

Fig. 1

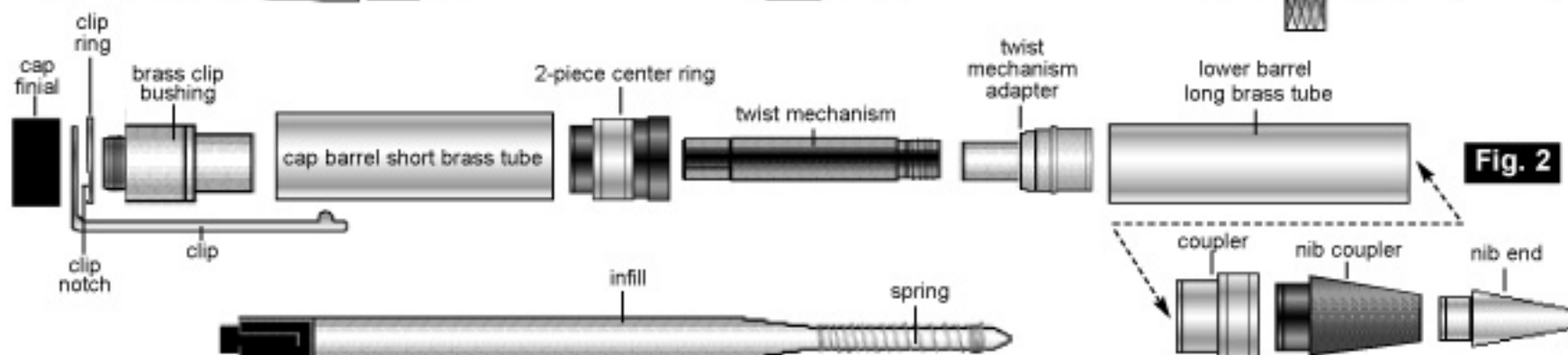


Fig. 2

Fig. 3

Materials:

- 1) Titan Ballpoint pen kit **554**
- 2) Pen blank, minimum size: 3/4 x 3/4 x 5"
- 3) 17/32 drill bit **149**, & 31/64" drill bit **176**
- 4) Maxi-cure Extra-thick CA **184**, epoxy **189**, or polyurethane **196**
- 5) 3/4" barrel facing tool **332** with pilot **335**
- 6) Amero-classic mandrel and bushing set **306**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP combo **109** or Hut Crystal Coat **104**

Preparation:

- 1) Cut blank in two pieces, each approximately 1/4" longer than its respective tube.
- 2) Drill shorter blank with a 17/32 drill bit. Drill longer blank with a 31/64" drill bit.
- 3) Glue tubes into blanks.
- 4) When glue is cured, square ends with barrel facing tool.

Turning:

- 1) Turn on an Amero-classic mandrel with bushing set 306, which consists of four step bushings (2 large & 2 small). Arrange bushings and tubes as shown. (Fig.1)
- 2) Turn blanks down to bushings. The larger, shorter barrel will serve as the pen cap.
- 3) Sand 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 use HUT Crystal Coat

Assembly (Fig. 2 & 3):

- 1) Assemble 2-piece center ring; put gold center ring on black center ring holder.
- 2) Insert 2-piece center ring in one end of large short barrel. Press the brass clip bushing into other end of tube, threads out. Put clip into notch on clip ring and slip both over clip bushing. Screw on finial threads.
- 3) Assemble nib. Press gold nib end into small end of black nib coupler. Press big end of gold coupler into the other end. Press into end of long lower barrel. Press twist mechanism adapter into other end of lower barrel.
- 4) Slide spring onto infill and insert through twist mechanism adapter. Screw twist mechanism into twist mechanism adapter.
- 5) Press upper and lower barrels together.