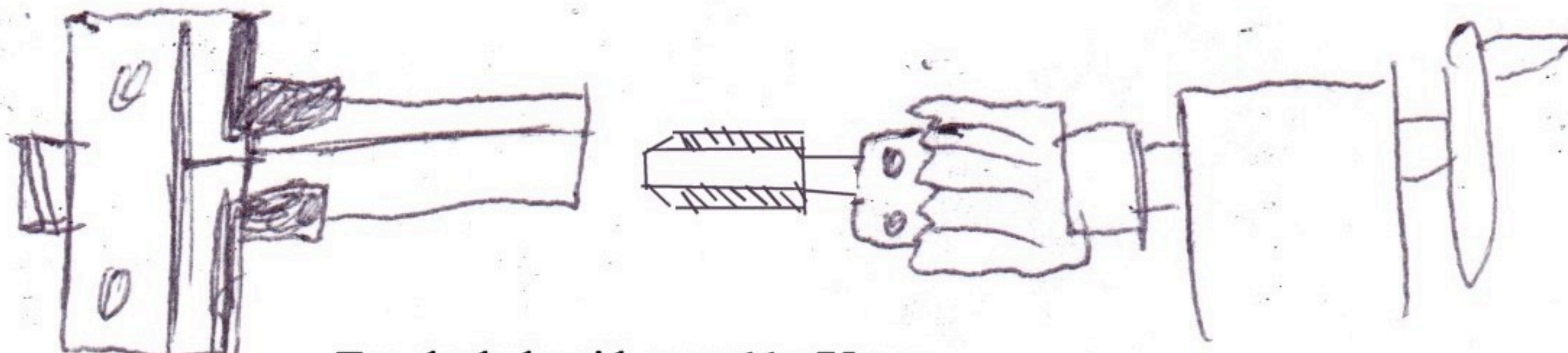
Then drill in about 15mm deep with an 11mm bit.

This is for the threads your section will mate with.

Then with an 11.25 or so bit, with the machine in reverse, mush in about 2mm the end of the hole.

Then put the machine in forward and drill that same depth.

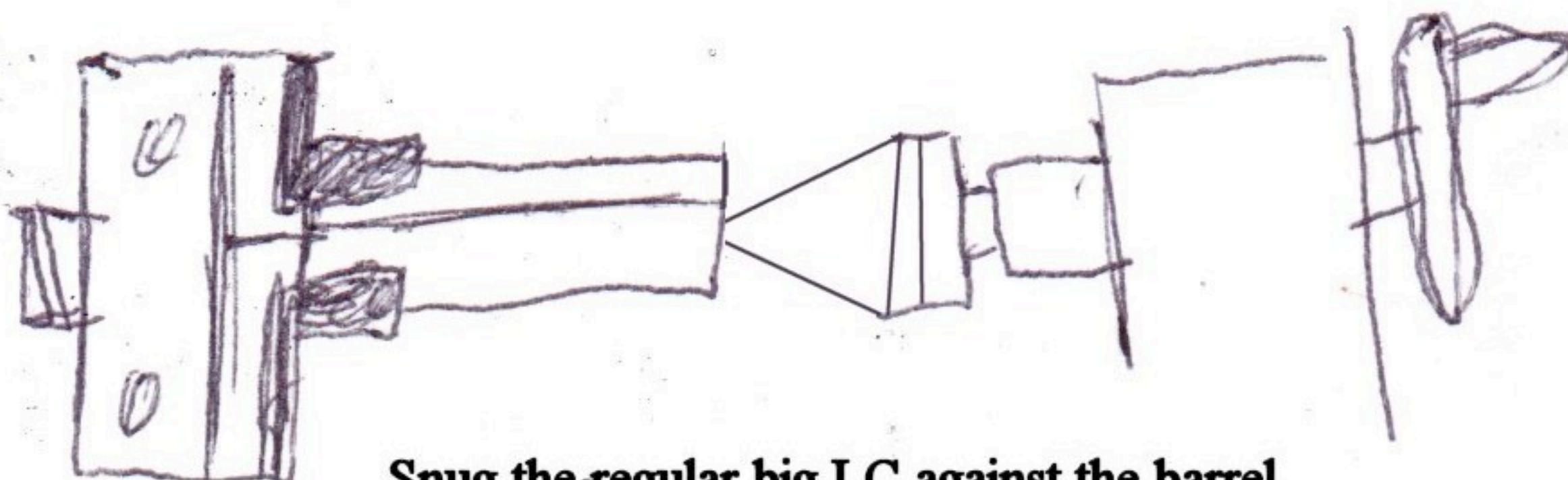
Putting it in reverse helps create a chamfer so your bit doesn't cause vibration or catching or whatever. Makes it easier. Especially with bigger bits for the cap.



