

ULTRA·SHEAR™
WOODTURNING TOOLS
by **Woodpeckers®**

BLADE BUTTON CLICK BALLPOINT PEN KIT

Instructions for Pen Kit Model Numbers
220091, 220092, 220093, 220094



SUPPLIES NEEDED:

- 11/32" Drill Bit (Part # ND-36980)
- Blade Pen Kit Bushings (Part # 220252)
- Replacement Tubes (Part # 220204)
- 3/4" x 3/4" Pen Blank
- Ultra-Shear Pen Mandrel (Part # USPMD)
- Ultra-Shear Pen Mill-Ci (Part # PMCIDLX)

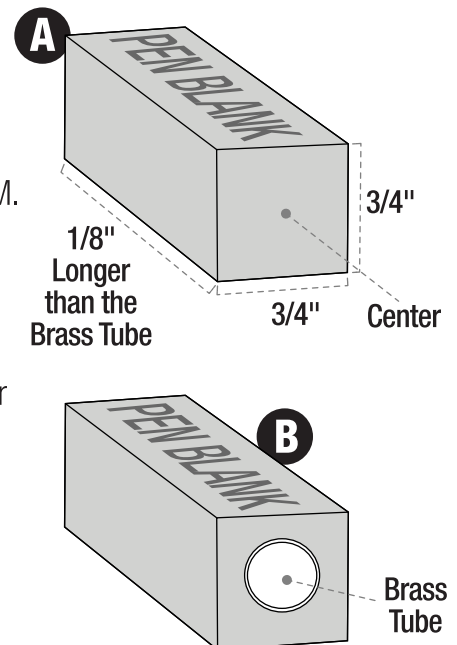
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All Pen Kits have different parts. The Pen Kit and the finished pen shown are for reference of the part names and may not fully resemble the Pen Kit you have purchased.

If you think you're missing anything, email us at mailroom@woodpeck.com.
You can also call us at 800-752-0725 from 9:00 a.m. to 5:00 p.m. EST Monday - Friday.

PREPARING THE PEN BLANK/BRASS TUBE ASSEMBLY

1. This is a single blank pen kit. Cut the material blank 1/4" longer than the brass tube. The tube on this pen is 3-11/16". You will need to use every bit of your drill bit to make the hole. Excess will be cleaned up in a later process.
2. Drill the blank with a 11/32" drill bit. Typical speed will be between 900 to 1,200 RPM. **FIG A.**
3. Scuff the brass tube to eliminate any debris and this will rough up the tube for better adhesion.
4. Apply epoxy or CA glue to the brass tube and twist as it is inserted to insure proper coverage. Make sure you have the brass tube fully inserted and not sticking out the other end of the material blank. **FIG B.**



5. Square the ends of the blanks to the brass tube. This process utilizes the Ultra-Shear Pen Mill-Ci. Place the material blank in a drill press vise and after selecting the proper reamer clean out the inside of the tub at the same time as you square the ends. **FIG C & D.**

!! COMMON ISSUES !!

- *Proper material blank length. Your pens operation depends is dependent on having the proper length tubes.*
- *Not cleaning out all the glue from the tube causes pen failure.*

TURNING THE MATERIAL BLANK

1. Assemble the blank on the mandrel using the proper bushings. Both bushings are the same size. No need to over tighten. **FIG E.**
2. Turn the blank to the desired contour, making sure the area next to the bushing is turning to the diameter of the bushing.
3. After turning the material blank, sand the surface in progressive steps. Depending on the material blank, wood, acrylic, hybrid you use a variety of sandpaper.
4. Apply the finish of your choice and polish.

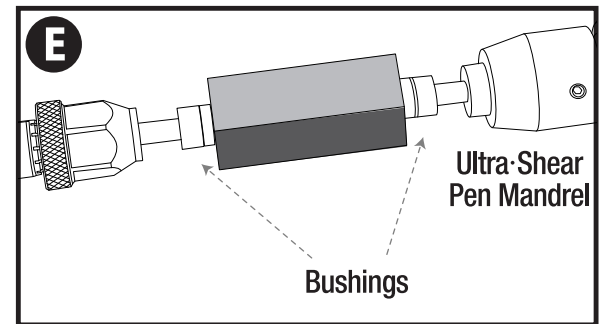
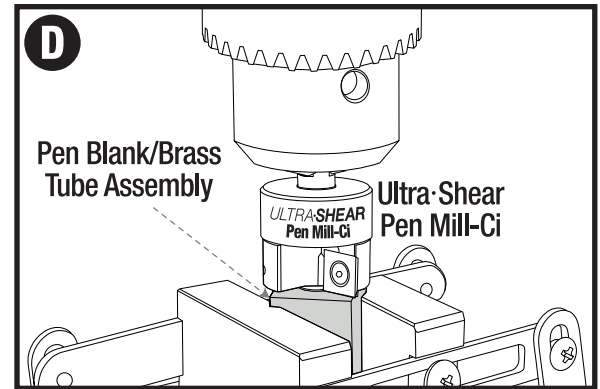
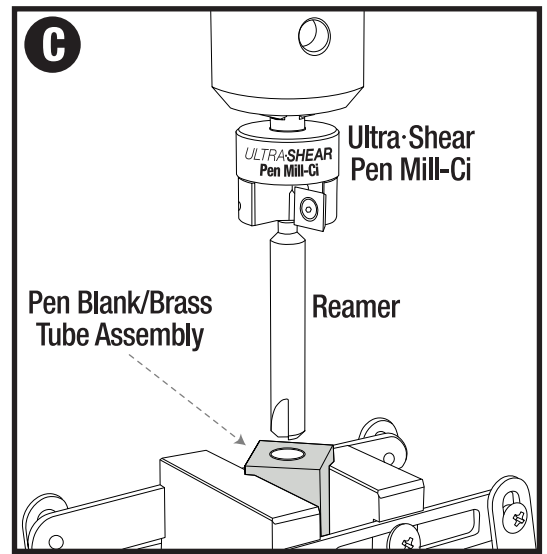
ASSEMBLE THE PEN *Please refer to the Pen Parts Diagram on page 1.*

!! COMMON ISSUES !! *Pen operation is dependent on properly aligned parts. 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. 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 LOCTITE on these parts before pressing them home. CA and Epoxy can affect the finish.

**AT NO POINT SHOULD THE CLICK MECHANISM BE PRESSED ON!
PLEASE DO NOT PRESS ON THE CLICK MECHANISM!**

1. Slide Clip onto Finial.
DO NOT PRESS ON THE CLICK MECHANISM
2. Press Finial into one end of Finished Blank.
3. Press Threaded Nib Coupler into the other end of Finished Blank.
DO NOT PRESS ON THE CLICK MECHANISM
4. Thread on Nib.
5. Insert Refill and Spring through Finial.
6. Thread on Click Mechanism.
7. **Congratulations, your pen is complete.**



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