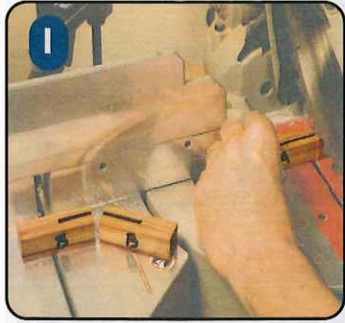
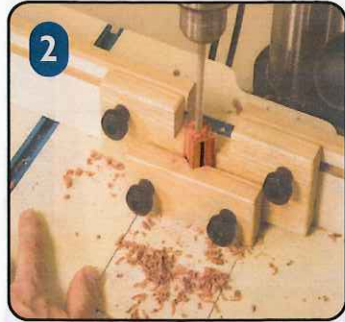


## Preparing the material



### 1. Cutting the blank

- Draw a line or letters for grain match. This allows parts to be assembled on the mandrel correctly.
- Cut blanks 1/4" longer than the tubes to allow for trimming.



### 2. Drilling the blank

- Mark center of the blank end.
- To ensure blank is 90° to drill press table, secure blank using a Rockler Pen Drilling Jig (26614).
- Bore hole to size listed in instructions.
- Use slow drill speed to reduce chance of "blowout" and clear the bit frequently.



### 3. Gluing the tube

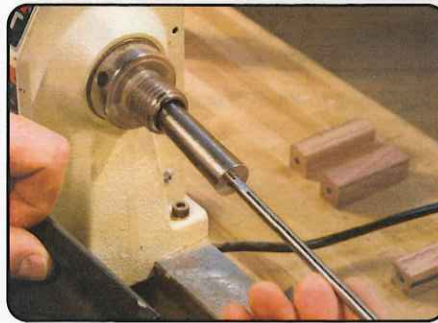
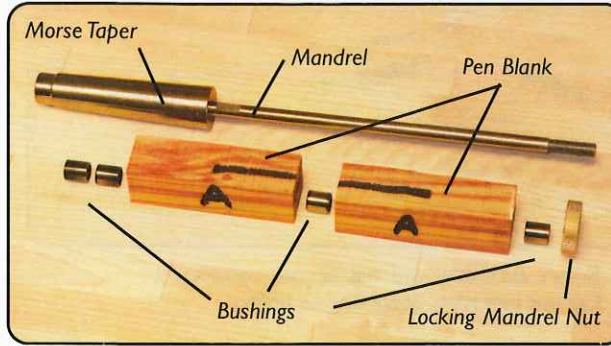
- Rough the surface of the brass tubes with fine sandpaper for equal distribution of glue.
- Apply quick drying CA glue.
- Insert with continuous twisting motion until flush with end of blank.



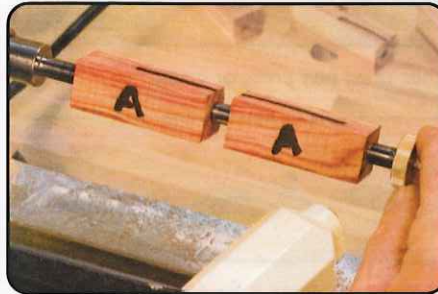
### 4. Trimming the blank

- Use barrel trimmer to square ends of pen blank until you just contact the bright brass end of tube.
- Barrel trimmer will also remove excess glue from inside the brass tube.

## Mandrel/lathe setup\*



- Insert Morse Taper end of mandrel into head stock and insert live center in tail stock.



- Slip on bushings and pen blank per the instructions with kit and secure with mandrel nut.
- Match lines or letters so they are facing each other.

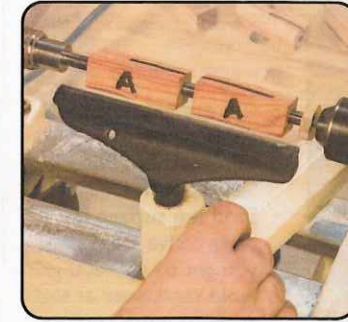
**Caution:** Do not overtighten the mandrel nut



- Snug up mandrel with the tail stock.
- (Do NOT over tighten, may damage mandrel)

\* For safety, please unplug power tool prior to setup

## Turning blanks

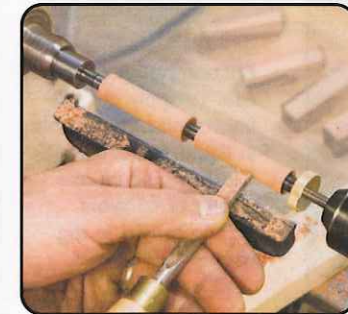


- Adjust lathe speed based on application.
- Slower speed to rough out.
- Faster speed to finish.
- Set tool rest parallel to the blank.
- Adjust height of rest so it is centered on the blank.
- Rotate manually to ensure there is adequate clearance

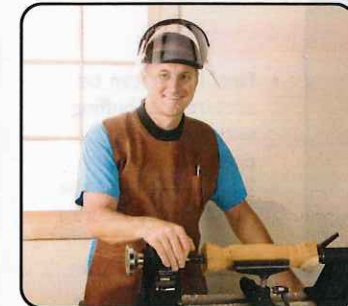


- Use a gouge to rough turn the blank to a cylinder.

