

Fig. 1

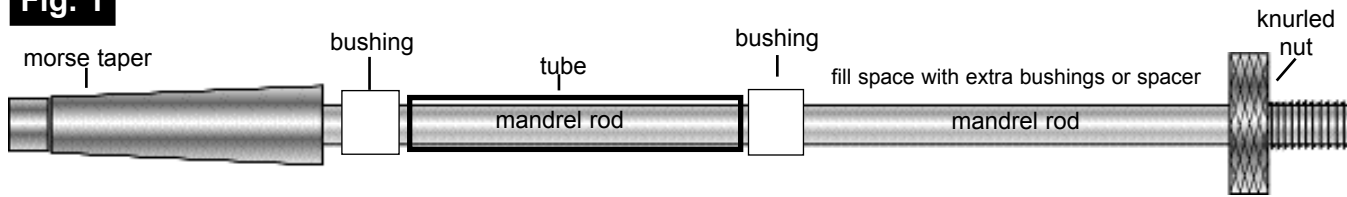
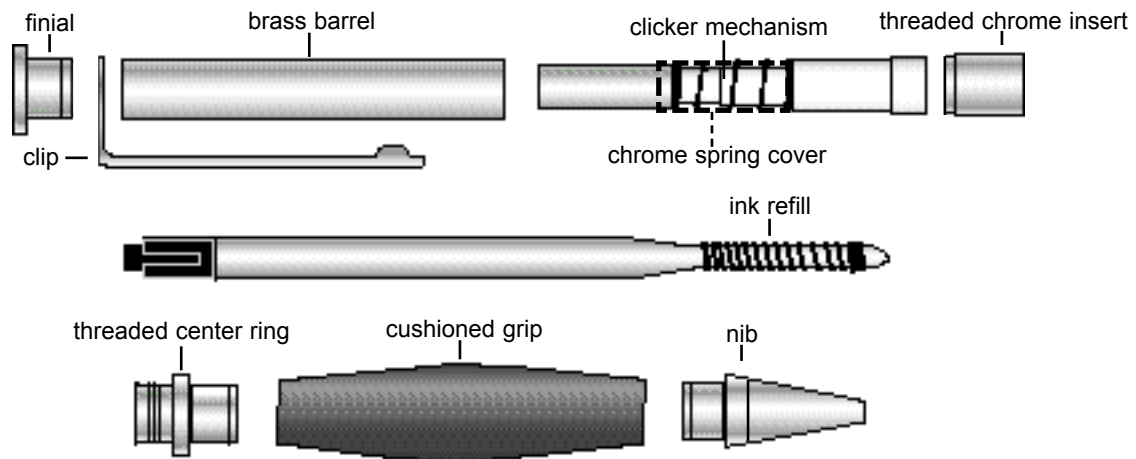


Fig. 2



Materials:

- 1) Comfort Grip Pen Kit **508**
- 2) Blank, minimum size:
5/8 x 5/8 x 5"
- 3) 21/64" drill bit **174**
- 4) Maxi-cure Extra-thick CA **184**, polyurethane **196**, or epoxy **189**
- 5) 5/8" barrel facing tool **331** with Ameroclassic pilot **334**
- 6) Ameroclassic mandrel and bushing set **381**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP combo **109**, or Crystal Coat **104**

Preparation:

- 1) Cut blank approximately 1/4" longer than its respective tube.
- 2) Drill blank with a 21/64" drill bit **174**.
- 3) Glue tube into blank .
- 4) When glue has cured, square ends with barrel facing tool.

***Note:** Only one barrel needs to be turned for this. You may do two pen barrels at one time by using all three bushings or one pen barrel by using two bushings and spacers to take up extra space on the mandrel.*

Turning:

- 1) Turn on an Ameroclassic mandrel with bushing set 381.
- 2) Turn blanks down to bushings or shape as desired.
- 3) Sand through 600 grit and finish with HUT PPP combo. Finish with a two-step process; first apply PPP Satin Gloss, then PPP High gloss for a perfect pen polish, or HUT Crystal Coat!

Assembly:

- 1) Press fit nib into one end of cushioned grip.
- 2) Push center ring. into other end of cushioned grip.
- 3) Slide clip onto finial and press this into one end of turned blank.
- 4) Slide chrome spring cover over top of clicker mechanism.
- 5) Drop clicker mechanism into other end of turned blank.
- 6) Press chrome insert into open end of the blank, beveled end first.
- 7) Insert ink refill with spring attached into lower barrel. Screw on upper barrel and now you are ready to write with a soft and easy grip!



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