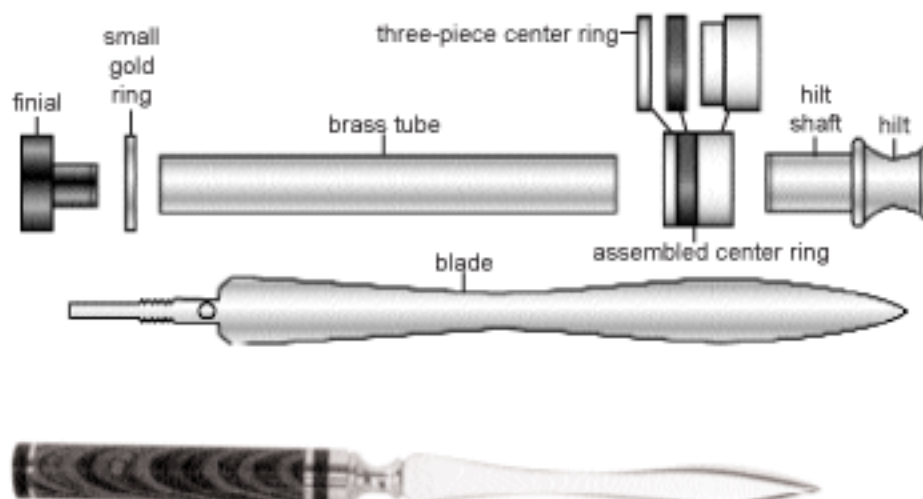
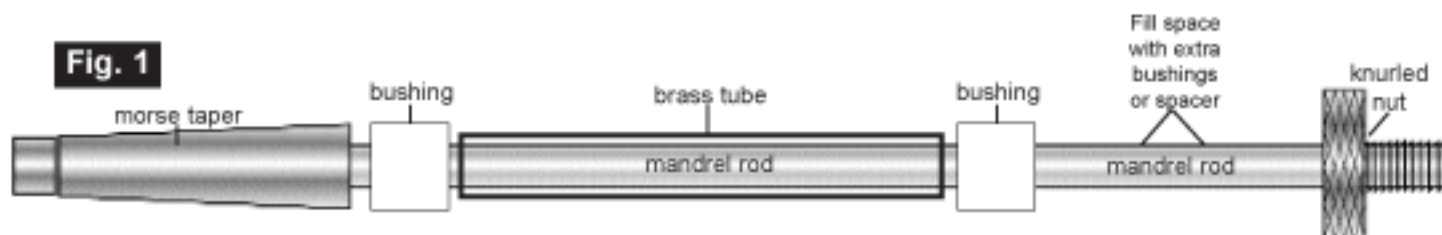


Fig. 1**Fig. 2****Materials:**

- 1) Ameroclassic wavy letter opener kit **626, 1426**
- 2) Pen blank, minimum size 5/8" x 2-3/4"
- 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 pilot **334**
- 6) Ameroclassic mandrel and bushing set **326**
- 7) Sanding rolls, 4 pk. **1120**
- 7) HUT PPP combo **109** or Hut Crystal Coat **104**

Blank Preparation:

- 1) Cut blank approximately 1/4" longer than its respective tube.
- 2) Drill blank with a 21/64" drill bit.
- 3) Glue tube into blank.
- 4) When glue is cured, square ends with barrel facing tool.
- 5) Turn on an Ameroclassic mandrel with bushing set **326** (you only need to use the 2 larger diameter cap bushings). Arrange bushings as shown (Fig. 1). Fill excess mandrel space with extra bushings.

Turning:

- 1) Turn blank down to the bushings. The barrel should have the typical straight Ameroclassic profile.
- 2) Using a parting tool, remove 3/16" of material down to brass tube on the center ring end of barrel. (Fig. 3) Make sure all glue is off 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!

Assembly:

- 1) Assemble three-piece center ring as shown (Fig. 2). Slide center ring onto hilt shaft, tapered end first. Press hilt into exposed end of brass tube. The center ring should fit over 1/8" of exposed brass tube.
- 2) Place small gold ring on finial.
- 3) Push finial with gold ring into top of barrel.
- 4) Screw blade into hilt.