

# Legacy “Hex” Pencil Kit

Assembly Instructions

Available at [www.thewoodturningstore.com](http://www.thewoodturningstore.com)

## Description:

The “Hex” pencil is a step-up kit, with similar features to a Slimline Pro Pencil. It has a click mechanism instead of a twist. It uses an 3/8” tube that is 2 29/32” long and 2mm pencil lead. It has a heavier feel compared to a Slimline pencil. Being a larger pencil, it is more surface area to show off a nice pen blank. It is a one piece body, which is often preferred by pen turners

Please read the following instructions carefully and completely before you start assembling the pencil.

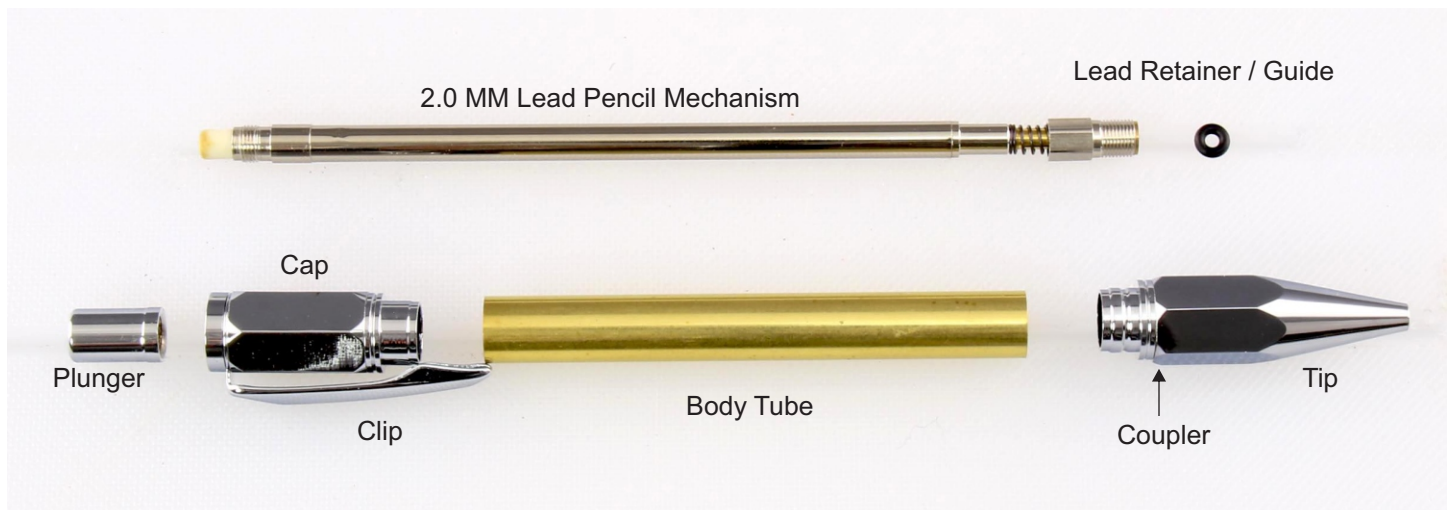
## Getting Started:

You will need the following accessories to make a Hex pencil. Many of these accessories can be used with other pen kits. (All accessories are available at [www.thewoodturningstore.com](http://www.thewoodturningstore.com))

- 1 wood or acrylic blank, approximately 3” inches long x 5/8” x 5/8”
- 3/8” drill bit
- Woodturning pen mandrel with 7mm rod
- Hex pencil bushing set
- Pen barrel trimmer (3/8”)
- Glue (CA, epoxy or polyurethane [Gorilla])
- Lathe, turning tools, sandpaper, pen finish
- Other items may be needed as desired



## Parts of the Hex Pencil Kit:



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## Preparing the Blank for Turning:

