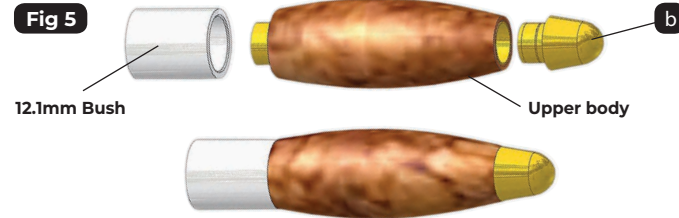
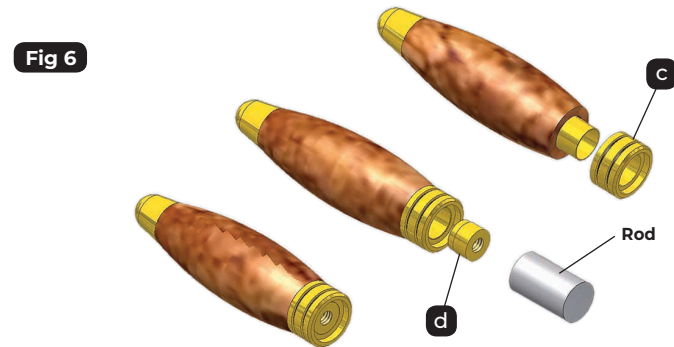


General Assembly...

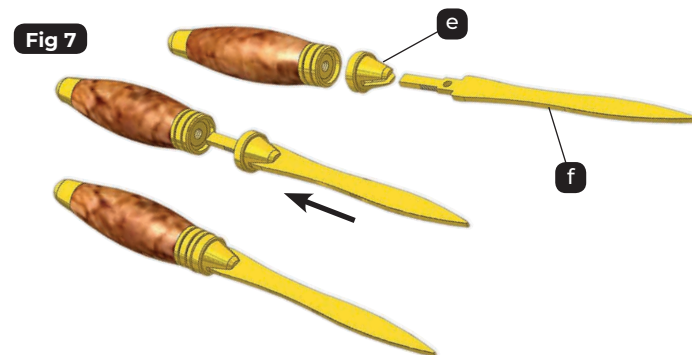
Introduce the End Cap (b) into the 'upper' end of the body. Using the 12.1mm Bushing to safeguard the protruding tube; press the End Cap into the body (See Fig 5).



Introduce the Handle Ferrule (c) onto the protruding brass tube, carefully press/ push the ferrule onto the tube and up against the body (See Fig 6). Introduce the Threaded Insert (d) into the brass tube and press home. This operation is a little difficult as the threaded insert is 'swaging'/ stretching the tube so that it locks the Handle Ferrule in place. It may be expedient to use a small piece of rod, et al, against the face of the Threaded Insert, in order to ensure the face of the insert and the recess in the Handle Ferrule are flush (See Fig 6).

