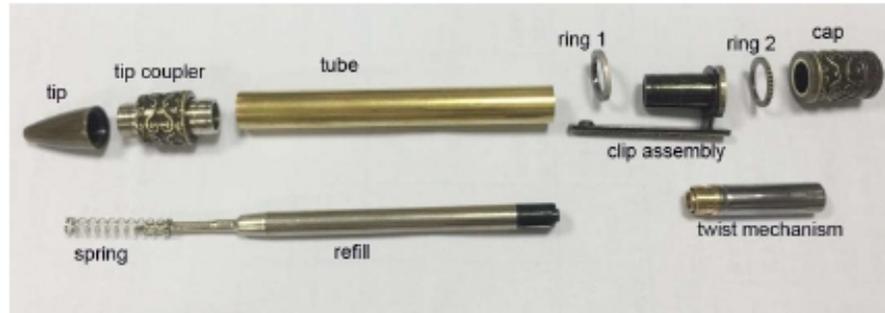




Making the SPIRITUAL Pen

The “Kit” contains all of this:

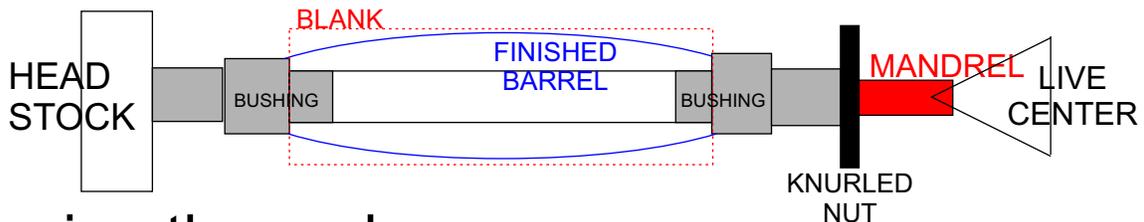


Start by taking out the brass tube.

Now, cut your pen blank to the length of the tube, plus about a quarter inch (3.25” ish). Drill the blank with a 3/8” drill bit. Glue the brass tube in the drilled hole, allow glue to cure, then set up for turning.

Turning

Use the “Prox and spiritual” bushing set. Put one bushing in each end of the tube, they are the same size, so it does not matter which is where. Then mount on your mandrel and turn your blank a little larger than the size of the bushings



Squaring the ends

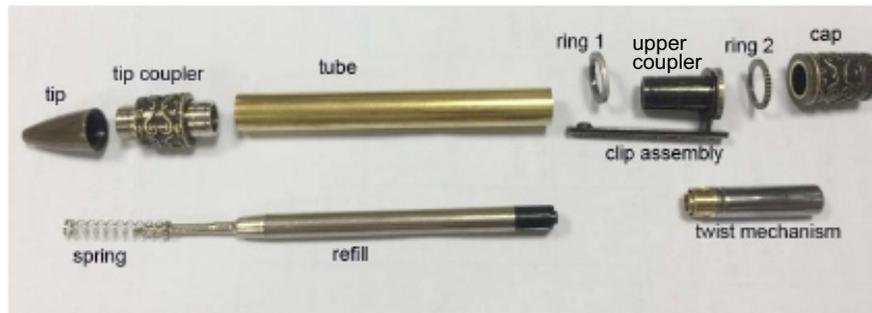
Take the blank off the lathe and square the ends with sandpaper, either using a jig on your disc sander or a sanding faceplate on your lathe. This method is MUCH less likely to destroy your pen blank, so we strongly recommend using it! The following video shows how to do this: <https://www.youtube.com/watch?v=WA7yEkYtsHU>

Final Turning

Return the pen to your lathe and turn until the ends are the correct diameter. Bushings may be off by a few thousandths, so it is best to measure the actual kit parts with a caliper and make your blank match those measurements, for optimum results.



Assembly!



**BEFORE ASSEMBLY, CHECK THAT ALL
GLUE RESIDUE IS REMOVED FROM
THE BRASS TUBE!!!**

Slide the tip trim over the tip assembly, be careful to keep the smaller end toward the pen tip. Now press the tip assembly into the tube.

On the other end, put the upper coupler through the clip, add ring one (smooth) and press this into the brass tube. Insert the refill and spring into the pen and test it to be sure the tip does not “grab” the refill as you extend and retract. Insert the twist mechanism by screwing it into the upper coupler, then test operation again. If all works well, press the cap and ring 2 (gnurled) over the twist mechanism and your pen is complete!!

