



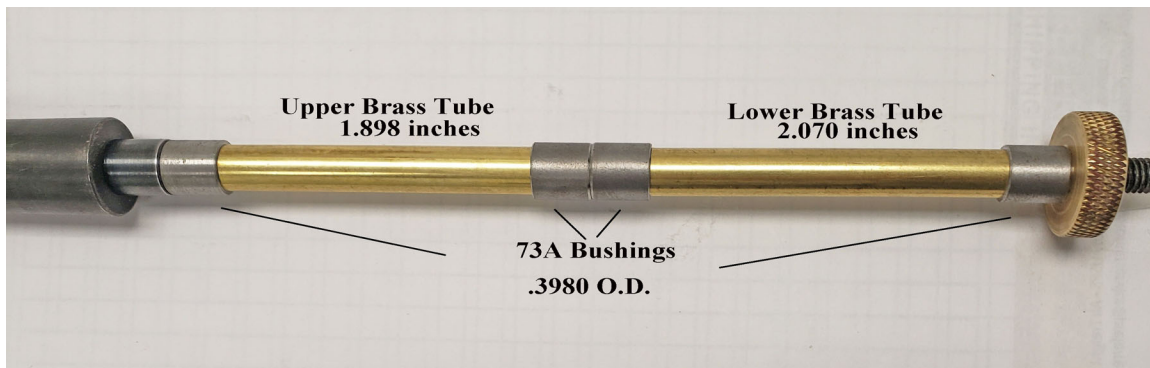
## 2201/B Medical Care Pen Kit

**KIT REQUIREMENTS-** Mandrel Shaft A, 11/32 Drill Bit, 73A Bushings

### Prepping Your Blanks

1. Two blanks are required for the Medical Care Pen Kit, cut your blanks about a 1/4" longer then the brass tube.
2. Using the 11/32 bit, drill lengthwise through the center of your blank.
3. Scuff up your brass tube with sandpaper.
4. Using Stick Fast 2 part epoxy, mix according to instructions, apply epoxy inside the blank using a toothpick or q-tip then apply a small amount on the brass tube. Give your brass tube a twist as you insert it into the blank, this will allow the glue to fill in around the tube.
5. Clean out any excess glue with a q-tip. The remainder can be cleaned out after the glue has dried. Set your blank 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 or you can use a disc sander, just until you see the bright brass tube, **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 blank down to the desired shape. Do not turn your blank 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 threaded coupler into one end of upper finished barrel(short).
2. Slide clip onto click assembly and press click assembly into other end of upper finished barrel. **DO NOT PRESS ON THE CLICK MECHANISM. USE A BLOCK OF WOOD WITH A HOLE IN IT.**
3. Press nib into one end of lower finished barrel(long)
4. Press threaded center band into other end of lower finished barrel.
5. Slide spring into refill (small end first) and slide into lower finished barrel.
6. Thread the upper finished barrel onto the lower finished barrel.