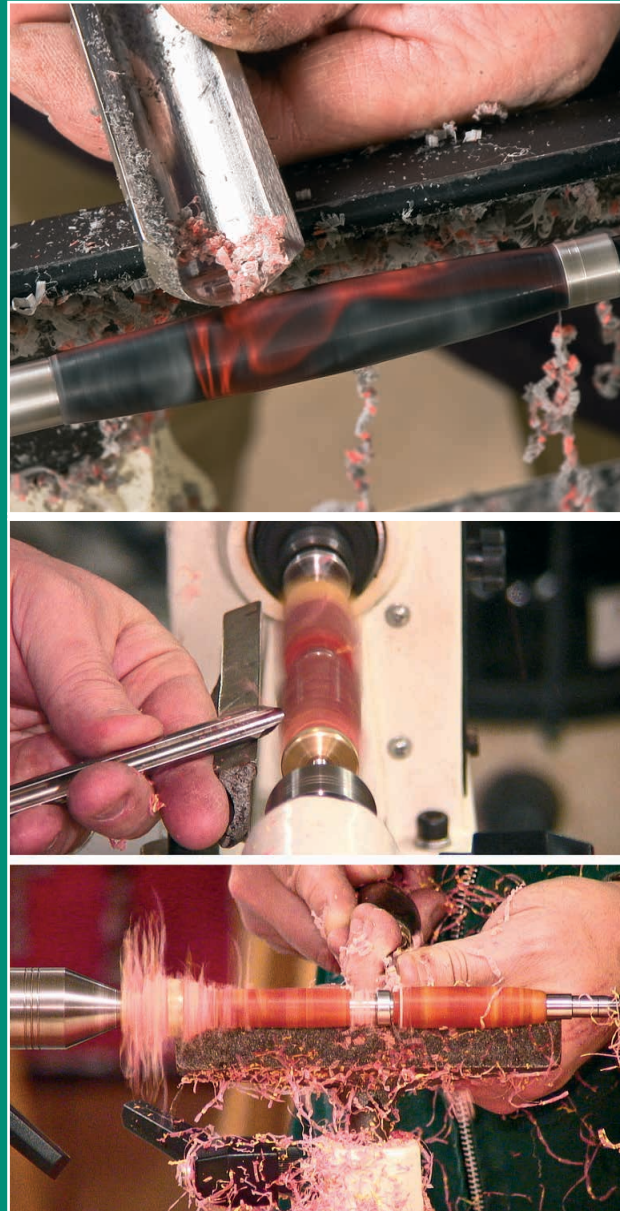


Pass the tang of the Blade (f) through the Blade Ferrule (e) and screw into the Threaded Insert in the handle. Ensure the locating ring on the Blade Ferrule is aligned with the recess in the Handle Ferrule and tighten firmly (See Fig 7).



Congratulations, may you have many letters (not Junk Mail) to open.

More Information...



AXMINSTER
woodturning

Letter Opening Kit

Code No: 700297



Pen Kit Instructions



Axminster Tools, Axminster, Devon, EX13 5PH

axminstertools.com

Instructions for the Pen Kits...

Kit No. 700297 Letter Opening Kit

Below is a list of the items required to make the finished items from the purchased kits (Not including the body blanks). If you do not possess these items we have offered our catalogue stock code numbers alongside the items as a quick guide. We have tried to include everything in the list, although we realise that many woodturners will already have most of them.



Read manual
before use



Ear protection
should be worn



Eye protection
should be worn



Dust mask
should be worn



Foot protection
should be worn

Required Items...

Alternatives are listed to cater for different lathe configurations.

Deluxe Pen Mandrel 1MT	211322
Deluxe Pen Mandrel 2MT	211323
60° Live Tail Stock Centre 1MT	340202
60° Live Tail Stock Centre 2MT	340203
Bushing Set (3 pieces)	951192
7.5m Drill Bit	610286
Axminster Universal Barrel Trimmer	700265
2 Part Rapid Epoxy Resin Adhesive	340282
Alternative Zap-A-Gap Adhesive (Cyanoacrylate)	990095

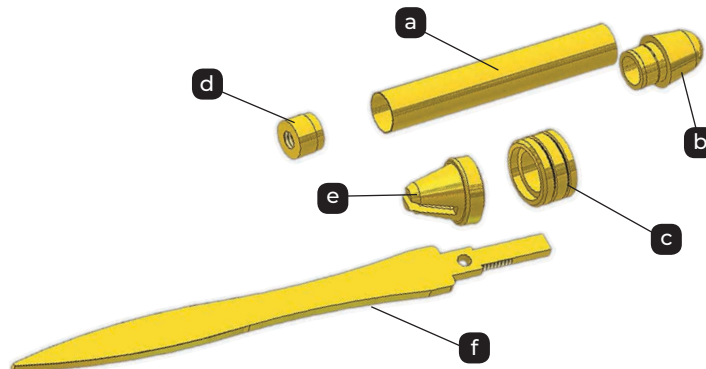
Recommended Accessories...

Quick Action Pen Blank Vice	600771
Axminster Deluxe Assembly/Disassembly Pen Press	106069

What's in the Kit...

