

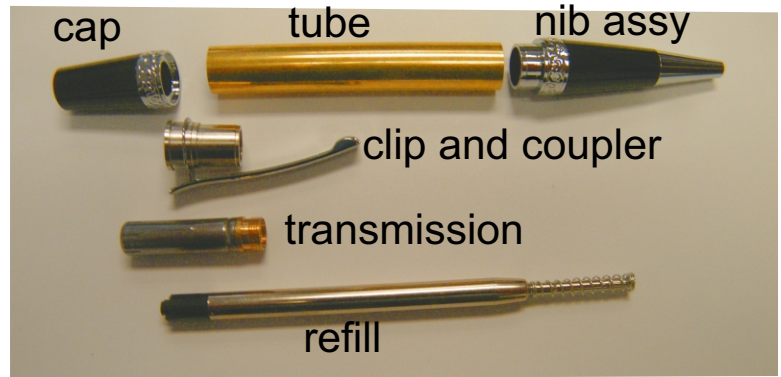
LeRoi kits D37

Specifications:

Bushings: D37 or LeRoiv2

Drill bits: 3/8" or 9.5 mm

Recommended Blank size:
1/4" longer than brass tube



Procedure:

Cut blank to size-.25" to .50" longer than kit brass tube. Drill with the bit you prefer 9.5mm or 3/8"
You want your tube to slide in and out with a little "drag". Acrylics can usually use 3/8", most wood closes slightly, so 3/8" is a better choice.

Glue brass tube in place with epoxy, med or thick CA, polyurethane or whatever adhesive you like. Coat brass tube, rotate in blank, get good coverage!! Allow sufficient time for curing (not just "drying").

Facing

Conventionally, "facing" is done with a pen mill before turning. We prefer starting to turn without facing. Then, when the blank is about an eighth inch over final size, take the blank off the lathe and sand the ends level with the brass tube end. You can see a video of this procedure here:
<https://www.youtube.com/watch?v=lzQ2Gla41dU>

Turning and polishing

Mount the pen blanks on your lathe, using the bushings shown above. Both bushings are the same size, so it does not matter which one is front or back. Turn to size with the tool of your choice. Sand and polish according to your own personal preferences.

Assembly

Insert nib assembly into tube

Insert clip and coupler into opposite end

Insert refill and spring

"Screw" transmission into clip coupler

Test operation of pen, twist transmission to retract and extend refill

Push on cap

Pen is complete!

