

# Legacy “Jam Session” Pen Kit

Assembly Instructions

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

## Description:

The “Jam Session” pen is one of our favorite kits and has some features to make it a “step-up” pen, while still being very easy to make. It uses an 8mm tube and a Parker style refill. It has a heavier feel compared to a Slimline pen. Being a larger pen, it is more surface area to show off a nice pen blank.

The Jam Session uses 8mm brass tubes which are 1 3/4” and 1 5/16” long. The upper tube is longer than the lower tube.

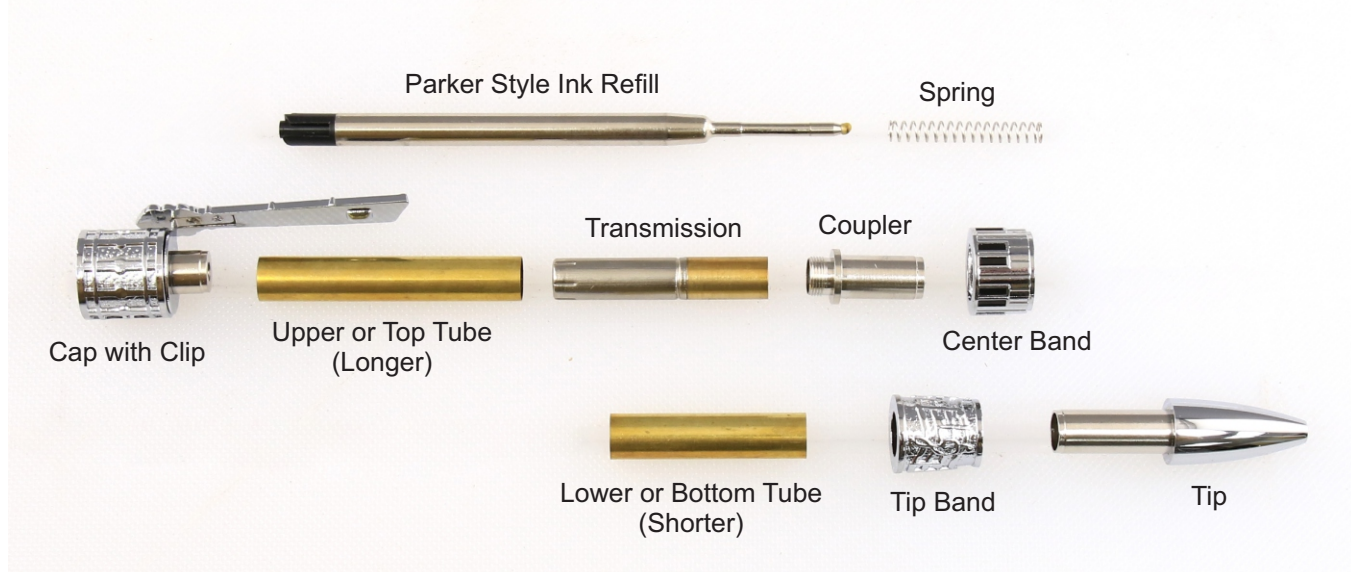
## Getting Started:

You will need the following accessories to make an Inspirational pen. 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 5 inches long x 3/4” x 3/4”
- 8mm drill bit
- Woodturning pen mandrel with 7mm rod
- Jam Session pen bushing set
- Pen barrel trimmer (8mm)
- Glue (CA, epoxy or polyurethane [Gorilla])
- Lathe, turning tools, sandpaper, pen finish
- Other items may be needed as desired



## Parts of the Jam Session Pen Kit:



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## Preparing the Blank for Turning:

- Start with your wood or acrylic blank and cut it in half so you have 2 pieces, The upper piece should be about 2” and the lower piece should be about 1 ½” in length. Mark the blank with “hash marks” at the cut line so you can keep the grain matched when you mount the blanks on the pen mandrel.
- Using a 8mm 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 (8mm) 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.