- Start with your wood or acrylic blank and cut it so it is slightly longer than the pen tube.
- Using a 3/8” twist drill, drill a hole through each blank. Be careful to drill slowly to avoid chipping and tearing the material. Also, it is highly recommended that you clamp the blank in a vise and use a drill press for the most accurate and straight hole. You could also mount each blank in a lathe chuck and drill the hole using your lathe.
- Roughen the surface of each brass tube with steel wool or fine sandpaper. Using one of the glues mentioned previously, glue the brass tube into the blank. Twist the tube when inserting it into the blank to insure good glue coverage. Center the tube in the blank, make sure the tube is at least 1/16” - 1/8” inside the blank so you can trim the blank end cleanly.
- Use a pen barrel trimmer (3/8”) to square the ends of the blank to the brass tube. This is an important step which will create a clean line between the turned blank and the metal components of the pen kit.
- Your blanks are now ready to be mounted on the lathe.

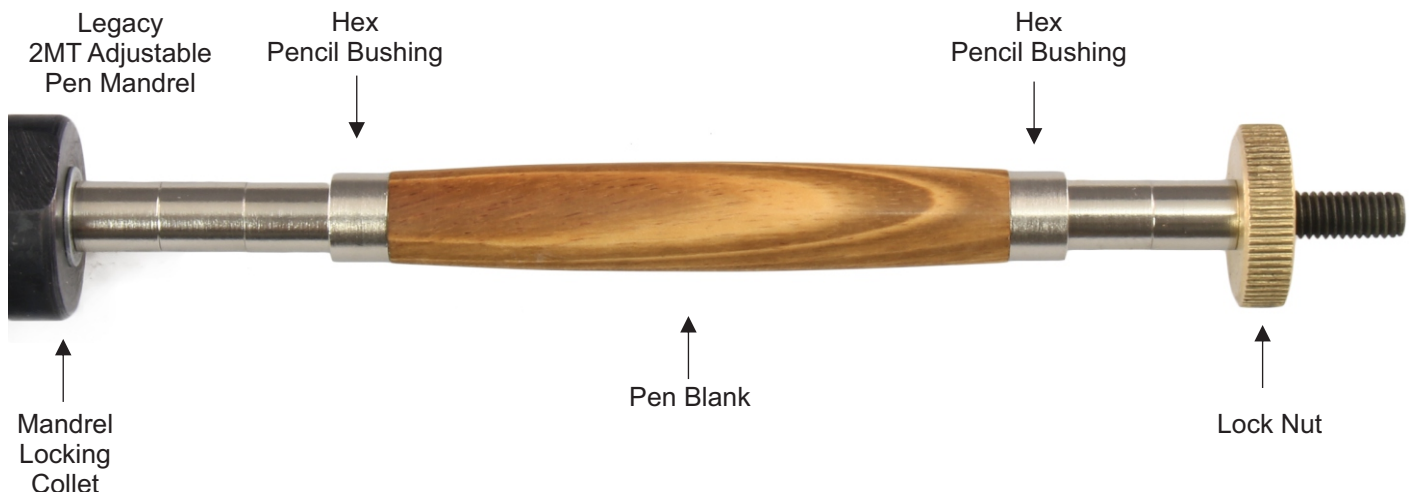
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## Turning the blanks on the lathe

- Use a pen turning mandrel with a 7mm shaft and Hex pencil bushings (available at our store). There are two bushings of the same diameter in the Hex pencil bushing set. You may want to add slimline bushings to give additional clearance around the pen mandrel collet and lock nut.
- Mount the pen blank on the mandrel as shown in the diagram below. Adjust the mandrel shaft so that the lock nut will tighten down on the assembly of pen blanks and bushings. Hand tighten the nut.
- Put a live center in your lathe's tailstock and bring it in to support the mandrel shaft and keep it stable while turning.
- Using turning tools, turn the blanks to cylinders which are the diameter of the bushings. You may want to add a gentle curve to the shape of each section of pencil.
- Note: Many turners prefer to turn the blank slightly oversize and then sand and polish the blank down to the exact size of the bushings.



