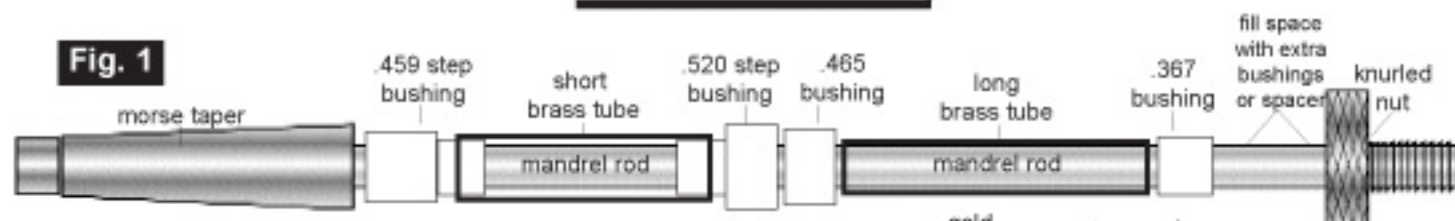
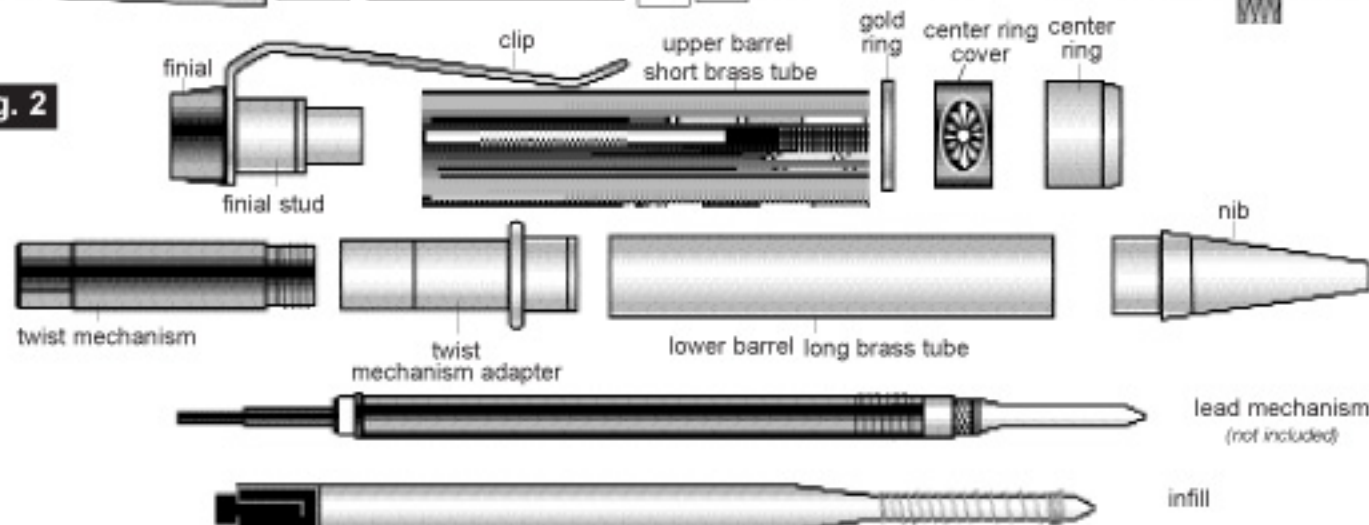


Fig. 1

Fig. 2

Materials:

- 1) Convertible pen kit **586**
- 2) Pen blank, minimum size 5/8" x 5/8 x 5"
- 3) 21/64" drill bit **174** and 23/64 drill **178**
- 4) Maxi-cure Extra-thick CA **184**, polyurethane **196**, or epoxy **189**
- 5) 5/8" barrel facing tool **330** with pilot **334**
- 6) 324 mandrel and bushing set **302**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP 109 or HUTCrystal Coat **104**

Blank Preparation:

- 1) Cut blank in two pieces, each approximately 1/4" longer than its respective tube.
- 2) Drill top blank, short barrel 23/64. Drill bottom, long barrel 21/64
- 3) Glue tubes into blanks.
- 4) When glue is cured, square ends with barrel facing tool.

Turning:

- 1) Turn on a 324 mandrel with bushing set **302**. Each bushing is a different size. Arrange as shown in the diagram
- 2) Turn blanks down to bushings. Profile pen as shown.
- 3) With a parting tool remove 3/16" of material, down to the brass tube on the center ring end of the cap barrel. Make sure all glue is off the brass.
- 4) 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!
- 5) If present, discard extra spacer bushing.

Assembly:

- 1) Press nib into nib end of lower barrel.
- 2) Press twist mechanism adapter into open end of lower barrel, threaded end out.
- 3) Screw twist mechanism onto twist mechanism adapter.
- 4) Assemble center ring and press onto bottom end of cap barrel. Press clip assembly into top end of cap barrel.
- 5) Line up grain and push upper barrel onto lower barrel.
- 6) Lead mechanism and ball point infill are interchangeable.

