



Writing Turning Flipping

Series 22 Vario Version 11/2009 © STARBOND EUROPA www.starbond-europa.de

Converted from German to English. (Uses Cigar Lower Assembly without a transmission.)

W-T-F PDF file can be found at <https://www.writingturningflipping.com/media/PDFs/2010Montage Serie 22.pdf>



Non-Retractable Ball Point Pen Kit

Required items:

7mm Adjustable Mandrel or Head Stock Dead Center

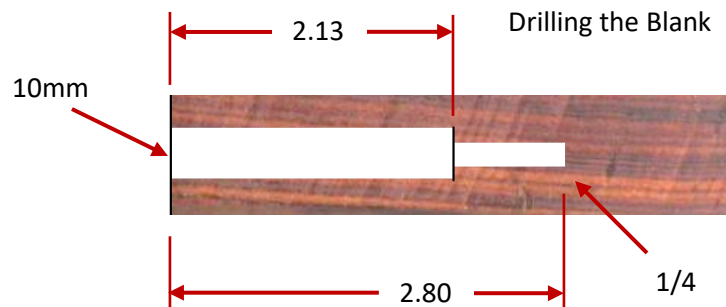
Tail Stock Live Center

Drill bits 10 mm and 1/4 inch

Blank Size Minimum 5/8 x 5/8 x 5 inches

Cigar (lower tube and nib assembly) Pen kit

Lower Cigar Bushing (.460 dia.)



Drill the blank on center with a 10mm bit, approximately 2.13 inches deep.

Roughen the tube with sandpaper and glue it into the 10mm hole.

Drill a 1/4 inch hole centrally for the refill, 2.80 inches deep.

Use an Adjustable Mandrel or Head Stock Dead Center and Live Tail Stock Center to turn the blank.



Turn the blank into the shape you want. Add your finish. Use a Parting Tool near the end of the Blank, do not part the waste off. Saw the waste off with the lathe turned off. Sand the parted end and add finish.

Press the 2-piece nib adaptor into the tube, insert the refill and spring, then screw on the Nib to complete the pen.

