



European Style Pens, Openers & Magnifying Glasses

Product # 06S45, 06S46, 06U90, 124962, 124963, 125268, 126454, 128260, 128262, 141658, 141659, 141660, 142305, 142508, 142509, 142510

1. Cutting Blanks

Pen: Cut two $\frac{3}{4}$ " x $\frac{3}{4}$ " blanks, one $2\frac{3}{4}$ " long and another $2\frac{1}{4}$ ".
Letter Opener: Cut one blank $\frac{3}{4}$ " x $\frac{3}{4}$ " x $2\frac{3}{4}$ " long.
Magnifying Glass: Cut one blank $\frac{3}{4}$ " x $\frac{3}{4}$ " x $3\frac{5}{8}$ " long.

2. Drilling Blanks

Pen, Letter Opener & Magnifying Glass: Drill a 7mm hole lengthwise through the center of each blank.

3. Gluing Blanks to Tubes

See General Instructions for details.

4. Sanding Blanks to Length

See General Instructions for details.

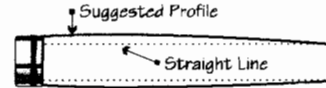
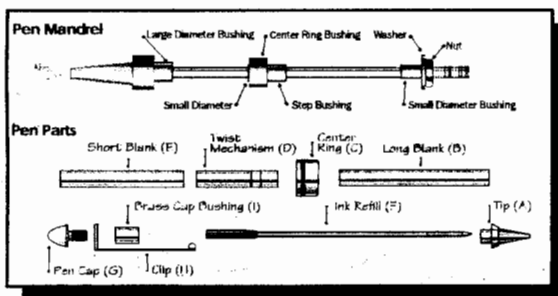
5. Mandrel Preparation

See General Instructions for details.

Pen: The bushing set (06S62) is made up of four pieces, large and small diameter end bushings, a step bushing, and a center ring bushing. These bushings must be placed on the mandrel in the order specified to turn blanks to the proper sizes. See Pen Mandrel Illustration for detail. Place the large diameter (.408" or approx. $\frac{13}{32}$ "), end bushing on the mandrel followed by the short wood blank (E). Next place the center ring bushing on the step bushing so that the small diameter end faces the headstock and the large diameter end faces the tailstock. Next place the longer blank (B), and small diameter (.360" or approx. $\frac{23}{64}$ ") bushing on the mandrel. Secure the bushing/blank assembly on the mandrel using the washer and retaining nut.

Letter Opener/Magnifying Glass: See Letter Opener/Magnifying Glass Mandrel Illustration for detail. Cut a spacer blank from scrap wood and drill a 7mm hole lengthwise through the center of the spacer. *NOTE: the lower, longer tube of the European Style Pen kit may be used instead of the wood spacer.*

Slide the large diameter (.408" or approx. $\frac{13}{32}$ ") bushing on the mandrel followed by the handle blank (D). Next place the center ring bushing on the small diameter end of the step bushing so that the small diameter end faces the headstock and the large diameter end faces the tailstock, and place this bushing combination on the mandrel. Next place the wood spacer on the mandrel followed by the small diameter (.360" or approx. $\frac{23}{64}$ ") bushing. Secure the bushing/blank assembly on the mandrel using the washer and retaining nut.

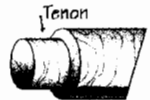


6. Turning the Blanks

See General Instructions for details.

Pen/Letter Opener/Magnifying Glass:

1. Turn a tenon (a projection of wood) on the center ring bushing end of the pen top (E) or handle (D) to accept the center ring bushing. Proceed carefully and check your progress by frequently test fitting the center ring bushing onto the tenon. The Pen/Opener/Magnifying Glass Center Ring (C) will ultimately be glued into place on this tenon. For a snug fit with the Pen/Opener/Magnifying Glass Center Ring (C), the tenon should be approx. $\frac{13}{32}$ " (10.5mm) in diameter and $\frac{3}{16}$ " (5mm) in length.
2. With the tenon complete and the center ring bushing in place on the tenon, turn the short blank (E) if turning a pen, or (D) if turning an opener/magnifying glass, to size using the center ring bushing and large diameter bushing as guides.
3. **Pen Only:** Turn the long bottom blank (B) to size using the large diameter of the step bushing and the small diameter bushing as guides.