**Note:** A pen turning set includes a gouge, scraper, and parting tool.



- Turn blank to desired contour, making sure that the wood next to the bushings is flush (per kit instructions for proper alignment).
- Use of a sharp turning tool will reduce the amount of sanding.



- For safety, please use proper eye protection, avoid loose clothing, tie back long hair, unplug lathe during setup.

## Finishing



Tool rest must be removed prior to sanding.

- Cut sandpaper into 1" strips or use our Woodturner's Multi-Roll Sanding Pack (35711).
- Sand the surface in progressive steps until you get to 400-600 grit.
- Hold sandpaper at slight angle to work surface.
- Continually move the paper left and right to avoid rings around the blank.



- If a higher polish finish is desired, continue sanding with micro mesh up to 12,000 grit.
- Sand lightly to avoid heat build-up.

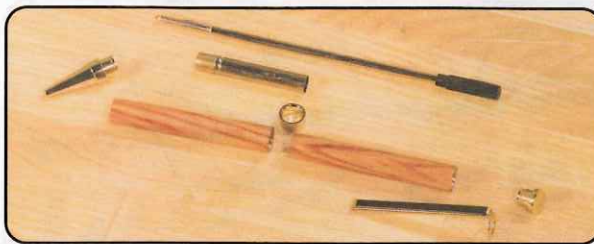


- Friction polish offers an easy-to-apply, durable finish. Polishes available in liquid, paste, or stick.
- Cloth should be in a small pad to avoid getting caught in the rotating work.



- Final luster can be acquired by buffing with a soft, dry polishing cloth.
- Run the lathe at the highest speed during buffing.

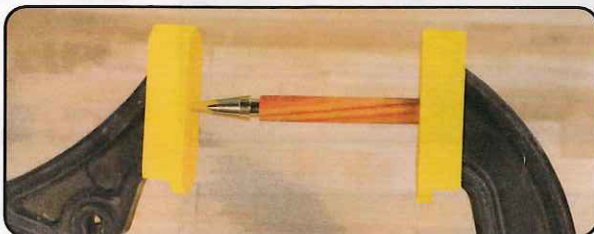
## Assembly



- Before assembly, read instructions completely. Lay out pen parts according to photo.



- Line up the parts according to kit instructions. *Note: You have one chance to assemble parts. Be sure you have them placed correctly.*



- Press parts together using pen press or clamp.



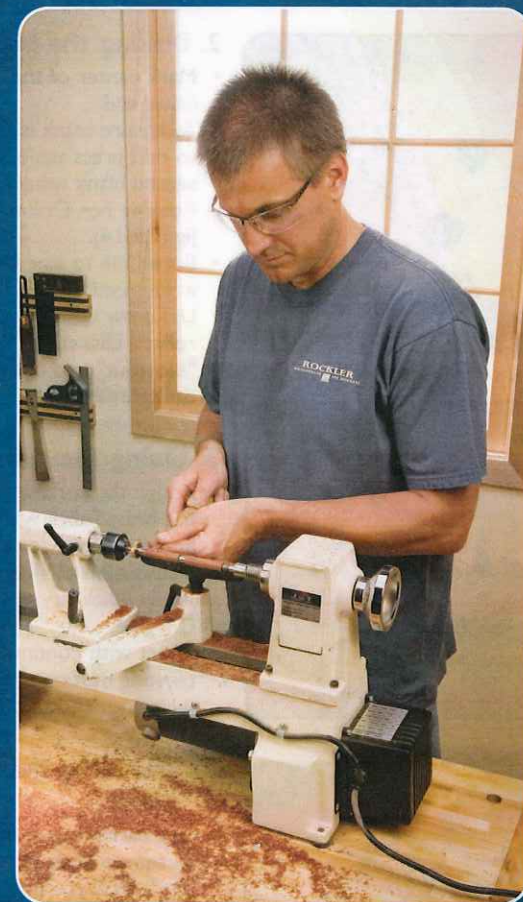
**Congratulations!** You now have a beautiful handmade pen to keep or give as a gift.

**Rockler carries a complete line of pen turning supplies: blanks, hardware and tooling. Stop in today or visit [Rockler.com](http://Rockler.com) to check out the complete selection.**

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# Discover the Fun of Pen Turning



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