

Berea Hardwoods Co., Inc.
Kit Instructions

Gold Top European (Chrome) (Berea #WCO-N301-xxx-1)



Needed: Mandrel-A

Bushings-10A (A 10.5A Bushing set is available. It gives the larger diameter bushing for the center band.)

Drill-7mm

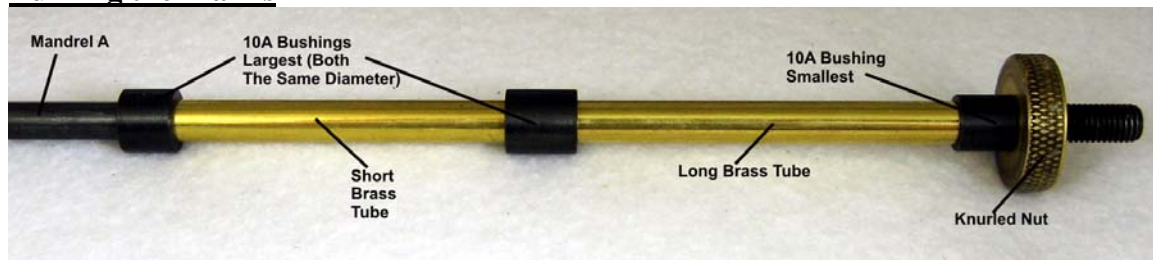
Wood Size- 3/4" x 3/4"

Preparing the Material Blanks

1. Cut the material blanks a little longer, approximately 1/4", than the pen tubes. Drill each blank through the center, lengthwise, with a 7 MM bit.
2. Polish the brass tubes with sandpaper. This can be done by hand or on a power machine such as a belt sander. The purpose of the sanding is to clean off the oxidation and roughen the tube so that the glue will have a better adhesion surface.
3. Plug the ends of the tubes with the material of your choice. Some use base wax, a dental product, or Play Dough, or even a slice of potato. Just push the ends of the tubes into a thin section of the material. This will form a plug to keep the glue from getting into the tube.
4. Clean the tube, after plugging, with acetone or alcohol on a rag.
5. Prepare your glue. We recommend two part epoxy glue that is available in all hardware stores. Use a fast drying type, one hour or less. Be sure to mix it thoroughly. (A Post-it Note Pad makes an excellent mixing place. When you are finished just tear it off and throw it away.) Polyurethanes and thick flexible CA's can be used, but they each have their drawbacks.
6. Place some epoxy into the blank using a small piece of dowel or other small stick.
7. Roll the appropriate tube in the epoxy.
8. Insert the tube with a twisting motion until it is almost in the material blank. Then use the dowel to push it in until the end is flush with the blank. Use the stick to rake off the excess glue even with the blank and the tube.
9. Push the brass tube through the blank until the other end is flush with the blank. Then rake the glue flush with that end. Now push the tube back into the blank until the tube is an equal distance from both ends of the blank.
10. Move it aside for 60 minutes until the epoxy has had time to reach its maximum strength.

11. If you are using CA glue, the wait is only about 60 seconds. When using polyurethane the wait will be about 24 hours.
12. When the glue has cured use a hobby knife to remove the plugs from the ends. It is also a good idea to clean the tubes with a brass gun cleaning brush to remove any glue that may have gotten into the tubes.
13. Not cleaning out all glue from the tubes is the most common cause of pen failure. BE CERTAIN that all dried glue is removed from inside the tubes before proceeding.
14. Using a barrel trimmer of the proper size, face off the ends of the blanks until you can just see the bright brass end of the tube. STOP facing at this point. Your pen's proper operation is dependent on having the proper length tubes. This facing operation can also be done with the proper jig and a disk or belt sander.
15. Not having the proper tube length is the #2 cause of pen failure. Sanding, on a disk sander, using a jig to hold the tube square with the disk, is a more sure way of getting the proper length. It should be tried if you have any doubt as to your abilities to square the material with the barrel trimmer.
16. Another good method of squaring the ends of the blank is to turn the blank until it is just round. Using a miter gauge to maintain the blank perpendicular to the sanding disk, just touch the ends to the disk. Once the blanks are square and you can see the ends of the tubes brighten, then return the blanks to the mandrel and finish the turning until the desired contour is accomplished.

Turning the Blanks



1. Assemble the blanks on the mandrel using 10A bushings as shown above. (A 10.5A Bushing set is available. It gives the larger diameter bushing for the center band.) Tighten the tailstock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks.
2. Turn the blanks to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
3. When turning the cap blank, the short one, turn the blank round to a diameter of 0.515", or to the diameter of the center band. Now taper it to the diameter of the second largest bushing using the classic European contour. **DO NOT turn the other end of the short blank to the diameter of the largest bushing. Leave it at 0.515".**
4. Measure from the edge of the blank, at the large end, back 0.240", or the width of the center band, and make a mark.
5. Turn a tenon on this end to the brass tube.
6. After turning the blank, sand the surface in progressive steps until you get to 400 or 500 grit.
7. If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
8. Apply the finish of your choice and polish.
9. Remove the blanks from the mandrel.

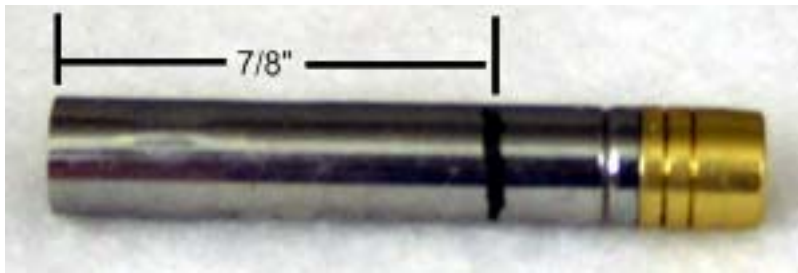
Assembling the Pen



Please refer to the Pen Parts diagram above.

The third most common error resulting in a non-functional or damaged pen is the misalignment of the parts when pressing them in place. The use of a good pen press or small arbor press is recommended, but it can be accomplished with a good “C” clamp and much care. When pressing in the various parts, by any means, BE SURE that the parts are straight and in line with the blanks. If the part is cocked or otherwise misaligned, at the very least, a poor fitting pen will result. At the worst, you may have a pen that is not usable. Exercise caution here!

One other word about pen parts. Occasionally, you will encounter parts that are a little loose fitting. This can be corrected by using a SMALL spot of glue, usually CA, on these parts before pressing them home.



1. Press the nib into the small end of one of the finished barrel blank.
2. Take the transmission and make a mark 7/8” from the end. See Picture above.
3. Press the Transmission into the other end of the same blank. Press this in up to the mark you made. It is wise to stop just a little short of the mark and then test the pen by inserting the refill and extending the point. The point should extend about 1/8”. Adjust the mechanism accordingly. Make sure you do not go too far. If you do then the pen point will not retract fully leaving the tip exposed to ruin a shirt or jacket.
4. Press the clip bushing into the small end of the cap barrel. This is the end with NO brass exposed.
5. Place the clip on the pen and screw on the finial.
6. Press the center band onto the exposed brass tube of the cap.
7. Slide the cap onto the pen. This is sometimes a little tight. Rubbing some paraffin wax on the mechanism nubs will help the cap to slide on easier.
8. Look at your masterpiece and decide who is special enough to receive this fine pen.

Copyright© 2014-Robert W. Keyes