

Bullet Twist pen by Berea



Needed:

Mandrel A; drill 10 mm; bushing 26A

Preparing the blank

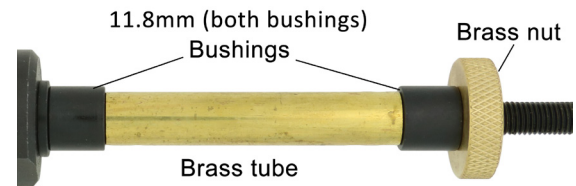
1. Cut the blank approximately $\frac{1}{4}$ " longer than the length of the brass tube.
2. Drill the blank lengthwise through the center with the 10 mm drill bit.
3. Polish the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate wax– to keep the glue from getting into the tube. Just push the ends of the tube into a thin section of the material to form a plug. *This is very important: glue inside the tube is a common cause of kit failure.*
5. Roll the tube in the glue. Insert the tube with a twisting motion until it is equidistant between both ends of the blank.
6. Set aside until the glue has had time to reach its maximum strength.

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7. When the glue has cured, use a hobby knife to remove the plugs from the ends. Using a barrel trimmer of the proper size or the proper jig and a disk sander, square off the ends of the blank until you can see bright brass tube, and stop. Do not shorten the tube.

Turning the blank



1. Assemble the blank on the mandrel using the 26A bushing set following the diagram above.
2. Lightly tighten the mandrel and secure. Do not over-tighten or apply excessive force or you risk bending the mandrel, which will cause your pen to come out oval. A spacer may be installed to give you more room between the thumbnut and the last bushing.
3. Turn the pen blank to the desired shape using the bushings as a sizing guide.
4. After turning the blank, sand the

surface in progressive steps until you get to 400 or 600 grit.

5. For a smooth finish, sand with Micro Mesh to 12,000 grit and use a finish of your choice.
6. Remove the blanks from the mandrel.

Assembling the pen

1. Press the threaded transmission adaptor into the large end of the cartridge body.
2. Press the bullet nib into the other end of the cartridge body.
3. Insert the refill, with the spring in place, and screw on the transmission. Check for proper operation of the transmission and refill.
4. Press the decorative ring into one end of your finished blank.
5. Press the transmission extender tube onto the small end of the finial adaptor.
6. Press this assembly into the other end of your blank. Be sure to place the notch in the finial adaptor where you want the clip to be located.
7. Place the finial cap through the hole in the rifle clip.
8. Align the clip with the notch in the finial adaptor and press the finial cap home.
9. Your pen is finished!

