

STEPS FOR MAKING VETERANS PEN BLANKS

BY OZARK WOODTURNERS 11/10/15

THIS PROCEDURE IS FOR **7MM SLIMLINE PENS**. OTHER PEN STYLES
MAY REQUIRE DIFFERENT OR ADDITIONAL STEPS

1. PURCHASED PEN BLANK STOCK IS NORMALLY 5 INCHES LONG AND COMES IN 5/8 INCH OR 3/4 INCH BLANKS. IF YOU ARE USING THIS DIMENSIONED STOCK, CUT BOTH PEN SECTIONS FROM THE SAME STOCK AND TRY TO KEEP THE PAIR TOGETHER THROUGH OUT THIS PREPARATION PROCESS TO PRESERVE A COLOR AND GRAIN MATCH.
2. CUT THE PEN STOCK TO 2 1/4 INCHES LONG. (EACH SLIMLINE PEN WILL REQUIRE TWO OF THESE.)
3. CENTER DRILL THROUGH THE STOCK USING A 7MM DIAMETER DRILL BIT. THIS CAN BE DONE ON THE DRILL PRESS USING A VERTICAL HOLDING VISE OR ON THE LATHE. TRY TO GET THE HOLE CENTERED ALL THE WAY THROUGH THE BLANK. DRILL BIT CENTERING BUSHINGS MAKE THE JOB EASIER IF YOU ARE USING A DRILL PRESS. (SEE THE VETERANS COORDINATOR.)
4. THE 7MM BRASS TUBES SHOULD HAVE A ROUGHED OUTER SURFACE TO MAKE BETTER GLUE ADHESION. IF YOUR TUBES ARE NOT OF THIS STYLE, USE SOME 100 GRIT SANDPAPER TO "ROUGHEN" THEM UP.
5. USE 5 MINUTE EPOXY OR MEDIUM OR HEAVY CYANOACRYLATE (CA) GLUE TO SECURE THE TUBES IN THE WOODEN BLANKS. INSURE A GOOD SURFACE COATING ON THE TUBES AND INSERT THEM IN A TWISTING MOTION TO BETTER SPREAD THE GLUE AS THEY ARE INSERTED. **CAUTION: IF USING CA GLUE, THIS STEP NEEDS TO BE DONE QUICKLY OR THE GLUE WILL "SET UP" BEFORE THE TUBE IS FULLY INSERTED.** WHEN THE TUBE IS FULLY INSERTED, YOU WILL HAVE ABOUT 1/16 INCH OF WOOD EXTENDING BEYOND BOTH ENDS OF THE BRASS TUBE.
6. ALLOW TIME FOR THE GLUE TO SET UP. USUALLY AN HOUR IS ADEQUATE FOR EPOXY AND TWO OR THREE MINUTES IS ADEQUATE FOR CA GLUE.
7. USE A BARREL TRIMMER TO REMOVE THE EXCESS WOOD FROM THE PEN BLANK DOWN TO THE BRASS TUBE. THIS MUST BE DONE CORRECTLY. THE END OF THE BLANK MUST BE SQUARE AND PERPENDICULAR TO THE TUBE OR THE PEN MECHANISM WON'T FIT PROPERLY WHEN ASSEMBLED. YOU MUST ALSO MAKE SURE THAT ANY GLUE ON THE INSIDE THE TUBE IS REMOVED (FOR THE SAME REASON). (THE BARREL TRIMMER DOES BOTH JOBS).
8. REMOVE THE INSIDE BURRS FROM THE BRASS TUBES, (USING A DE-BURRING TOOL), MOUNT THE BLANKS ON A PEN TURNING MANDREL ON THE LATHE AND TURN THE BLANK TO ROUND. IF THE UPPER AND LOWER BLANKS ARE MATCHED, RUBBER BAND THEM TOGETHER.

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9. USING A PEN TURNING MANDREL WITH 7MM BUSHINGS, MOUNT THE PEN BLANKS ON THE LATHE, TURN TO DESIRED PROFILE, SAND, AND APPLY A FINISH.
10. ASSEMBLE THE BLANKS USING A 7MM SLIMLINE PEN KIT ACCORDING TO THE MANUFACTURES DIRECTIONS, USING A PEN PRESS.