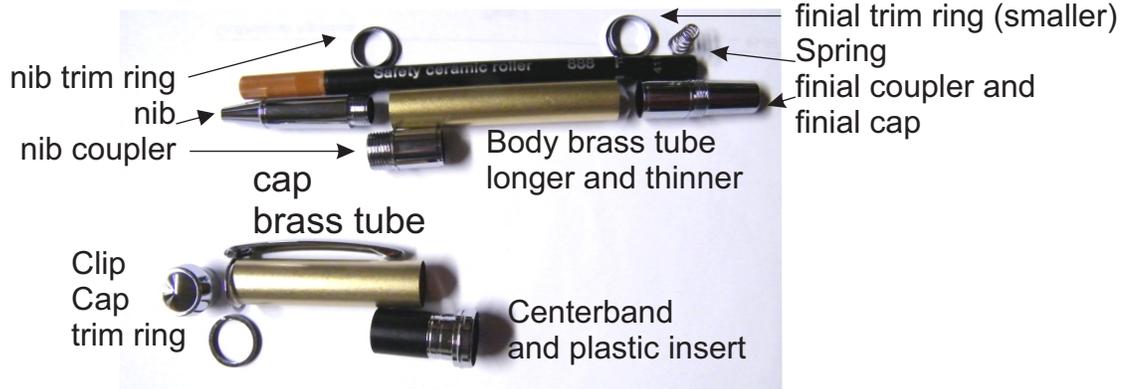


# Making the Caballero

## The “kit” contains ALL THIS:



Start by taking the brass tubes out.

Now, take your pen blanks and cut them to the length of the brass tubes, plus about a quarter inch..

Drill the blank, using a 25/64” bit for the body and a 29/64” bit for the cap. Do not drill THROUGH!

Drilling detail: Start with a SHARP drill bit. When drilling, measure the length of the brass tube and mark your drill bit. Do NOT drill through the blank, just drill longer than the amount needed, then cut off the remainder, exposing the hole. This will save you many “blow outs” caused by the drill bit exiting the pen blank.

As you drill your blanks, you should “back off” and clear the flutes of your drill bit every quarter to half inch. Be certain to avoid getting the blank hot. It is sometimes advisable to put water into the hole to keep it cool. If you do this, be certain to allow the blank to dry thoroughly before attempting to glue in the brass tubes.

Additional information if using spalted or burl or other “unstable” pen blanks: Before cutting off the end, you MAY want to put thin CA glue into the hole and “swish it around” for a while. You can repeat this several times, over several days if the material is “punk” or “rotten”. Allow to set for a couple days before you attempt to redrill, however, as the drill bit will get warm and thin CA can really grip the bit if it is still somewhat active.



This is my personal preference: An adjustable length mandrel, coupled with a mandrel saver in the tailstock. Because the length of the mandrel (that you are using) is only about 4”, the mandrel has less “flex”. A nice, straight mandrel will produce a nice, ROUND pen!! If you use this method, you will turn one pen tube at a time.



After drilling the hole, test fit the brass tube into it, the tube should slide in, without much friction. If you are using a resin that you expect to be somewhat translucent, now is the time to paint your brass tube, and/or the inside of the hole you just made. IF you are going to paint, you MAY want to make the hole a little larger, either by using the next larger bit or by sanding the inside of the hole a little, by putting sandpaper around a wood dowel.

Glue the tube into the hole you have drilled.

Both water and heat accelerate CA, so be certain your blank is cool and dry!!

Gluing detail: You can use CA (Superglue) or Epoxy, whichever you prefer. Do NOT use thin CA, either medium or thick will fill gaps, thin will not.

To get a good adhesion, take some time, here. First put a liberal coating of glue on your brass tube. Insert into blank, about half the length of the tube and rotate the tube inside the blank. Give it 10-20 revolutions, then remove from blank. Put a little more glue on the tube and insert from the opposite end of the blank. (REMEMBER: you want your pattern to line up from the body to the cap of the pen. Keep

your tubes as close as possible to the end of your blank, at the center, where the pen grain should match with the cap on.) Again rotate quite a bit. IF you start to feel resistance (like the glue setting), insert the tube quickly and make sure it is not sticking out on either end. NOTE: IF you have painted your tubes or the inside of the hole, you may find the paint is smeared by the CA glue. It is preferable to use Epoxy when painting. Epoxy can actually be tinted as well, to make it more invisible on the finished pen.

Once the brass tube is glued in place, set the blank aside for a day or so to give the glue time to set completely.

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“Facing” the blank.”Conventional Wisdom” uses a pen mill to face the blank at this point. So, if you have a pen mill, you can put it into your drill press and hold the blank with a vice-grip or other method and face the blank.

Personally, I wait until the pen is mostly turned, then remove the extra on the lathe, with

sandpaper. You can see this in the videos at [ExoticBlanks.com](http://ExoticBlanks.com)

By the way, if you are facing wood, especially diamondwood or punky wood, you can put a little thin CA on the end. This will harden the material, making it less likely to break in facing or in later turning.

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Turning: Mount on a standard “7 millimeter” mandrel rod, using the bushings listed. If you have difficulty inserting the bushings, there is, most likely, dried glue inside your brass tube. You should remove the dried glue. This can be accomplished with a round file (like you would use to sharpen a chain saw), or a pocket knife, or a brush (as is used to clean guns). Also be careful to remove any burr on the brass tube that may have resulted from your facing tool. This can be done with a deburring or chamfering tool.

Turn the blanks down close to size of the bushings. It is a good idea to measure the kit components and determine what diameter YOU like. A caliper is a good investment and can improve the quality of ALL your turned pens. But, you can use the bushings as a rough guide and achieve a pretty good result!!



# Page 3--Assembly

Before beginning assembly, make certain there is no glue remaining in the ends of your tubes. The first half inch of each end **MUST** be **CLEAN**. Use a small penknife or a round file to clean it out thoroughly!!! (I know I said this before, but it **IS IMPORTANT!!!!!!!**)



## Assembly:

Begin with the body--start by locating the larger trim ring and placing it on one of the couplers. The shoulder of the trim ring goes toward the threads of the coupler. IF you are making the FOUNTAIN PEN, put the nib assembly into the coupler and move the blank so the best side is facing you, when you have the nib positioned in the writing position. Keep the coupler in this position, relative to the blank and remove the nib section so you can press in the coupler.

(If you are making a rollerball, it does not need to be oriented in any one direction, so you can just install the coupler and screw in the rollerball front end.)

Now, screw the centerband assembly onto the nib, as if you were closing the pen. Slide the cap piece (that you turned) on the black plastic piece, oriented so the pattern matches from the body to the cap. Unscrew (hold onto the metal so the black plastic piece does not shift positions) and press the cap onto the black plastic and metal centerband **DO NOT PUSH ALL THE WAY DOWN!!!!**

Clean the "shavings" off that are between the metal centerband and the piece you turned for the cap--Once this is completely clean **THEN** continue to seat your cap into the centerband until flush.

Now, put the cap and clip and trim piece on top of the pen and press in place. Again, pay attention to the "best side" of the pen and position it forward.

Take off the cap, remove the front end and press the finial coupler, with the smaller trim ring in place (shoulder facing the threads). Screw in the end cap and the pen is complete.

Congratulations!!



If you make your pen solid black, there is no "grain match" required

