



Fig. 2

Materials:

- 1) Ameroclassic Twist pencil kit **538, 539, 568, 1458**
- 2) Blank, minimum size: 5/8 x 5/8 x 5"
- 3) 21/64" drill bit **174**
- 4) Maxi-cure Extra-thick CA **184**, epoxy **189**, or Polyurethane **196**
- 5) 5/8" barrel facing tool **331** with pilot **334**
- 6) Ameroclassic mandrel and bushing set **326**
- 7) Sanding rolls, 4 pk **1120**
- 8) HUT PPP combo **109**

7-30-04

Preparation:

- 1) Mark blank using tubes as guides. Cut blank in two pieces, each approximately 1/8" longer than its respective tube.
- 2) Drill blanks with a 21/64" drill bit.
- 3) Glue **large diameter** (outer) tubes into blanks.
- 4) When glue is cured, square the ends with barrel facing tool. Do not remove any brass. This pen will not function properly if tubes have been altered.

Turning:

- 1) Turn on an Ameroclassic mandrel with bushing set **326**. Arrange bushings and tubes as shown. (Fig. 1)
- 2) Turn wood down to bushings. The barrels should have straight, Ameroclassic profile. Cap barrel should measure between 1-3/4" to 1-13/16".
- 3) Using a parting tool, remove 3/16" of material down to brass tube on the center ring end of cap. (Fig. 3) Make sure all glue is off brass.



- 4) Sand and finish with HUT PPP combo.

Assembly:

- 1) Press assembled center ring over exposed portion (Fig. 3) of large diameter brass tube on cap barrel, flat end first. (Fig. 2) Using a small piece of rolled-up sand paper, remove rough edges from inside of brass tube under center ring.
- 2) Press the beveled end of brass clip bushing into either end of small diameter inner tube until flush. Slide this tube, open end first, into clip end of cap tube. It will be a snug fit.
- 3) Insert finial through hole in clip and screw into brass clip bushing (top of cap).
- 4) Press fit center stabilizer ring into center end of lower barrel. Slide nib ring onto black center. Push fit black center into nib end of lower barrel.
- 5) Insert lead mechanism through open end of lower barrel, brass end first. While holding lead delivery unit in place, screw on gold nib tip. Tighten securely.
- 6) Push cap over exposed portion of lead delivery unit. Turn cap clockwise until lead is advanced to desired position.

Lead replacement: Rotate lead mechanism clockwise as far as it will go, clearing mechanism of old lead particles. Rotate counter-clockwise to a point where the new piece of lead will go completely into the pencil except for the last 1/8". Press exposed portion of lead against a solid surface to seat lead in the mechanism. Pencil uses .7mm lead.

