

## Surfix pen



### Needed:

Mandrel A, drill 7 mm, bushing 1A

### Preparing the blank

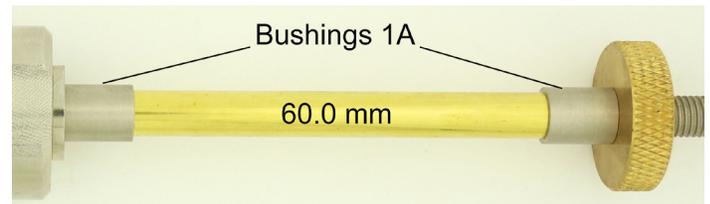
1. Cut the blank 1/4" longer than the brass tube so you can square off the blanks after the tube has been glued in.
2. Drill lengthwise through the blank using a 7 mm drill bit.
3. Scuff the brass tube with sand paper to clean off oxidation and give the glue a better adhesion surface.
4. Plug the ends 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. Insert the tube with a twisting motion until it is equidistant between 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 a barrel trimmer of the proper size,

william wood-write

penblanks.ca

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. *Improper tube length is another common cause of pen failure.*

### Turning the blank



1. Assemble the blank and bushings on the mandrel following the diagram above.
2. Turn the blank to the desired contour making sure that the areas next to the bushings are turned to the size of the adjacent bushing.
3. Sand to 400 or 500 grit. For a smooth finish, continue sanding with Micro Mesh through to 12,000 grit.
4. Apply a finish of your choice and remove the blank from the mandrel.

## Assembling the pen

---

1. Press the nib into one end of one of the finished blank.
2. Press the twist mechanism into the other end of the same blank. Press this in up to the indentation on the mechanism. It is wise to stop just a little short of the indentation and then test the pen by inserting the refill and extending the point. The point should extend about 1/8". Adjust the mechanism accordingly. Make sure you do not go too far. If you do, the pen point will not retract fully.
3. Press the center band into the upper clip assembly.
4. With the refill screwed into the twist mechanism, press the top clip assembly onto the twist mechanism.

