

Americana Classic Pen Instructions

Wood Preparation

Blank size and cutting

The blank size for this project is best at 16mm x 16mm x 90mm

Drilling

Mark the centre of the blank to be drilled and drill to required size. To help prevent blanks from over heating or splitting clear the drill often and only drill deep enough for the tube length and trimming

Glueing

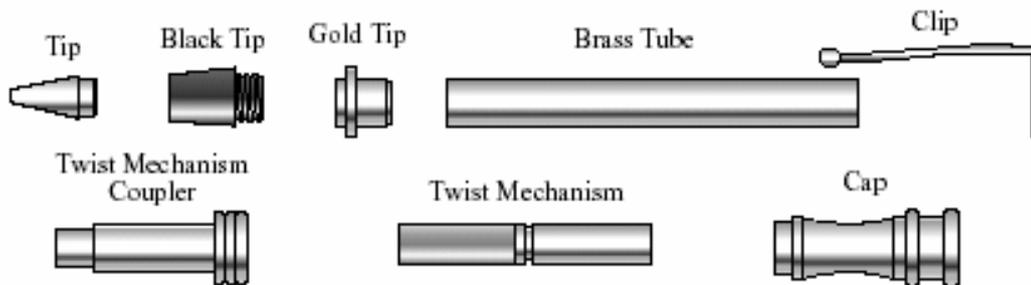
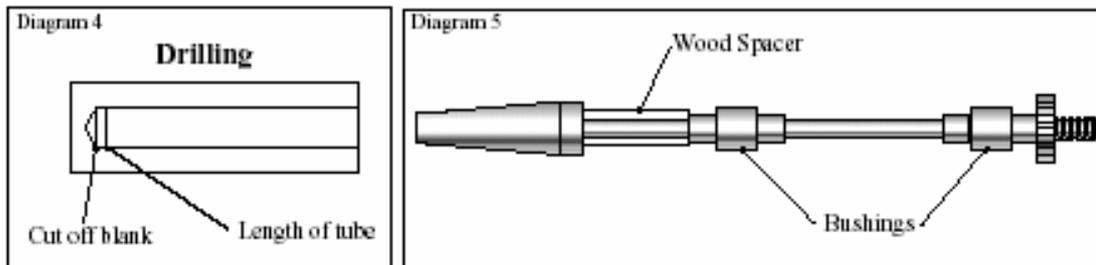
Using 220g sandpaper clean the outside of the brass tube. We recommend cyanoacrylate glue for fast drying or epoxy and polyurethane glues for slow drying. Apply a coat of glue to the tube and rotate the tube as you push it into the drilled blank.

Trimming

Use a barrel trimmer to square the ends of the blank, this is the fastest and cleanest method. You may use a disc sander to sand the ends square with the tube. Note : make sure you do not remove any of the brass tube as this will alter the finished length.

Mandrel & set-up.

Place the bushing and barrel onto the mandrel. You will need to use the olive packer with this project .



Drill: "S" 11/32"
Blank: 5/8" x 5/8" x 4 3/4"



Before Assembly:

Read the assembly instructions completely. Layout the pen parts according to the diagram. This helps familiarize yourself with the parts and how they will go together. We strongly recommend using a vice with wooden jaws during assembly to avoid damaging the parts.

Assembly

1. Press the tip into the end of the black tip and lay it aside.
2. Press the gold tip into the end of the brass tube.
3. Slide the clip onto the twist mechanism coupler then press them into the other end of the brass tube.
4. Press the brass end of the twist mechanism into the twist mechanism coupler. **STOP** pressing when the overall assembly length is FOUR INCHES long. {excluding the assembled black tip}
5. Slide the spring onto the refill point.
6. Slide the refill and spring into the assembled pen body.
7. Screw the assembled black tip into the gold tip and test the pen. If the pen refill does not extend through the point remove the refill and press the twist mechanism a little deeper. **BE CAREFUL NOT TO PRESS IT IN TOO FAR.**
8. Slide the cap over the mechanism to complete the pen