

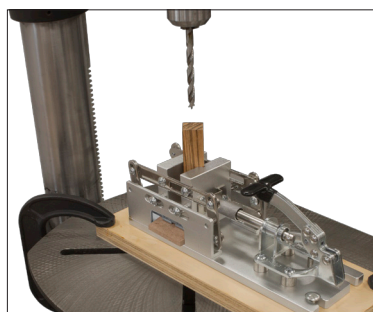
PALISADES PEN INSTRUCTIONS

Pen Blank Size

Select or cut a pen blank that is the appropriate size for the pen you're turning. The pen blank size for this pen kit will be 3/4" x 3/4" x 2-3/8" in length. Additional length has been added to the blank for squaring the ends.



Drill Your Blank



Drill the pen blank with a 27/64" drill bit.

CAUTION:

Placing too much pressure on the bit while drilling may cause the bit to "walk or wander" resulting in splitting the blank. It is good practice to feed the bit slowly in moderate increments and back out repeatedly for chip and debris removal. For best results using a drill press with a fence or a pen vise is recommended.

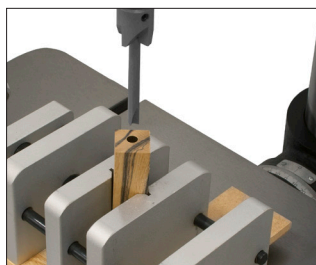
Gluing Tubes To The Blank

Scuff the surface of your tube with 220 grit sandpaper for better adhesion. Using an epoxy or CA glue (not included) spread the glue on to the outside of the tube. Insert the tube into the pen blank hole with a smooth left to right twisting motion to distribute the glue evenly. Center the tube evenly from end to end and allow to dry.

Shop Note:

Depending on what type of glue you use, drying times may vary. It is recommended that you leave the tubes dry overnight. It is also important to not apply to much glue to the tube. Doing so may cause glue to overflow to the inside of the tube.

Trim The Blanks

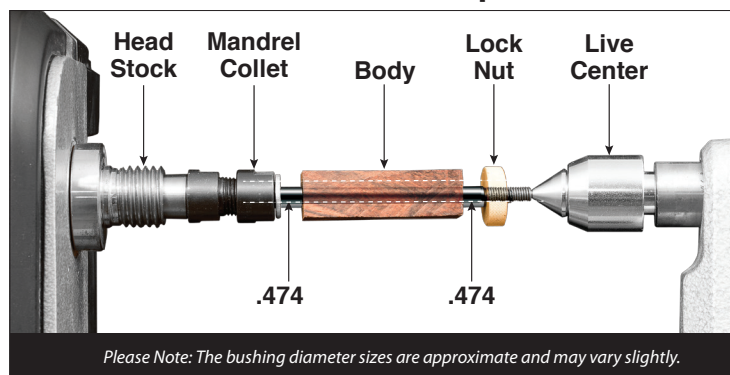


Using a sander or barrel trimmer, square the ends of your pen blank so that it is flush to the ends of the tube that is inserted into the pen blank. When squaring the ends of your blank, do not remove any of the brass. Removing any of the brass tube will change the overall length of the finished pen which will affect the overall operation of the pen.

Shop Note:

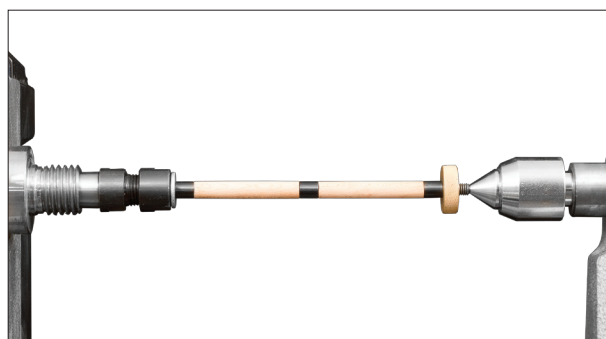
A Barrel Trimmer may be used with a drill press or hand drill for this process. You may also mount the Barrel Trimmer (not included) to a handle (not included) of your choosing.

Mandrel Setup



With your pen mandrel inserted into your lathe, slide one of the .474" bushings up against the mandrel collet, slide the Body piece on to the bushing, slide the other .474 bushing into the Body. Secure with locking nut. Slide the live center into the mandrel and secure. (Do not overtighten the locking nut or live center, doing so may damage the wood or the mandrel).

Turn the Pen Blank

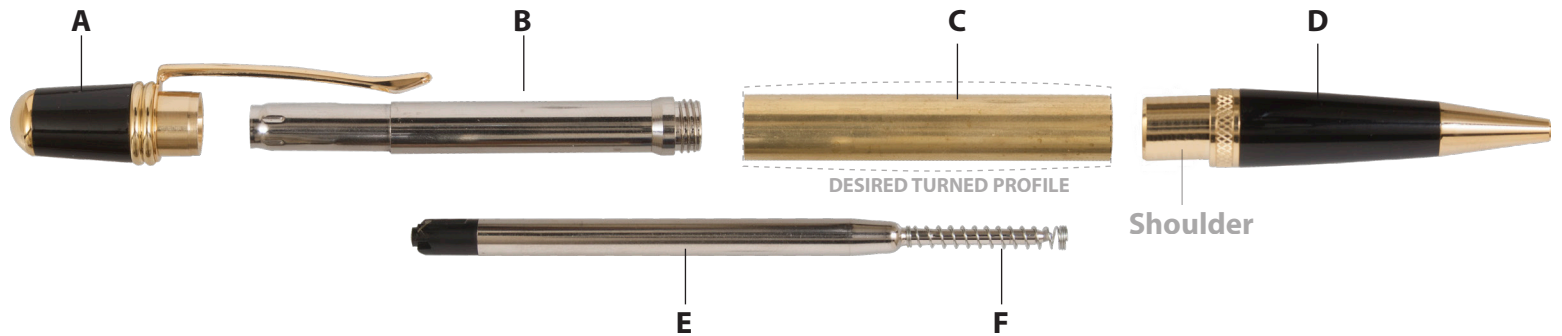


Turn the blanks to your desired look leaving the diameter slightly larger than the bushings. While the lathe is spinning, start sanding with 120 grit sandpaper and progressively work up to 320 grit. After sanding, apply the finish of your choosing to achieve your desired look.

CAUTION:

As you get close to the final O.D. keep in mind to use the bushings as your guide. Each bushing is approximately the same size as the finished pen parts, going past this point will create an undesirable look and may also cause the wood to be too thin and split.

PALISADES PEN ASSEMBLY



- Slide Spring (F) on to Pen Refill tip (E).
- Insert the Pen Refill (E) into the threaded end of the Twist Mechanism (B). Thread the Twist Mechanisms into the Pen Tip Assembly (D).
- Press the Cap/Clip assembly (A) into one end of the turned blank/tube (C).
- By hand, slide the open end of the pen body over the Twist Mechanism (B) and on to the shoulder of the Pen Tip Assembly (D) until it seats against the Pen Tip Assembly.
- To operate the pen mechanism, hold the pen tip assembly (D) and twist the top of the pen clockwise to advance the tip, turn opposite directions to retract the pen tip.

Shop Note:

Pen components can be pressed together using a pipe clamp (sold separately) with pads, however, it is recommended that you use a pen press for better assembly pressure.