

## Turning a Bullet Pen

### Supplies Needed

- 8mm Drill Bit
- 3/4" x 2 5/16" Pen Blank
- Pen Mandrel
- Bullet Pen Bushings
- Glue (Thick CA or Epoxy)
- Sandpaper/Finish
- Drill or Drill Press
- Barrel Trimmer/Disc Sander
- Pen Press or Clamp
- Eye and Ear Protection

### Cutting and Drilling the Pen Blank

1. Cut the blank 1/4" longer than the brass tube.
2. Using a drill press with the blank secured in a vise or clamp, drill a hole through the center of the blank stopping an 1/8" short of the bit exiting the blank. Drill at 2,000–3,000 rpm backing the drill bit partially out of the hole every 1/2" to clear chips. When using larger bits or drilling plastics drill at 250–500 rpm.
3. Trim away a small amount of material from the end of the blank to expose the hole. The blank should be slightly longer than the brass tube. This technique prevents cracking caused when the bit exits the blank.

### Gluing the Brass Tubes Into the Blanks

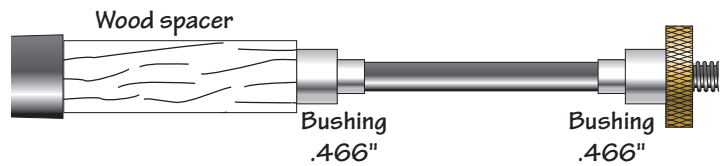
1. Lightly scuff the exterior of the brass tube with 220 grit sand paper to prepare it for gluing.
2. For a fast bond, use thick cyanoacrylate adhesive (super glue) or 5 minute epoxy. For additional working time and more thorough bond, use expanding polyurethane (Gorilla Glue). Apply a thin layer of glue to the tube and inside the wood blank. Insert the tube into the blank rotating it as you go spreading the glue evenly. Position the brass tube in the blank so that the blank extends beyond the tube on both ends to allow for trimming.

### Trimming/Truing the Blanks

1. Square the ends of the blank with the tube using either a barrel trimmer or disc sander. This step is critical for the pen components to fit together properly. **Do Not** trim the brass tube as this may result in an improper fit when the pen is assembled.

### Mandrel Setup and Turning

1. Assemble the bushings and blank on the pen mandrel as shown below.



2. Advance a 60° revolving cone center into the dimpled end of the mandrel and tighten using light pressure. **Do Not** over tighten the tailstock or mandrel nut as this may cause the mandrel to flex resulting in an off-center barrel.
3. Turn the blank to the desired shape leaving the blank slightly larger than the bushings.
4. Sand the blank using progressively finer grits of sand paper, then apply the finish.

### Assemble the Parts

Layout the parts as shown. Use a vise or clamp with wood or plastic jaws to prevent damaging parts during assembly.

1. Press the clip/cap assembly into one end of the turned blank.
2. Insert the refill into the bullet cartridge, then screw the twist mechanism into cartridge.
3. Slide the upper barrel over the transmission to join the two halves. Your pen is now complete.

