



EZline Ballpoint Pen Kit



REQUIREMENTS- Mandrel Shaft A, Letter J Bit, 1A Bushings

Prepping Your Blanks

1. Two blanks are needed for the EZline Ballpoint Pen Kit, cut your blanks about a 1/4" longer than the brass tube.
 2. Using the Letter J bit drill lengthwise through the center of your blanks.
 3. Scuff up your brass tubes with sandpaper.
 4. Using a 2 part epoxy, mix according to instructions, apply epoxy inside the blanks using a toothpick or q-tip then apply a small amount on the brass tubes. Give your brass tubes a twist as you insert it into the blanks, this will allow the glue to fill in around the tubes.
 5. Clean out any excess glue with a q-tip. The remainder can be cleaned out after the glue has dried.
- Set your blanks aside to dry, a 5 min epoxy should take about an hour.
6. After your glue has dried, square the ends. We recommend the Ultra Shear Pen Mill but, you can use a disc sander. Just until you see the bright brass tubes, **do not remove too much.**

Turning your Blanks



1. Tighten your blank setup down on your mandrel. This will depend on your setup.
2. Turn the blanks down to the desired shape. Do not turn your blanks completely flush with the bushings. You will still need to sand and finish in the next few steps.
3. After turning, sand the surface of your blank in progressive steps, for wood- 180,220, 360,400,600 and 800. For acrylics, wet sand, 180,220,360,400,60,800, then use micro mesh from 1500 grit to 12000 grit.
4. Apply the finish of your choice and remove for assembly.

Assembling the pen

1. Press finial and clip into end of short blank and set aside.
2. Press nib into end of long blank.
3. Press twist mechanism into other end of long blank **Stop at the index line showing.**
If you prefer, you can test the refill as you go to set the length of the tip.
4. Slide on center band and thread in ink refill into the twist mechanism.
5. Slide the upper finished blank into the twist mechanism.