Tap the hole with your 11x.75 tap.

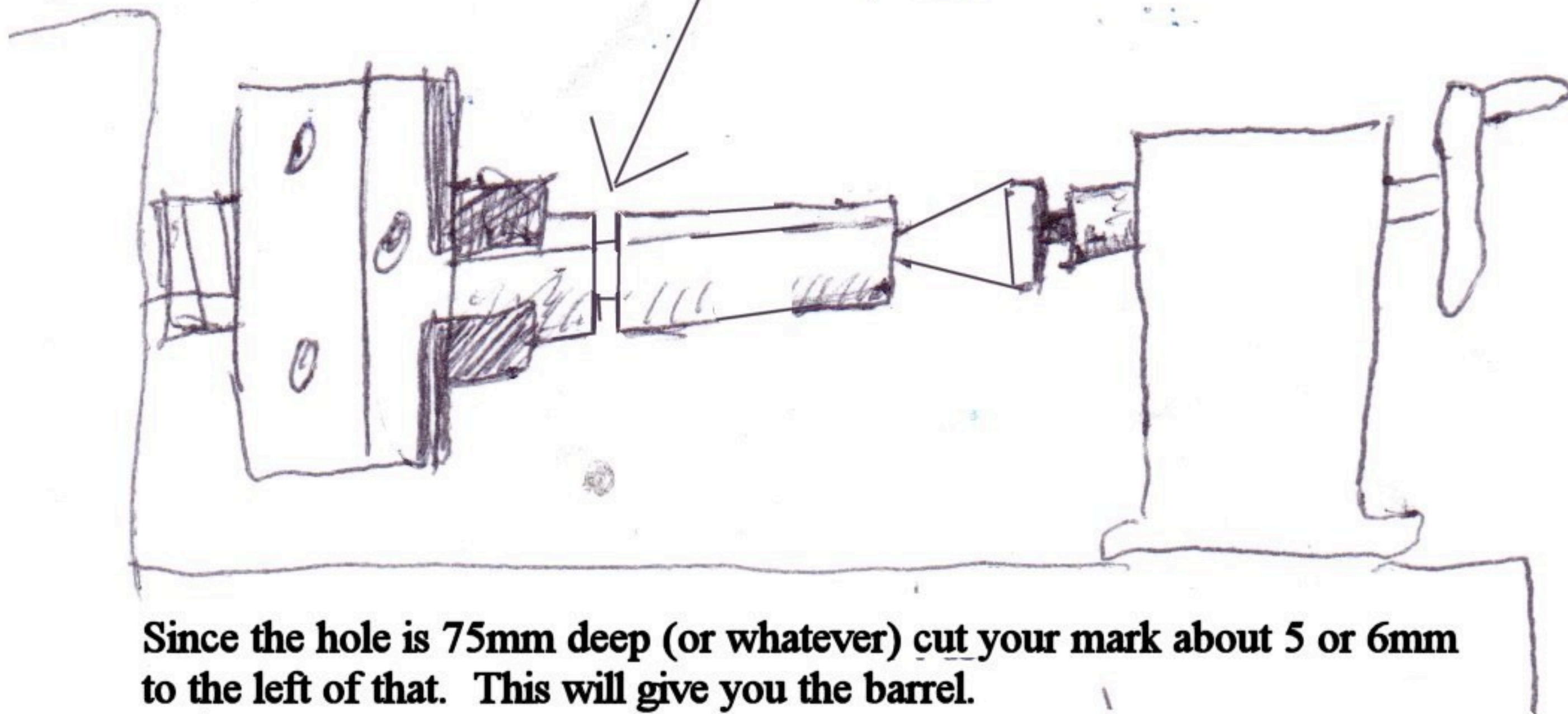
I used cooking oil on a paintbrush as lubricant.

Test fit the section. Yay! Be sure the blank end is square or the section won't fit snug against it.



