

Berea Hardwoods Co., Inc
Pen Instructions

Berea Hardwoods MP208 BallPoint/Roller Ball Pen (Berea #MG1807/B-xxx)

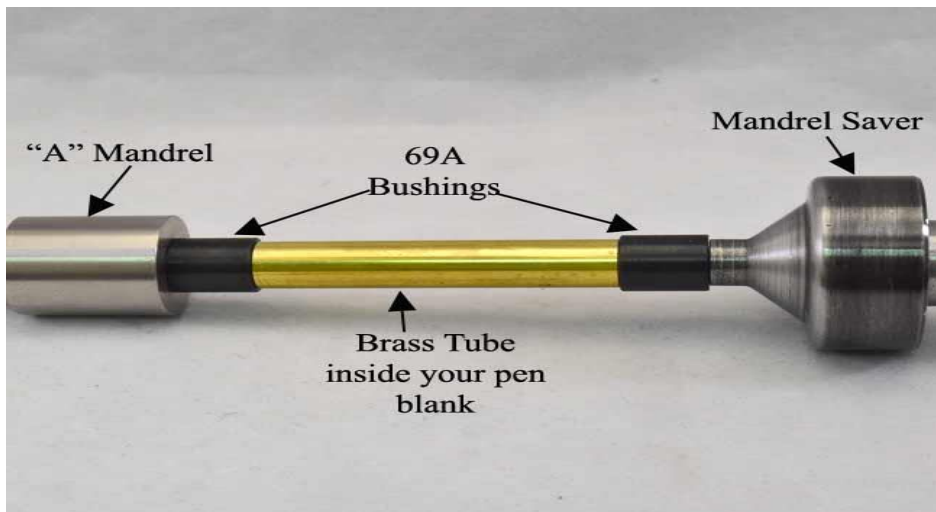


Needed: Mandrel A, Bushings 69A, Drill Letter V, Wood Size $\frac{3}{4}$ " x $\frac{3}{4}$ "

Preparing the Material Blanks

1. Only 1 material blank is required for this pen. Cut the material blank slightly longer than the brass tube.
2. Drill the blank through the center, lengthwise, with a Letter V bit.
3. Scratch up the brass tube with sandpaper and plug the end of the tube with base plate wax. This will keep the glue from getting into the tube.
4. Glue your plugged tube into your pen blank using either two part epoxy or medium CA glue. Roll the tube in the epoxy or CA glue and with a twisting motion, place it inside the pen blank going in and out several times making sure that the glue has covered the inside of the pen blank.
5. Let the blank dry thoroughly. Once dry remove the wax plug with a hobby knife.
6. Use a barrel trimmer or a squaring jig to square the ends of the blank until it just touches the brass pen tube. Be careful not to remove too much of the blank, this may cause a failure of the pen when you assemble it later.

Turning the Blank



1. Assemble the blank on the mandrel using the 69A bushings. Since these are the same size no special orientation is needed.

2. Turn the blank to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
3. After turning the blank, sand the surface in progressive steps until you are satisfied. Apply a finish of your choice and remove blank from the mandrel in preparation of assembly.

Assemble the Pen



1. Press Center Band into one end of Cap Tube.
2. Slide the Clip onto the Cap Finial Press the assembly into the Clip Bushing.
3. Press the completed assembly into other end of the Cap Tube.
4. Lay the cap aside.
5. Press the Threaded Nib Coupler into one end of your blank.
6. Press the Threaded Body Coupler into the other end of your blank.
7. Press the Finial into the Finial Insert.
8. Thread the Finial Assembly into one end of the Threaded Coupler.
9. Decide on a Ballpoint refill or a Roller ball Refill. **Note: Roller ball refill is not included in kit and is a Special size, a standard Roller Ball refill will not work. Make sure to attach the spring on the Roller ball refill as shown above.**
10. Thread the Nib into the other Threaded Coupler.
11. Sit back and admire your work!

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