

SIERRA PEN KIT



Parts required

Pen mandrel (PM-1 or PM-2)
Sierra pen bush (131-6038BU)
27/64" drill bit (075-0103)
Pen mill (AR-100)
GPW Gap filling ca super glue
Sandpaper

Preparation

1. Cut the desired blank to 3/4" x 3/4" and slightly longer than the tube.
2. Drill lengthwise through the center of the blank using the 27/64" drill bit, then use the pen mill to square the ends.
3. Take some sandpaper and rub it on the brass tube to roughen it up, this makes the glue stick better.
4. Trial fit tube in blank before gluing.
5. Glue the tube into the blank with a twisting action to allow even coverage, allow to dry before turning.

Turning

1. Place the blank on the mandrel with the bushes in each end, use spacers or the adjustable stop to ensure a tight fit.
2. Turn blank to the top diameter of the bushes.
3. Sand to desired finish, then apply your choice of product to protect the wood such as a friction polish or shellac.

Assembly

1. Press the clip and cap assembly into the tube.
2. Place the refill and spring into the nib assembly.
3. Screw the twist mechanism over the refill and into the tip.
4. Slide the tube over the twist mechanism, your pen is now finished.

GPW PTY LTD
1/12 TRADERS WAY CURRUMBIN QLD 4223

www.gpw.au.com