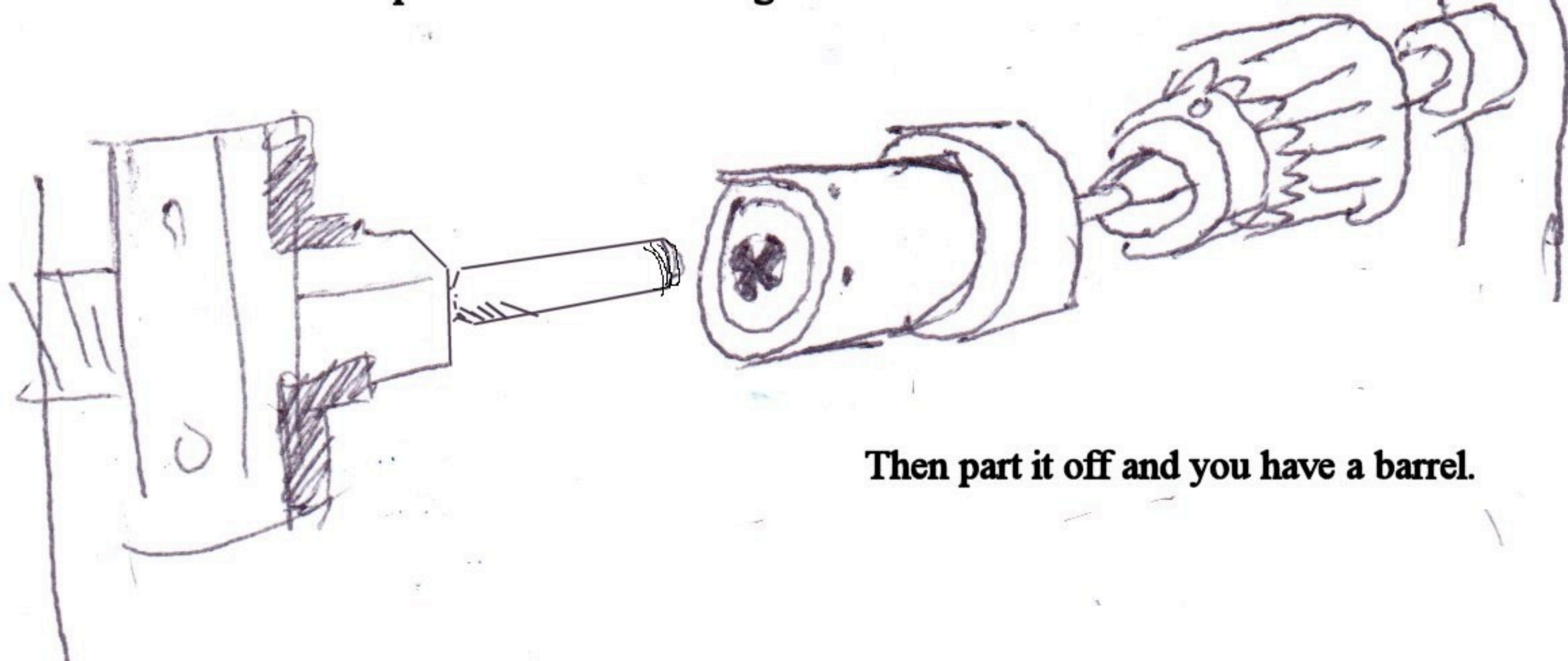
Snug the regular big LC against the barrel.

Cut w/ parting tool to
mark end of part.



