

Regal pen



william wood-write

penblanks.ca

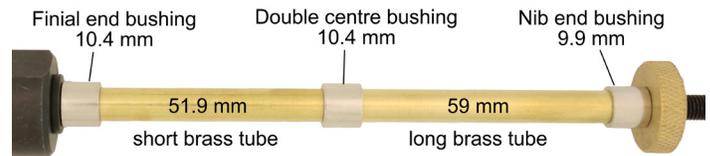
Needed:

Mandrel A, drill 8 mm, bushing 86A

Preparing the blanks

1. Cut the blank 1/4" longer than the length of each brass tube to allow for squaring of the ends after the tubes have been glued in. Drill each blank lengthwise with the 8 mm drill bit.
2. Scuff the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
3. 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.*
4. Roll one of the tubes in glue and insert it into the blank with a twisting motion until it is equidistant between both ends of the blank. Repeat with the other tube.
5. 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. Square off the ends of the blanks until you can see bright brass tube. STOP at this point. This can be done with a pen mill cutter head and pilot shaft or using a 90° jig and a disk sander. Improper tube length is another common cause of kit failure.

Turning the blanks



1. Assemble the bushings and barrels onto the mandrel referring to the image above.
2. Lightly tighten the mandrel and secure.
3. Turn the blanks 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, continue sand using Micro Mesh to 12,000 grit.
6. Apply a finish of your choice and remove the blanks from the mandrel.

Assembling the pen

1. Press the nib into the smallest end of the

lower (longer) blank.

2. Unscrew the transmission from the centre band coupler and press the centre band/coupler into the other end of the lower (longer) blank.
3. Slide the refill into the lower blank through the centre band/coupler.
4. Screw the transmission into the centre band coupler. Test for good operation.
5. Unthread the chrome nut from the clip/finial and press the chrome nut flush into the top of the upper (shorter) barrel, recessed end first.
6. Push the threaded finial part through the hole in the clip and screw this assembly into the chrome nut in the upper barrel.
7. Press the upper barrel over the transmission of the lower barrel.

