

# Beaufort Tempest Click Ballpoint Pen Kit

william wood-write

penblanks.ca



## Needed:

Mandrel A, drills 10.3mm and 8.1mm,  
bushings TEM-BP-BU

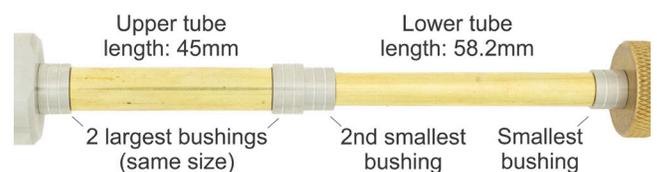
## Preparing the blanks

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 10.3 mm drill bit.
3. Drill the blank that will use the longer, lower tube lengthwise with the 8.1 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 cap connector end. The smaller of the two bushings is for the nib 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.

4. Line up the grain of the two barrels and lightly push the upper (shorter) barrel onto the centre band. With the centre band still slightly attached, unscrew the centre band and, using a press, push it the rest of the way on.

**IMPORTANT:** Do not put pressure on the click button from your pen press. Instead, use a small scrap of pen blank material with a 7mm hole through it. Insert the click button into the hole and press the mechanism assembly into the top of the upper barrel

### Assembling the pen

1. Press the nib into the smaller end of the lower (longer) barrel.
2. Press the cap connector into the other end of the lower (longer) barrel.
3. Screw the centre band onto the cap connector.

5. The refill is accessed by unscrewing the nib.