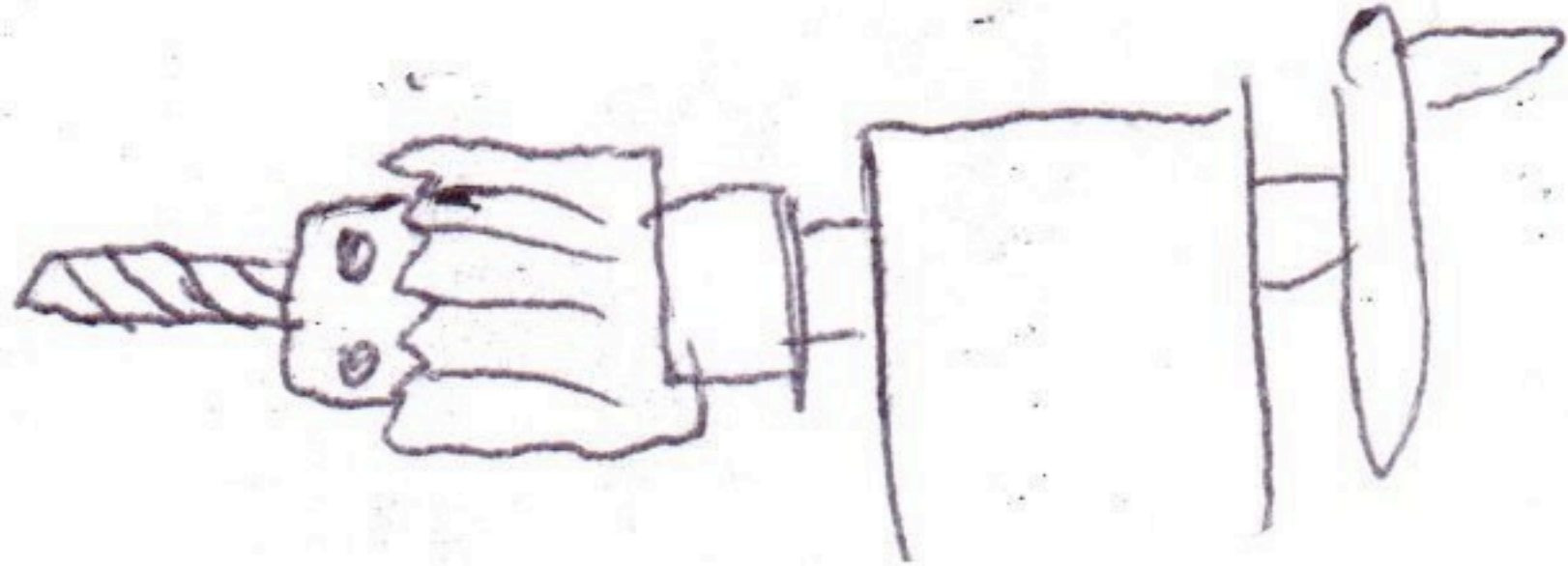
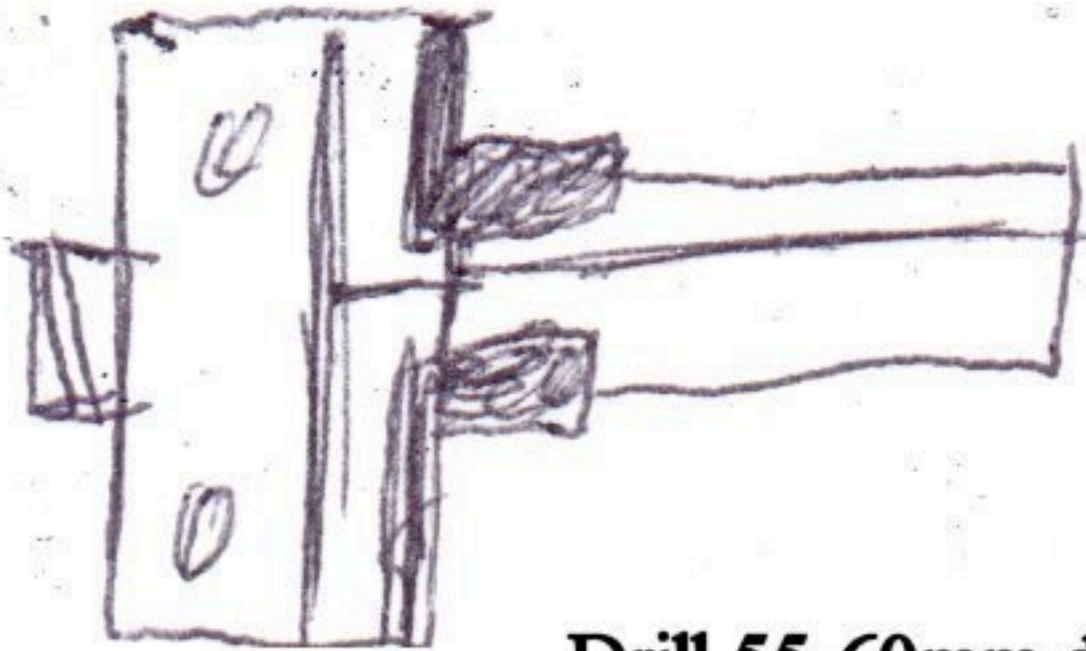
Since the hole is 75mm deep (or whatever) cut your mark about 5 or 6mm to the left of that. This will give you the barrel.
Then simply turn your barrel to shape and size.
I make the threaded end 14mm thick (or a hair under)
for the 9/16" threads.