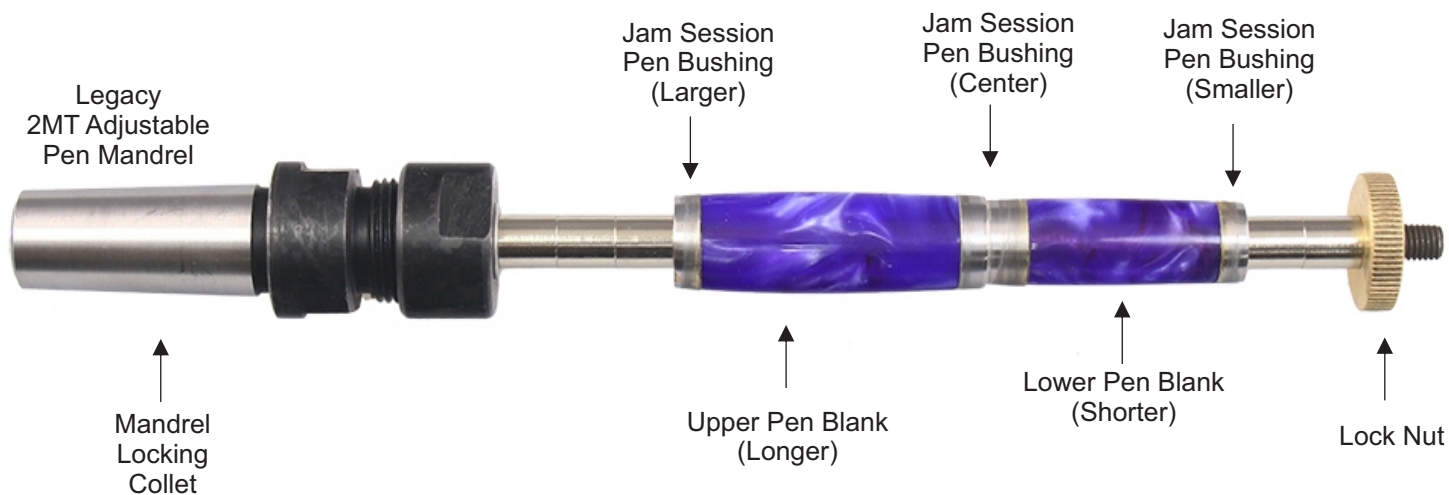
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## Turning the blanks on the lathe

- Use a pen turning mandrel with a 7mm shaft and Jam Session pen bushings (available at our store). The Jam Session set consists of three bushings. For the Jam Session kit, the end bushings are different diameters. The cap bushing is slightly larger than the tip bushing. You may want to add slimline bushings to give additional clearance around the pen mandrel collet and lock nut.
- Mount the pen blanks on the mandrel as shown in the diagram below. Make sure that your “hash marks” are in the center which assures that the grain of your blank will match that of the original single piece blank. Adjust the mandrel shaft so that the lock nut will tighten down on the assembly of pen blanks and bushings. Hand tighten the nut. Note that the upper pen tube is longer than the lower tube. Pay careful attention to this when you mount your pen blanks on the mandrel.
- 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.
- 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 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!)

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## Assembly of the Finished Pen:



- Now that you have turned and finished the blanks into the upper and lower halves, you are ready to assemble your pen.
- It is highly recommended that you use a vise or clamp to assemble the pen. 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, lay out your blanks so that you recall how the grain originally matched.
- First, insert tip band onto the tip and then press the pen tip into the lower or front tube, (shorter tube, narrow end).
- Take the coupler and pass it through the center band.
- Next, press the unthreaded end of coupler into the upper end of the lower tube. It is a good idea to make a spacer block with a hole in it to press the coupler into the lower tube. The threaded end of the coupler is very delicate and can be damaged if pressed in directly.
- The lower assembly is now finished.
- Press the cap with clip into the top end of the upper tube.
- The upper assembly is now finished.
- Insert the spring into the lower assembly, followed by the pen refill.
- Screw the transmission on to the lower assembly.
- Push the top assembly onto the lower assembly and your pen is complete!