

Berea Hardwoods Co., Inc.  
Kit Instructions

**Berea Hardwoods Hymark (Berea #MP-1301-xxx)**



Needed: Mandrel-A  
Bushings-44A  
Drill-14 mm and 15 mm  
Wood Size- 3/4" x 3/4"

## Preparing the Material Blanks

1. Cut the material blanks a little longer, approximately ¼", than the kit tubes. Drill the shortest blank through the center, lengthwise, with a 15 MM bit.
2. Drill the longer blank through the center, lengthwise, with a 14 MM 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 blank using a small piece of dowel or other small stick.
8. Roll the appropriate tube in the epoxy.
9. 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.
10. 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.
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 tubes 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 kit 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 kit'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 kit 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.



1. Assemble the blanks on the mandrel using 44A bushings. Be sure to get the right bushings in the right tubes. They will only fit one way.
2. Tighten the tailstock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks.
3. 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.
4. After turning the blank, sand the surface in progressive steps until you get to 400 or 500 grit.
5. If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
6. Apply the finish of your choice and polish.
7. Remove the blanks from the mandrel.



Kit Parts Diagram

### Assembling the Kit

Please refer to the Kit Parts diagram

The third most common error resulting in a non-functional or damaged kit 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 kit will result. At the worst, you may have a kit that is not usable. Exercise caution here!

One other word about kit 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 adaptor into one end of the long finished blank.
2. Press end cap into the other end of the long finished blank.
3. Drop the spring, large end first, into the long blank.
4. Uncap your marker and drop it into the long blank with the marker nib sticking out.
5. Select the appropriate nib for the size marker you are using and screw it into place over the marker. Lay this aside for a moment.
6. Now place the clip over the finial, that's the part with the threaded stud inside.
7. Press the finial bushing onto the finial clip assembly.
8. Press the finial/clip/bushing assembly into one end of the short blank.
9. Drop the plastic catch insert into the open end of the short blank.
10. Using a blunted Phillips screwdriver, or a straight blade of the appropriate size, screw the catch insert on to the threaded stud inside the finial.
11. Snap the cap onto the finished long blank. The catch insert may be adjusted for a good tight fit.
12. NOW, GO MAKE YOUR MARK IN THE WORLD WITH YOUR NEW MARKER!

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