I also sand and polish BEFORE cutting threads. Threads last.

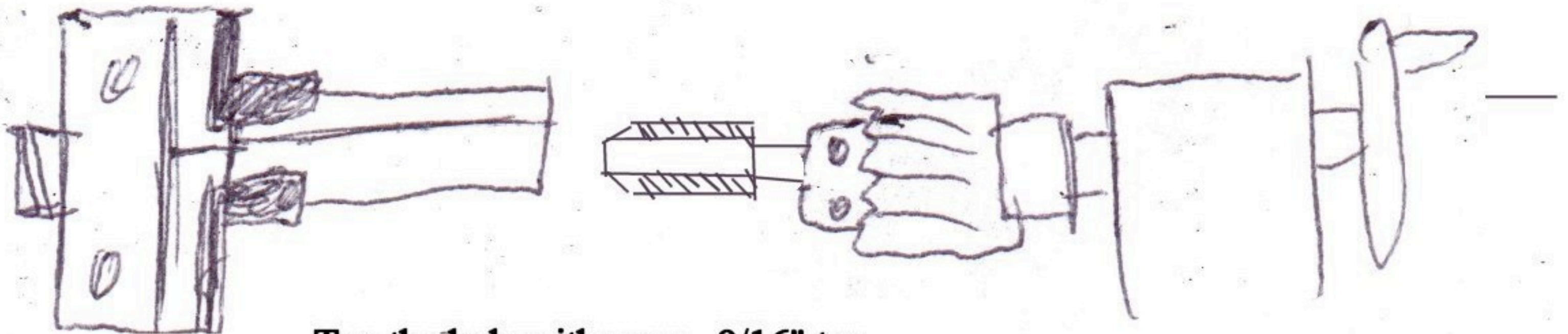


Then part it off and you have a barrel.

Make the cap next.



**Drill 55-60mm deep with 23/64" bit.
This will give the nib some wiggle room.
Then drill 25-30mm deep with your 17/32" bit
- creating the shoulder inside the cap that
the section lip will snug against - to keep it
from drying out between uses.**



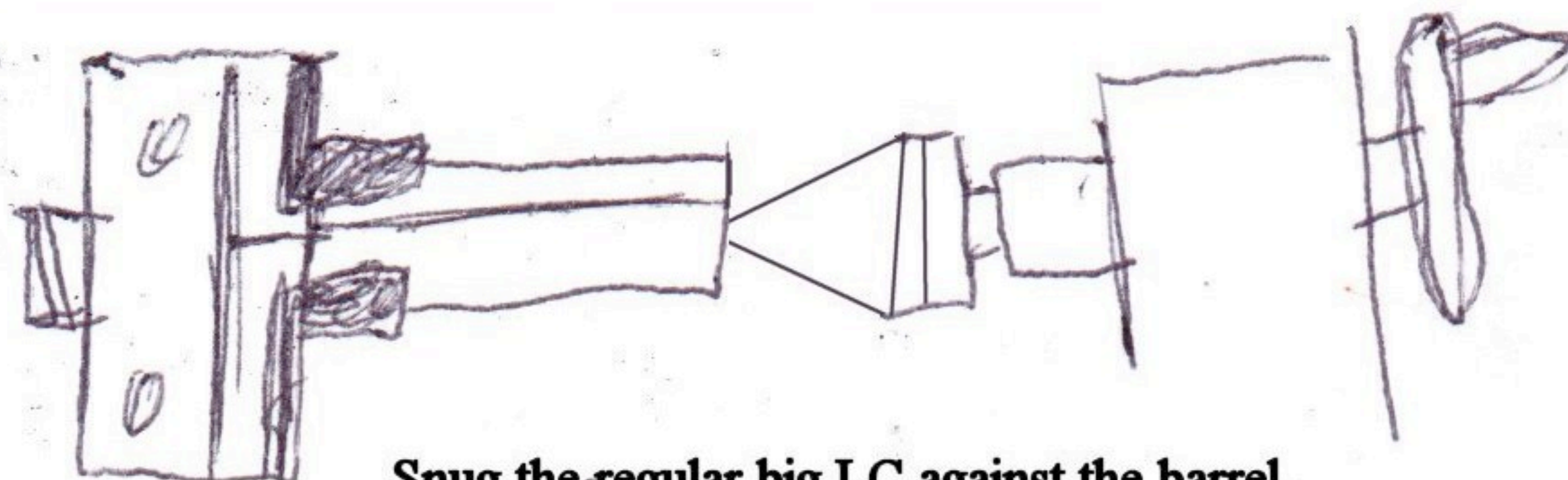
Tap the hole with your 9/16" tap.

