

Berea Hardwoods Co., Inc.  
Kit Instructions

## **Berea Hardwoods Pensar (Berea #1306PL/B-XX)**



**Berea Hardwoods**

Pensar

Needed: Mandrel A

Bushing 20A (2 sets make this go faster, but 1 will do nicely)

Drill 27/64"

Material size 3/4" x 3/4"

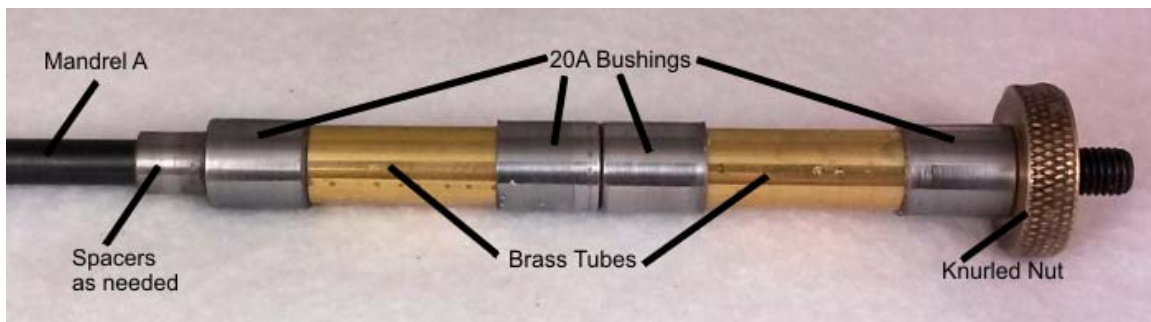
Note: If you have made the Sierra Pen then this kit should be a snap. But, do pay attention to the instructions as some things are different.

### **Preparing the Material Blanks**

1. 2 material blanks are required for this pen. Cut the material blanks slightly longer than the brass tubes.
2. Drill the blanks through the center, lengthwise, with a 27/64" bit.
3. 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.
4. 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.
5. Clean the tube, after plugging, with acetone or alcohol on a rag.
6. 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.
7. Place some epoxy into the blanks using a small piece of dowel or other small stick.
8. Roll the tubes in the epoxy.

9. Insert the tubes 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 blanks and the tubes.
10. Push the brass tube through the blanks 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 equidistant between both ends of the blank.
11. Move it aside for 60 minutes until the epoxy has had time to reach its maximum strength.
12. If you are using CA glue, the wait is only about 60 seconds. When using polyurethane the wait will be about 24 hours.
13. 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 tube with a brass gun cleaning brush to remove any glue that may have gotten into the tubes.
14. 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.
15. 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.
16. 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.
17. 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.

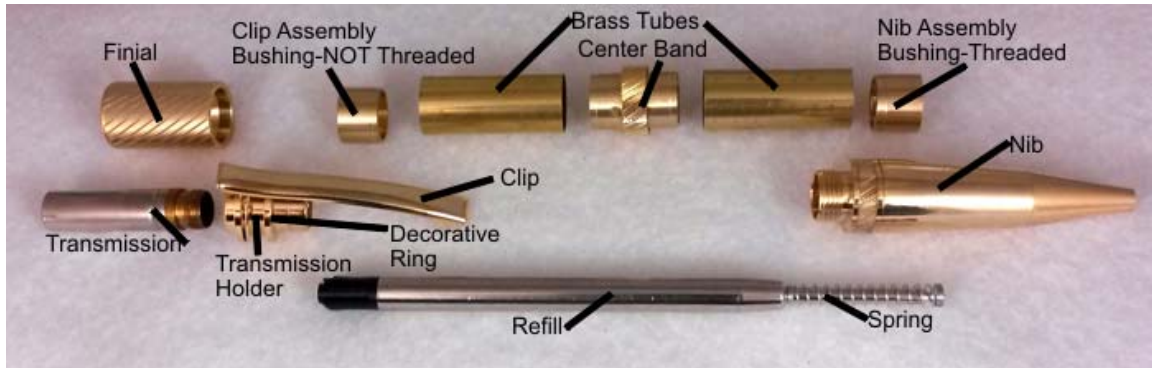
### Turning the Material Blanks



1. Assemble the blanks on the mandrel using the 20A bushings. These are the Sierra bushings. If you have 2 sets then both blanks can be turned at the same time. If not, then you will have to turn each one individually. Selection of the bushings is easy since they are all the same size. Put any bushing in any position.
2. Since the blanks are short, you will have to place spacers on the mandrel in order to tighten the tubes for turning. You can drill a 7mm hole in a piece of wood for a spacer or 7mm bushings make excellent spacers.
3. Tighten the tailstock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks.

4. Turn the blank to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
5. After turning the blanks, sand the surface in progressive steps until you get to 400 or 500 grit.
6. If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
7. Apply the finish of your choice and polish.
8. Remove the blanks from the mandrel.

### Assemble the Pen



1. Press one finished blank onto the center band.
2. Press the other blank onto the other end of the center band.
3. Press the Nib Assembly Bushing, tapered end first, into the brass tube where the nib will go. Note: This bushing is treaded on the inside!!
4. Slide the Clip and Decorative Ring onto the long end of the Transmission Holder.
5. Now press the Clip Assembly Bushing, non tapered end first, onto the clip assembly you just put together. Note: This bushing has NO threads!
6. Next, press this entire assembly into the end of the pen where the finial will go.
7. Screw the nib into place.
8. Drop in the refill with spring.
9. Screw in the Transmission.
10. Push on the Finial and you are done.

It should be noted that this is a single twist pen.

This pen offers a lot of options. You can use different materials for each blank as I have done. By sacrificing a Sierra tube you could even make the sections unequal. Let your imagination run wild!!

Copyright© 2013-Robert W. Keyes