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## Sanding, Polishing and Finishing the blank

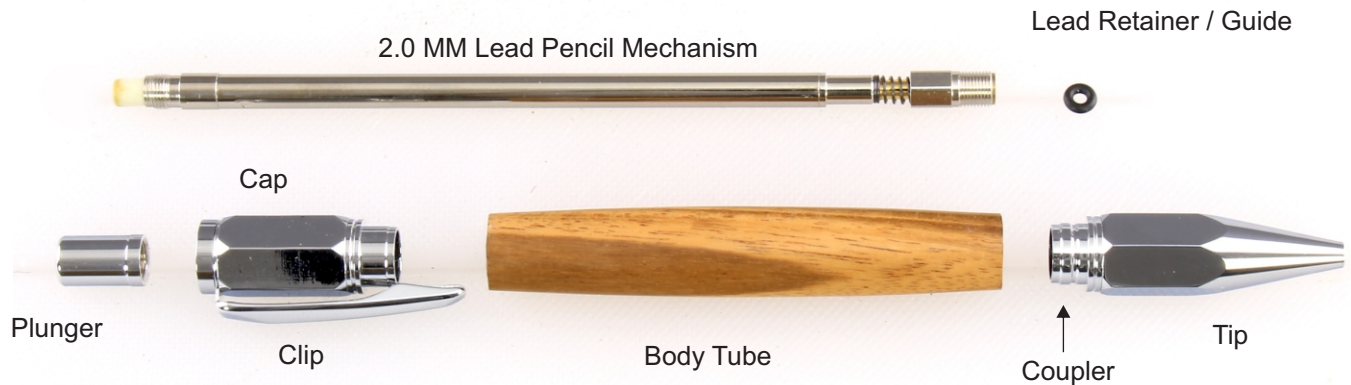
- Most pens and pencils are finished to a high luster and finished with a durable coating of protective finish. Depending on your skill level and the material being used, you will need to sand with aluminum oxide paper of progressively finer grits, starting with a grit coarse enough to remove all tool marks and possibly shape the blank.
- If you have turned your piece oversize or if it is rough, you can smooth and even shape your blank with 80-100 grit sandpaper. Use a high lathe speed (2000+ RPM) but be careful not to overheat your piece which could cause heat checking.
- Progress through finer and finer grits 120, 180, 240, 320, 400, 600, etc.
- For acrylic materials you can use sandpaper up to 1000 grit then switch to micro mesh pads (up to 12000) and polishing cream to get a superior glossy finish.
- There are many finishes available for pens and you can experiment with what works best for you and the materials you use. Try to use a finish which will be durable and long lasting because the pen will be handled thousands of times and you want the finish to stay on and not be worn away (especially if you have sold the pen!)
- Remove the blanks from the pen mandrel and you are ready to assemble your pencil.

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## Assembly of the Finished Pencil:



- Now that you have turned and finished the blanks into the upper and lower halves, you are ready to assemble your pencil.
- It is highly recommended that you use a vise or clamp to assemble the pencil. It is essential that you press the parts together “straight”. If you press the parts together and they are not straight, they will not straighten as you continue to press. There are many commercially available pen presses which make the process simple and easy.
- Before you press the parts together, for two piece kits, lay out your blanks so that you recall how the grain originally matched.
- First, press the end of the pencil coupler into the lower or front tube. You may want to press it in with the tip screwed on, to protect the pen threads.
- The lower assembly is now finished.
- Now press the cap / clip assembly into the top end of the tube.
- Insert the pencil mechanism into the cap end so that the end of the mechanism exits the lower end of the pencil.
- Screw the pencil tip onto the mechanism being careful not to over tighten it. You may want to add a drop of WD40 onto the tip of the pencil mechanism to help the lead release when advancing the pencil lead.
- Place the cap over the pencil eraser and your pencil is complete!
- Click the mechanism to advance the lead.