I used cooking oil on a paintbrush as lubricant.

**Be sure the barrel and section
fit in there just right. cut away any threads with
a very small parting tool to get it to fit just right
if you have to.**

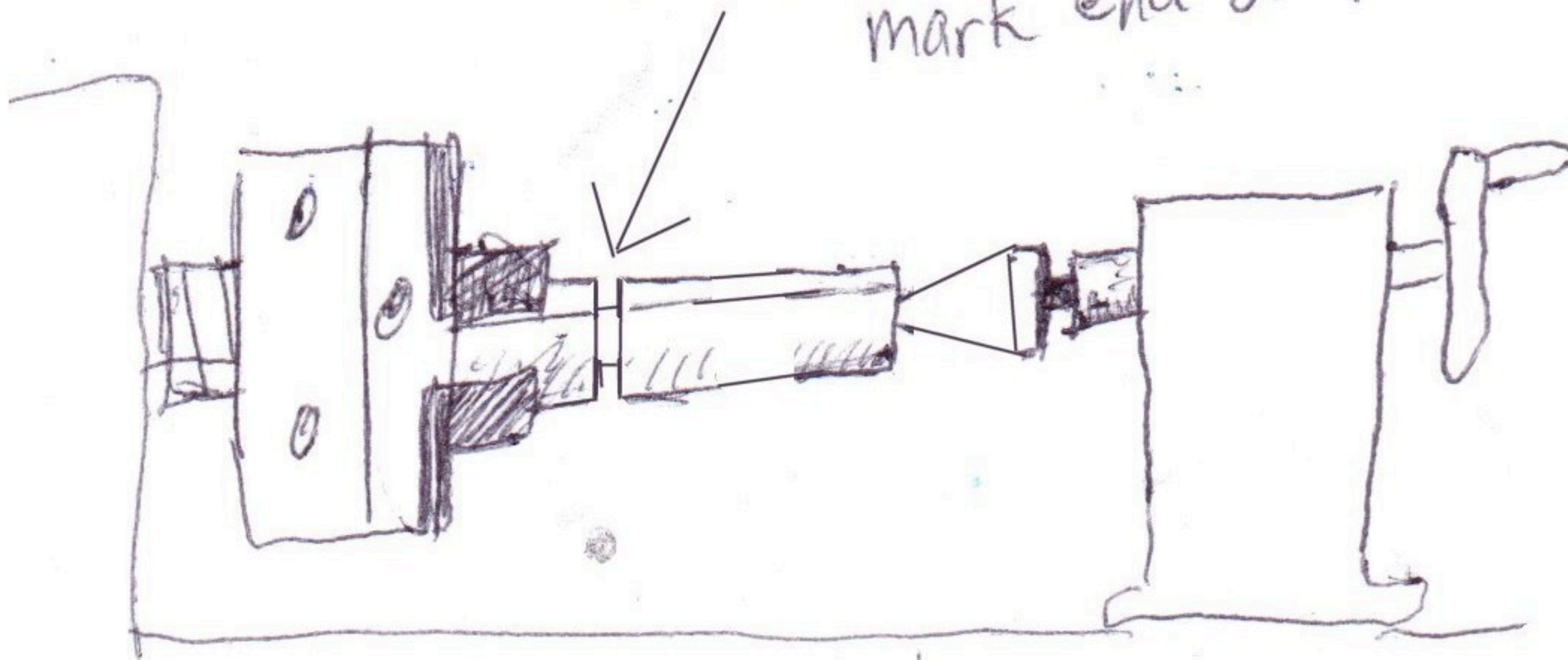
**This is so the threads don't start right at the lip
of the cap. The cap will cover some of the
barrel past the threads and be pretty.**



