

**Materials:**

- 1) Fat pen kit **571** or **581**
- 2) Pen blank, minimum size 5/8" x 4-1/2"
- 3) 10 mm drill bit **157**
- 4) Maxi-cure Extra-thick CA **184**, polyurethane **196**, or epoxy **189**
- 5) 5/8" barrel facing tool **331** with pilot **335**
- 6) 7mm mandrel and bushing set **357**
- 7) The Spacer **351**
- 8) Sanding rolls, 4 pk. **1120**
- 9) HUT PPP combo **109** or Hut Crystal Coat **104**

Blank Preparation:

- 1) Cut blank in two pieces, each approximately 1/4" longer than its respective tube.
- 2) Drill blanks with a 10 mm drill bit.
- 3) Glue tubes into blanks.
- 4) When glue is cured, square ends with barrel facing tool.

Turning:

- 1) Turn on a 7mm mandrel with bushing set **357**. Each bushing is a different size. Arrange as shown in the following order, from headstock (finial) to tail-stock (nib): .475," .575," .525," & .460" (notched bushing). (Fig. 1)
- 2) Turn blanks down to bushings. Profile pen as shown.
- 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!

Assembly:

- 1) Screw together nib and nib adapter, then press nib assembly into smaller diameter of turned barrel.
- 2) Insert twist mechanism adapter into open end of lower barrel, threaded end out.
- 3) Insert spring and infill into lower barrel. Screw twist mechanism onto twist mechanism adapter.
- 4) Slide gold ring onto center ring. Press center ring assembly into larger diameter of the turned upper barrel.
- 5) If finial stud is not pre-assembled with inner brass tube, press the two together and insert in other end of upper barrel, inner brass tube first, leaving all threads exposed.
- 6) Line up grain and push upper barrel onto lower barrel.
- 7) Orient clip for best presentation and screw on finial.

