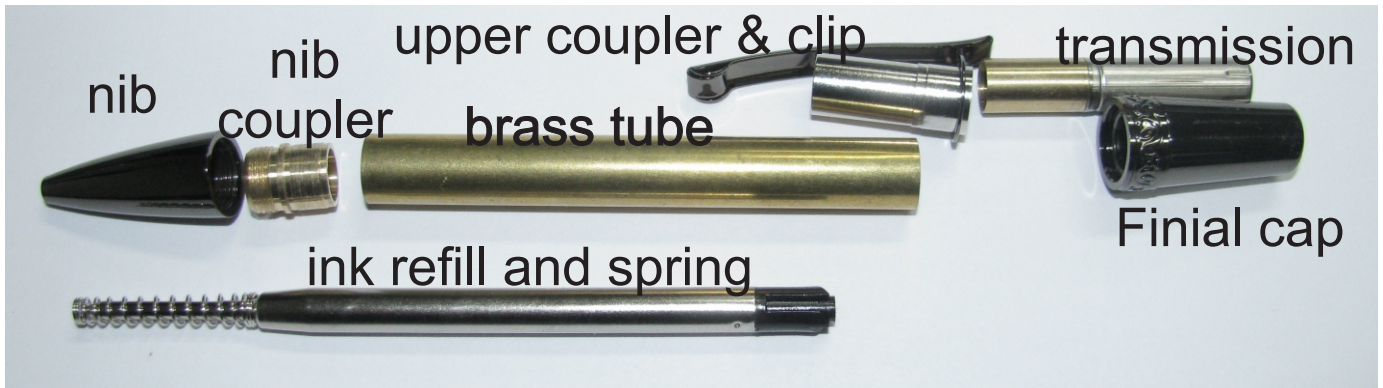




EXOTIC
BLANKS



Making the SPW Royale

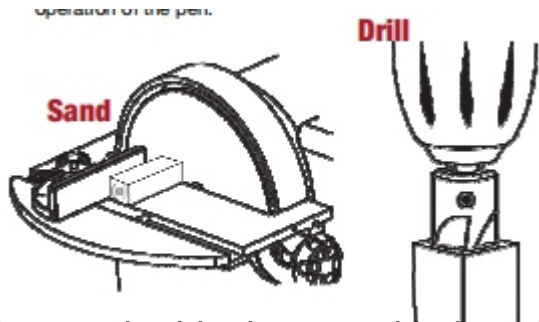


Choose and cut your blank

The blank should be at least 3/4" square and 3" long. Measure the OD of the tube (about .362" and drill to achieve a snug, but not tight fit for the tube. Depending on material, the bit could be U, V or 3/8". Retract drill often so flutes work effectively and minimum heat is built up. Put aside to cool.

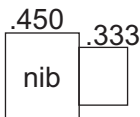
Glue in tubes

Using epoxy, Cyanoacrylic or other adhesive, glue the brass tube into the hole with a twisting motion to achieve maximum coverage. Allow to cure (overnight if possible)

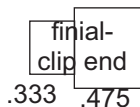


Square the blank even with the tube

Using a sanding station (preferred) or a pen mill (not recommended), square your blank to the length of the brass tube (do not shorten!)



Bushings



Turning the blank

Mount the blank on your lathe, using a mandrel or turn-between-centers bushings. Turn the material close to the size of the bushings, or you can measure the size of the nib and finial from the kit you are using for a more precisely-fitting final pen. Use sandpaper or similar to achieve more exact dimension as measured by your calipers.

Finish as you prefer

For wood, we suggest a Glu-Boost finish, for resins, simply sand and polish with the plastic polish you prefer. Buffing with tripoli and white diamond is our preferred final step--this is YOUR pen, so follow YOUR preferences!!

Assembly

- Press nib coupler in one end of brass tube
- Put the clip on the upper coupler and insert in other end of brass tube
- Mark the transmission .74" from top and insert in the upper coupler to your mark. This will extend the refill an appropriate length.
- Press (by hand) the finial cap over the transmission
- Insert refill and spring through nib end
- Screw on nib and test operation--your pen is complete!