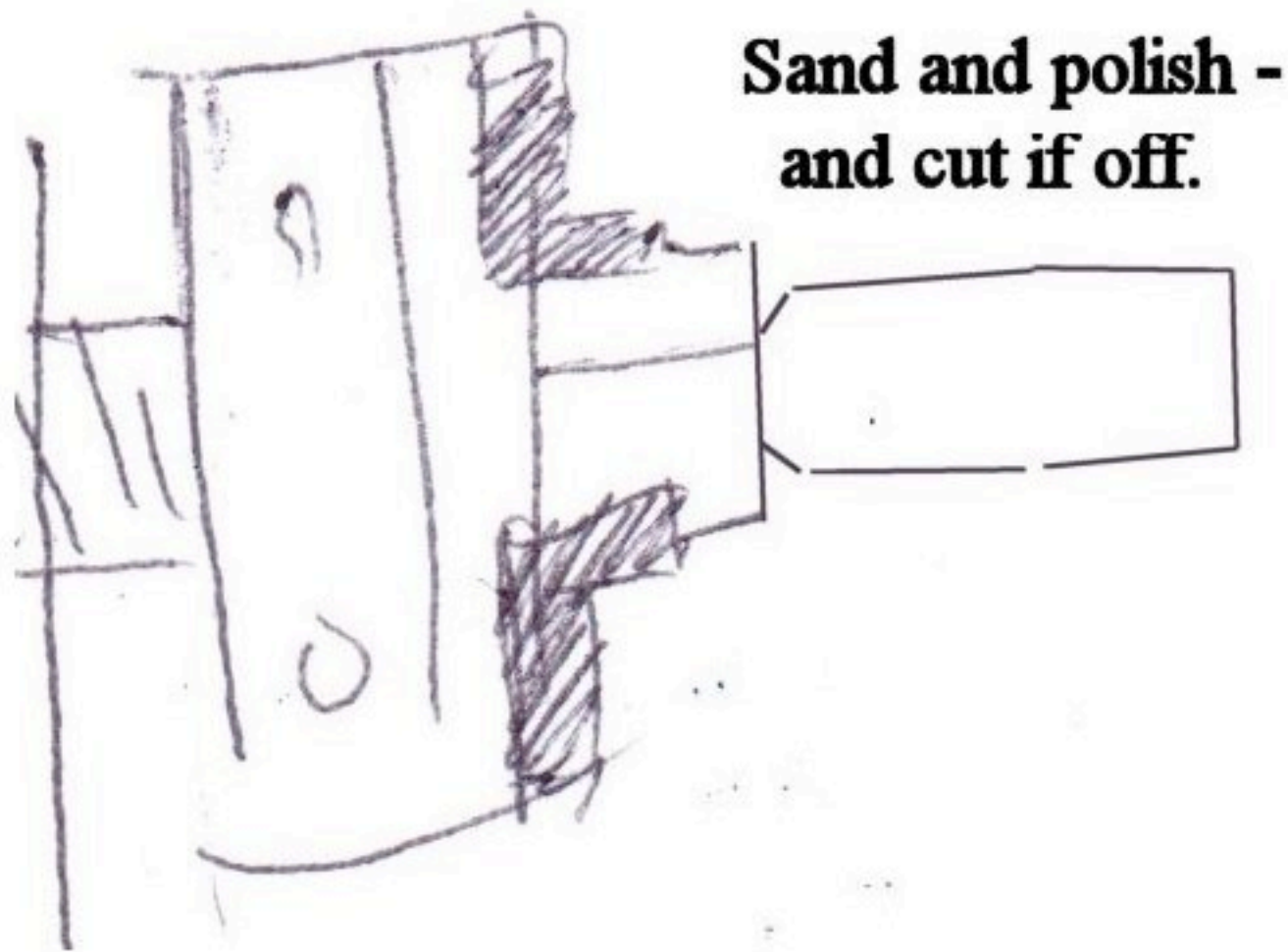


Snug the regular big LC against the barrel.

cut w/ parting tool to
mark end of part.



**Since the hole is 55mm deep (or whatever) cut your mark about 5 or 6mm to the left of that. This will give you the cap.
Then simply turn your cap to shape and size.**



**Wrap the middle of barrel/cap with 1 layer
of masking tape - stick in appropriate collet -
and clean the end of it up with cutting tool.
Sand and polish.
DONE.**