1 Brass Tube (45mm Long)	(a)	1 Blade Ferrule	(e)
1 End Cap	(b)	1.Blade	(f)
1 Handle ferrule	(c)		
1 Threaded Insert	(d)		

1

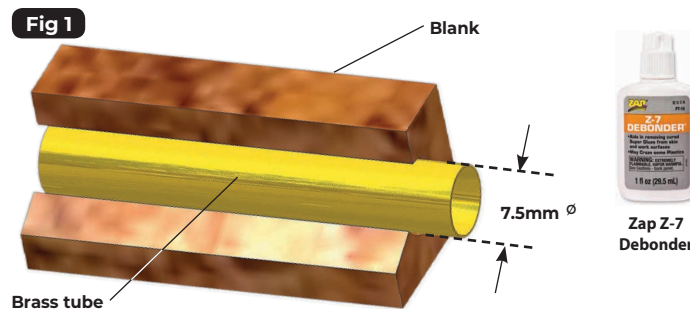


Preparing the Bodies...

Using 16mm (5/8") Square stock; cut the blank to the length of the brass tubes less 4mm (41mm). The Pen Blank Sizing and Cutting Jig makes this process very much easier.

Drill a 7.5mm diameter hole through the centre of the blank. Care must be taken not to force the drill bit, (this may cause it to 'wander' from the centre line), and remember to back out the drill frequently to clear the debris from the hole. If you are using a pillar drill the Quick Action Pen Blank Vice is a very useful accessory for this task, it ensures that the blank is held upright and firmly in position. Moreover, if the vice is clamped to the table of the drill, it will provide accurate repeatability for all the blanks that require drilling.

When the hole is drilled, spread the adhesive randomly over the brass tube (excepting the outer end) and insert the tube into the blank using a twisting motion to ensure the glue is spread evenly between the two surfaces. Insert the tube into the blank leaving a 1mm trimming allowance (at viz:- the upper end) and a 5mm protrusion (at viz:- the lower end). (See Fig 1).



Warning. If you are using cyanoacrylate adhesive, exercise extreme caution and do not allow the adhesive to come into contact with the skin. If this happens keep the affected area from contact with any other surface, until the glue has hardened or you can treat the area with a softening agent similar to Zap Z-7 Debonder (990099), and you can remove the glue.

Allow the adhesive to dry thoroughly.

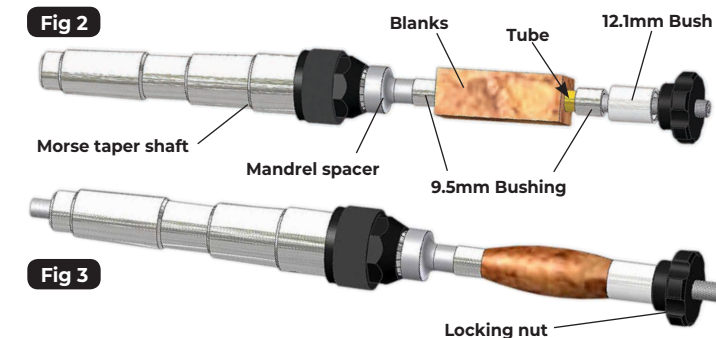
Using the Barrel Trimmer; trim the upper end of the blank squarely and neatly to the end of the brass tube; this will also remove any excess glue that may have exuded from the joint. Take care not to undercut the brass tube.

2

Turning the Blanks...

Note. The following procedure is written, assuming a Bushing Set is being used. It is not a mandatory requirement; if you are not using one please modify the procedure to suit your own methodology.

Slide a mandrel spacer onto the shaft of the Pen Mandrel. Add one of the 9.5mm Bushings from the Bushing Kit. Mount the trimmed end (the upper end) of the blank onto this bushing. At the lower end of the blank with the 5mm protruding tube carefully insert the other 9.5mm bushing into the tube, and then slide the 12.1mm bushing over it (See Fig 2) and up against the blank.



Add the locking nut and finger tighten (See Fig 3). The geometry of the bushings is so arranged as to clamp the blank without putting pressure on the brass tube. Tighten the lock nut to allow the assembly to be turned without moving.

Do not overtighten, this may cause the assembly to distort, the body to split, strip the thread on the lock nut, etc. Similarly do not advance the tailstock centre with too much force.

The current bulk of the blank may be adding strength to the assembly but as the body diameter is reduced, too much force on the mandrel may cause it to distort/bow. Turn the blank down to your preferred profile, sand and finish to the reference diameters of the bushings. Remove the finished body from the pen mandrel.

General Assembly...

Note. The Axminster Pen Assembly Press (106069) is a very useful accessory for these operations, as it gives greater control over the applied force and keeps the components in line.



3

Continues Over...