

# Beaufort Mistral Ballpoint Pen Kit



william wood-write

penblanks.ca

## Needed:

Mandrel A, drills 10.7mm (or 27/64) and 8.2mm, bushings MIS-BP-BU

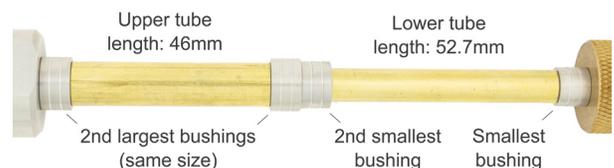
## Preparing the blanks

1. Cut the blanks the length of the brass tubes, giving a little extra length for the facing of the blanks after the tubes have been glued in.
2. Drill the blank that will use the shorter, upper tube lengthwise with the 10.7 mm drill bit.
3. Drill the blank that will use the longer, lower tube lengthwise with the 8.2 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 tube 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 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 barrel trimmers of the proper size or the proper jigs and a disk sander, square off the ends of the blanks until you can see bright brass tube. Not having the proper tube length is another common cause of pen failure.

## Turning the blanks



1. For the upper barrel, the cap finial and centre band ends have the same diameter bushings. For the lower barrel, the larger of the two bushings is for the mechanism connector end. The smaller of the two bushings is for the nib connector end.

2. Turn the pen blanks to the desired shape using the bushings as a sizing guide.
3. After turning the blanks, sand the surface in progressive steps until you get to 400 or 600 grit.
4. 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.
5. Remove the blanks from the mandrel.

is normal to have some threads still showing on the mechanism once it is fully screwed in.

4. Assemble the three-piece centre band. Note: the accent ring has a smaller chamfer on one side on it's inside surface. The accent ring should be fitted with the chamfer nearest to the fixed ring. The other loose ring should be fitted so that the groove is adjacent to the accent ring.
5. Press this centre band assembly into one end of the upper barrel.
6. Pass the upper barrel over the mechanism to seat it on the collar of the mechanism connector. Ensure the cap is clean inside and turns freely.
7. Slide the clip onto the cap finial and press this assembly into the top of the upper barrel.

## Assembling the pen

1. Press the accent cabochon into the cap finial. This will be a very tight fit.
2. Press the nib connector into the small end of the lower barrel and then screw on the nib.
3. Press the mechanism connector into the large end of the barrel and then screw on the mechanism. Note: it

