



Archer Pen Kit Instructions (AZ 140 & AZ141)

Supplies Needed:

23/64" Drill Bit, Pen Blank $\frac{3}{4}$ " x $\frac{3}{4}$ " x 3", Archer Bushings, Pen Mandrel, Drill Chuck or Drill Press, Glue (Medium CA or 2 Part Epoxy), Insertion Tool, Barrel Trimmer or Squaring Jig, Sand Paper & Finish of choice, Pen Press & Eye protection.

Cutting & Drilling the Pen Blank:

Cut your pen blank 1/8" longer than the brass tube.

Drill the pen blank (23/64" drill bit) using a drill press or drilling on the lathe with a drill chuck.

Gluing the brass tube into the pen blank:

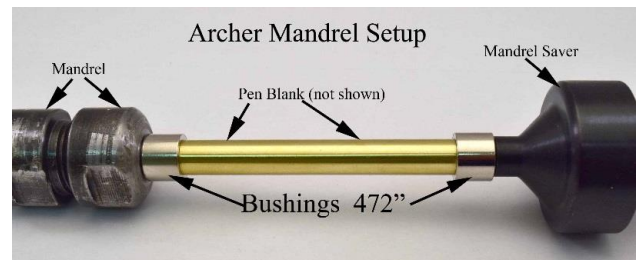
Rough up the pen tube using 80 grit sandpaper so the glue will adhere better to the pen blank.

Apply a liberal amount of glue on a piece of wax paper and roll the pen tube in the glue. Using an insertion tool, put the pen tube onto the insertion tool and roll it into the glue. With a twisting motion insert it into one end of the pen blank. Remove the pen tube, roll it in the glue again and then insert it into the other end of the pen blank twisting it as you go inside the pen blank. This time leave it inside the pen blank.

Trimming the pen blank:

You need to make sure the inside of the pen tube is perpendicular to the outside and this is done by "squaring up" the pen blank. Using either a barrel trimmer or a squaring jig, remove the excess wood from the pen blank until it is just touching the brass tube. DO NOT REMOVE too much of the brass tube or your pen parts will not fit together properly!

Mandrel Setup: Place one of the Archer Bushings onto the mandrel followed by the blank and then other bushing. If using a mandrel saver just slide the mandrel saver over the mandrel until it makes contact with the pen blank.



Assembly of your Pen: Layout the parts of the pen kit as shown in the image. Chamfer the top and bottom of the brass tube. This will help align the parts when pressing into the finished pen blank. Start by pressing the cap/clip assembly into the upper part of your turned blank. The nib coupler and nib are screwed together so press this assembly into the other end of your turned pen blank. Now, unscrew the nib from the coupler and insert the refill WITH the spring on the end into the body of the pen and screw the nib back onto the nib coupler. Twist the cap clockwise to advance the refill and counter clockwise to retract the "Parker Style" refill. **Congratulations on assembly of your Archer Pen Kit!**

