

TURNING SUPPLIES & REPLACEMENT PARTS

Set of Bushings	050-4037
12.5mm Drill Bit	192-1250
10.5 mm Drill Bit	251-1050
Replacement Tubes (2)	050-9159
Fountain Pen Refill	050-7057
Schmidt Rollerball Refill	050-4416
Accessory Kit (drill bits, bushings)	850-4151

HOW TO CONTACT US...

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CRAFT SUPPLIES USA
THE WOODTURNERS CATALOG

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Jr. Gentlemen's II & Jr. Statesman II Pens



Drill: 12.5mm & 10.5mm

Blank: 3/4" x 3/4" x 5"

For use with the following: 050-4107, 050-4157, 050-0372, 050-4178, 050-4109, 050-4159, 050-0374, 050-4180, 050-4106, 050-4156, 050-0371, 050-4177, 050-4108, 050-4158, 050-0373, 050-4179, 050-2326, 050-2325, 050-2328, 050-2327, 050-4147, 050-4149, 050-4146, 050-4148

SAFETY: Follow all safety instructions that came with your lathe. Always wear proper eye and ear protection.

CUTTING AND DRILLING: Measure the length of each brass tube and cut each blank 1/4" longer than each tube. Once you've marked the center of each blank, secure the blanks in a clamp or vise. Then drill each blank using the correct sized bit(s) at a speed of 2,000 to 3,000 rpm, clearing out the chips after every 1/2" of drilling. When using larger bits or drilling plastic, use lower speeds. To prevent blow outs stop drilling 1/8" from the bottom of the blank, then cut off the end of the blank leaving the drilled blank 1/8" longer than the tube.

GLUING: Lightly sand the exterior of the brass tube with 220 grit sandpaper to prepare it for gluing. Use thick cyanoacrylate glue for an instant bond or epoxy for additional working time. After applying a coat of glue to the tube, insert it into the blank, rotating the tube as you go, ensuring an even distribution of glue. Make sure there is enough wood on each end of the tube to allow for trimming.

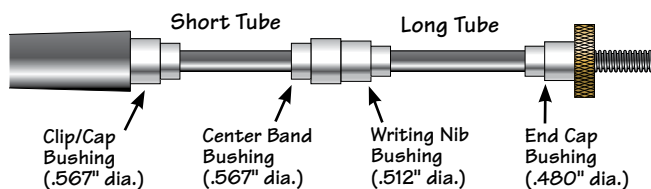
TRIMMING/TRUING: Square the ends of each blank using a barrel trimmer. Do not trim away the brass tubes to prevent improper fit when assembling the pen. Some kits may require you to turn a barrel trimmer adapter. A disc sander may also be used to square the ends of the blank.

2 Setup & Turning

1. Mount the clip/cap bushing (.567" dia.), short tube, center band bushing (.567" dia.), writing nib bushing (.512" dia.), long tube, and end cap bushing (.480" dia.) onto a pen mandrel. Advance a 60° revolving center into the dimpled end of the mandrel. **DO NOT** over tighten the tailstock or the mandrel nut as this may cause the mandrel to flex, producing an oval pen.

2. Turn both blanks to the desired shape leaving the blanks slightly larger than the bushings.

3. Sand the blanks using progressively finer grits of sandpaper, then apply your favorite finish.



Drill: 12.5mm & 10.5mm

Blank: 3/4" x 3/4" x 5"

3 Assembling the Project

BEFORE ASSEMBLY: Read the assembly instructions completely, then layout the project parts according to the drawing. This will help familiarize yourself with the parts and how they will go together. We strongly recommend using a vise or clamp with wooden jaws when assembling to avoid damaging the parts.

1. Slide the clip onto the cap, then press them into the top of the short tube.

2. Press the center band coupler, black end first, into the opposite end of the short tube.

3. Press the end cap coupler into the smaller end of the long tube, then screw the end cap onto the end cap coupler.

See figure 1 for Threaded End Cap assembly.

4. Slide the trim ring, aligned as shown below, over the unthreaded end of the nib coupler, then press them into the larger end of the long tube.

Rollerball- Insert the spring then the ink refill into the long tube. Thread the rollerball nib into the nib coupler.

Fountain- Attach the ink cartridge to the back of the fountain nib, then thread the fountain nib into the nib coupler.

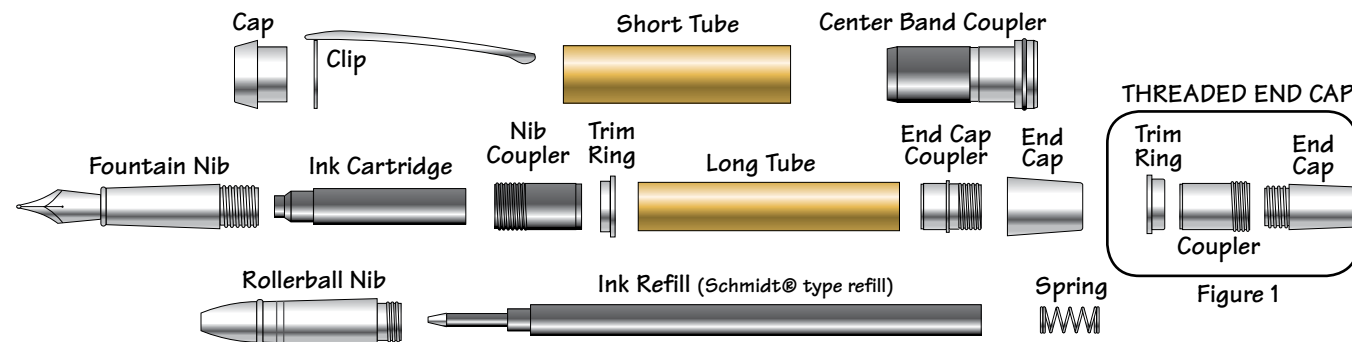


Figure 1