

## TURNING SUPPLIES &amp; REPLACEMENT PARTS

Set of Bushings .....	050-4035
37/64" Drill Bit .....	075-3764
15/32" Drill Bit .....	075-1532
Replacement Tubes (2) .....	050-9205
Schmidte Rollerball Refill .....	050-4416
Fountain Ink Refill .....	050-7057
Accessory Kit (drill bits, bushings) .....	850-0321

## HOW TO CONTACT US...

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**CRAFT SUPPLIES USA**  
THE WOODTURNERS CATALOG

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# Gentlemen's & Statesman Pen



Drill: 37/64" &amp; 15/32"

Blank: 7/8" x 7/8" x 5 1/2"

For use with the following: 050-4020, 050-4460, 050-0396, 050-4030,  
050-4461, 050-0397, 050-0322, 050-0321, 050-0324, 050-0323, 050-4140,  
050-4141

**SAFETY:** Follow all safety instructions that came with your lathe. Always wear proper eye and ear protection.

**CUTTING AND DRILLING:** Measure the length of each brass tube and cut each blank 1/4" longer than each tube. Once you've marked the center of each blank, secure the blanks in a clamp or vise. Then drill each blank using the correct sized bit(s) at a speed of 2,000 to 3,000 rpm, clearing out the chips after every 1/2" of drilling. When using larger bits or drilling plastic, use lower speeds. To prevent blow outs stop drilling 1/8" from the bottom of the blank, then cut off the end of the blank leaving the drilled blank 1/8" longer than the tube.

**GLUING:** Lightly sand the exterior of the brass tube with 220 grit sandpaper to prepare it for gluing. Use thick cyanoacrylate glue for an instant bond or epoxy for additional working time. After applying a coat of glue to the tube, insert it into the blank, rotating the tube as you go, ensuring an even distribution of glue. Make sure there is enough wood on each end of the tube to allow for trimming.

**TRIMMING/TRUING:** Square the ends of each blank using a barrel trimmer. Do not trim away the brass tubes to prevent improper fit when assembling the pen. Some kits may require you to turn a barrel trimmer adapter. A disc sander may also be used to square the ends of the blank.

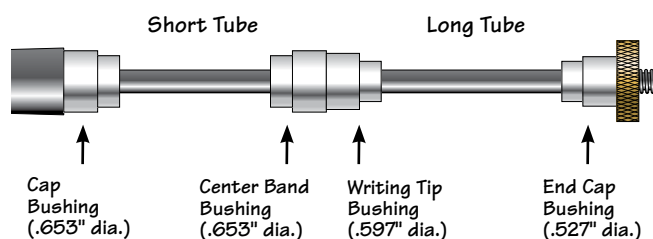
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## Setup & Turning

1. Mount the cap bushing (.653" dia.), short tube, center band bushing (.653" dia.), writing tip bushing (.597" dia.), long tube, and end cap bushing (.527" dia.) onto a pen mandrel. Advance a 60° revolving center into the dimpled end of the mandrel. **DO NOT** over tighten the tailstock or the mandrel nut as this may cause the mandrel to flex, producing an oval pen.

2. Turn both blanks to the desired shape leaving the blanks slightly larger than the bushings.

3. Sand the blanks using progressively finer grits of sand paper, then apply your favorite finish.



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## Assembling the Project

**BEFORE ASSEMBLY:** Read the assembly instructions completely, then layout the project parts according to the drawing. This will help familiarize yourself with the parts and how they will go together. We strongly recommend using a vise or clamp with wooden jaws when assembling to avoid damaging the parts.

1. Press the end cap into the smaller end of the long tube.

2. Press the unthreaded end of the nib coupler into the larger end of the long tube.

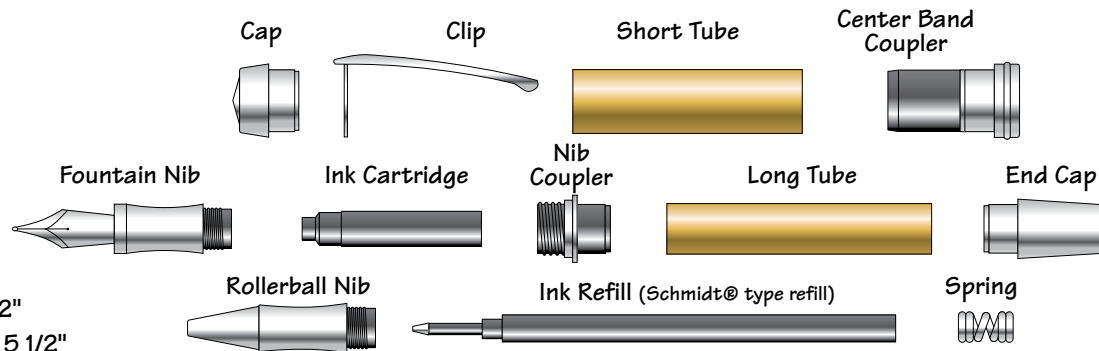
3. **Rollerball Pen:** Insert the spring then the ink refill into the long tube. **Fountain Pen:** Attach the ink cartridge to the back of the fountain nib.

4. Thread the rollerball or fountain nib into the nib coupler.

5. Slide the clip onto the cap, then press them into the short tube.

6. Press the center band coupler into the other end of the short tube to complete the pen.

**NOTE:** These pens use a coarse thread for quick and smooth opening and closing. This coarse thread has 4 starting points. In order to have the wood grain line up, the pen must be closed using the same starting point each time.



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