7. Finishing the Blanks

See General Instructions for details.

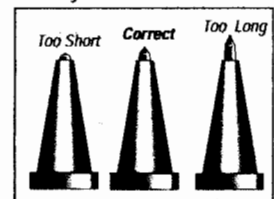
8. Assembly

See General Instructions.

Pen:

1. Using a vise or clamp, press the pen tip (A) into the small diameter ($\frac{11}{32}$ ") end of the long blank.
2. Press the twist mechanism (D), brass end first, into the opposite end of the long blank. The twist mechanism should be pressed into the tube so that approximately $\frac{7}{8}$ " of the chrome portion extends from the blank. Care should be taken so the mechanism is not pressed in too far. If pressed too far, the pen tip will not retract fully into the pen nib. While pressing the

Fully Twisted Position





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twist mechanism into place, test the position by extending the pen tip and noting its location with respect to the pen nib. To test extension/retraction of refill tip, screw refill (F) into twist mechanism (E) and rotate the twist mechanism. Proper placement of the twist mechanism will result in tip/nib position as shown in the illustration to the right. This is a trial and error process.

3. Using a drop of CA glue, secure the center ring (C) band into place on the tenon of the short blank.

4. Place the stud on the gold pen cap (G) through the center hole of the pen clip (H) and screw the stud into the brass cap bushing (I). Press this assembly into the short blank opposite the pen center ring.

5. Complete the pen by pushing the pen top and bottom assemblies together.

Letter Opener:

1. Using a vise or clamp, press a cap/blade bushing (indentation end first) (E) into the bottom (tenoned) end of the handle. If bushing (E) is threaded onto the blade, remove it before press fitting into handle. Screw the stud of the gold cap (C) into the

other cap/blade bushing. Press this assembly into the opposite end of the handle.

2. Using a drop of CA glue, secure the center ring (A) band in place on the tenon of the handle.

3. Screw the letter opener blade (D) into the cap/blade bushing previously pressed into the center ring end of the handle.

Magnifying Glass:

1. Using a drop of CA glue, secure the center ring (C) into place on the tenon of the blank.

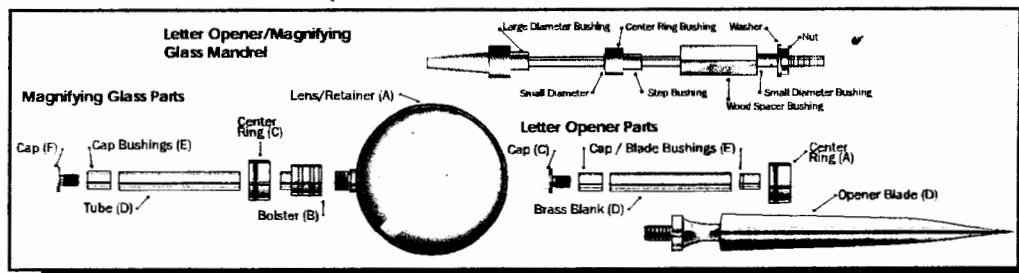
2. Using a vise or clamp, press the Bolster (B) into the tenoned end of the handle until seated against the center ring.

3. Screw the stud of the cap (F) into the cap bushing (E). Press this assembly into the opposite end of the handle.

4. Thread the Lens/Retainer (A) into the bolster (B).

Additional Parts:

06S53	pen replacement tubes (5 pr.)
124732	letter opener replacement tubes (5)
124983	magnifying glass replacement tubes (5)
142300	1 medium/ black Cross refill
142301	1 medium/1 blue Cross refill



To Order Additional Parts Call: 800 225-1153
For Technical Advice Call: 800 535-4486

