

Jr Antony pen



Needed:

Mandrel A, drills 10.5 mm and 12.5 mm, bushing 89A

Preparing the blanks

1. Cut the blanks the length of each brass tube, giving a 1/4" extra length for the facing of the blank after the tubes have been glued in.
2. Drill the blank that will use the short barrel lengthwise with the 12.5 mm drill bit.
3. Drill the blank that will use the lower barrel lengthwise with the 10.5 mm drill bit.
4. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
5. Plug the tube ends with a material of your choice – we recommend baseplate wax – to keep the glue from getting into the tube. Just push the ends of the tubes 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.*
6. Roll one of the tubes in glue and insert it into the blank with a twisting motion until the tube is equidistant between both ends

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of the blank. Repeat with the other tube.

7. Set aside until the glue has had time to reach its maximum strength.
8. When the glue has cured, use a hobby knife to remove the plugs from the ends.
9. Using a barrel trimmer of the proper size, square off the ends of the blanks 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 blanks



1. Assemble the bushings and barrels onto the mandrel referring to the image above.
2. Tighten the tailstock before tightening the nut on the mandrel. Don't over-tighten as this may bend the mandrel and cause your pen to come out oval.
3. Turn the pen blanks to the desired shape using the bushings as a sizing guide.
4. After turning the blanks, sand the surface

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

5. If a higher gloss finish is desired, continue sanding with Micro Mesh through to 12,000 grit. Then apply a finish of your choice and polish.
6. Remove the blanks from the mandrel.

Assembling the pen

1. Press the end cap with the trim ring into the smaller end of the long tube (large flange of the trim ring should face the barrel).
2. Unscrew the rollerball nib. Press the nib coupler with trim ring into the larger end of the long tube (large flange of the trim

ring should face the barrel).

3. Insert the spring, then the ink cartridge in the long tube. Thread the rollerball nib into the nib coupler.
4. Push the center band onto the center band coupler.
5. Press the center band and coupler, black end first, into the opposite end of the short tube.
6. Slide the clip onto the top finial and then press them into the top of the short tube.

