

Glacia pen



Needed:

Mandrel A, bushing 55A, drill 11/32

Preparing the blank

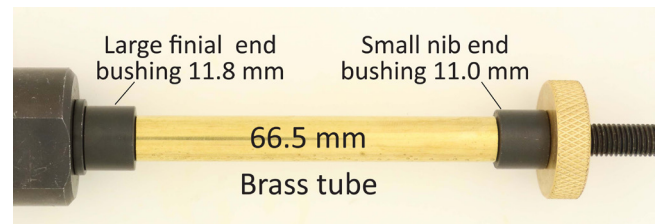
1. Cut the blank about ¼" longer than the pen tube for facing the blank after the tube is glued in.
2. Drill the blank through the centre, lengthwise, with the 11/32 drill bit.
3. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate wax – to keep the glue from getting into the tube. Push the tube ends into a thin section of the material to form a plug. *This is important – glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in glue. Push the tube into the blank with a twisting motion until the tube is an equal distance from both ends of the blank. Set aside until the glue has had time to reach its maximum strength.
6. When the glue has cured, use a hobby knife to remove the plugs from the ends.
7. Using the proper jig and a disk sander,

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square off the ends of the blank until you can see bright brass tube. STOP at this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another common cause of pen failure.*

Turning the blank



1. Assemble the blank on the mandrel using the 55A bushings, following the diagram above.
2. Tighten the tailstock before tightening the blanks on the mandrel. Then tighten the nut that holds the blank.
3. Turn the blank to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
4. After turning the blank, sand the surface in progressive steps until you get to 400 or 600 grit. If a higher polish finish is desired continue sanding with Micro Mesh to 12000 grit.

5. Apply the finish of your choice and polish.

6. Remove the blank from the mandrel.

Assembling the pen

1. Press the threaded nib bushing into the small end of your blank.
2. Screw the nib into the bushing.
3. Slide the clip over the small end of the threaded transmission bushing and press this into the large end of your blank.
4. Slide on the decorative ring.
5. Place the spring onto the refill if it is not

already in place.

6. Drop the refill into the pen and screw in the transmission.

7. Place the finial/cap onto the exposed end of the transmission.

