

MAGPEN Instructions

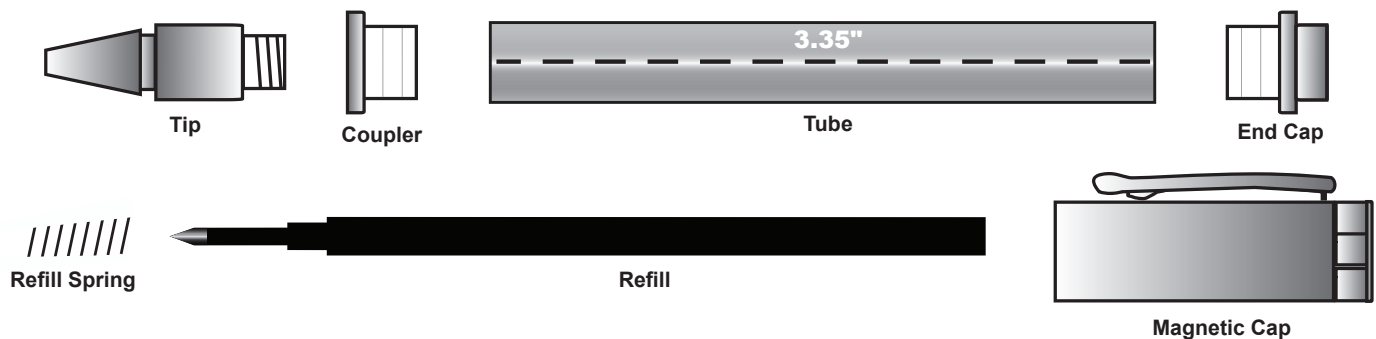
Kit Features

- Ink refills (RE-RB2)
- Overall length: 5-3/16"
- Magnetic Cap

Required Accessories & Materials

- 7mm mandrel
- 2-pc. Magpen bushing set (PKMAGPEN-BU)
- Drill bit – 10.5mm (DB10.5mm)
- Universal trimming kit (BTRIMKIT8)
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Parts and Assembly



BLANK PREPARATION

The Magpen has a single tube measuring 3.375". **Cut** your blank approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. Use a medium drill speed to **drill** the blank. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blank, **sand** the exterior of the brass tube to roughen its surface and use CA **glue** to glue the tube inside the blank. Sand or barrel trim to **square** the ends of the blank.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. The pen's bushings have an outside diameter of .51" (see Diagram B). **Turn** the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

ASSEMBLY

(Line up finished parts according to Diagram A)
To avoid damage to components when assembling, use a vise with covered jaws or one of WoodTurningz' pen presses.

1. If coupler comes pre-installed on tip, unscrew for assembly.
2. Layout parts according to diagram A.
3. Press coupler into either end of the barrel.
4. Press end cap into the other side of the barrel.
5. Drop spring into the opening in the coupler.
6. Pull the refill cover off the refill, slide the refill into the barrel pushing the spring to the end towards the end cap.
7. Screw the tip over the refill into the coupler.
8. Place magnetic cap over refill.
9. The pen is now ready to operate. When not in use, it is recommended to keep the cover on.

Diagram B - Bushings

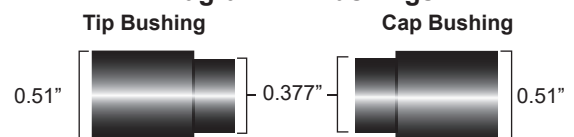


Diagram C - Turning the Pen

