

Legacy “Streamline” Pencil Kit

Assembly Instructions

Available at www.thewoodturningstore.com

Description:

The “Streamline” model is considered one of the basic pen kits and is a great starter kit for those new to pen turning. The Streamline kit is very similar to the Slimline kit but it has a wider center band, which allows for a slightly “heftier” pen. Many experienced pen turners use the Streamline kit to make elaborate and unusual pens and pencils which vary greatly from the basic Streamline pen.

The Streamline uses two 7mm brass tubes of equal length. The tubes are $2 \frac{3}{32}$ ” long. The center band is wider than the cap and tip, so the pencil will need to be turned with a slight taper from the center band to the cap or tip. Like the Slimlines, you can alter the shapes away from the standard taper and make interesting designs.

The Streamline is available in a wide range of finishes (Gold, Silver, Gun Metal, etc). You can also customize your Streamline pencils with a wide variety of decorative pen clips.

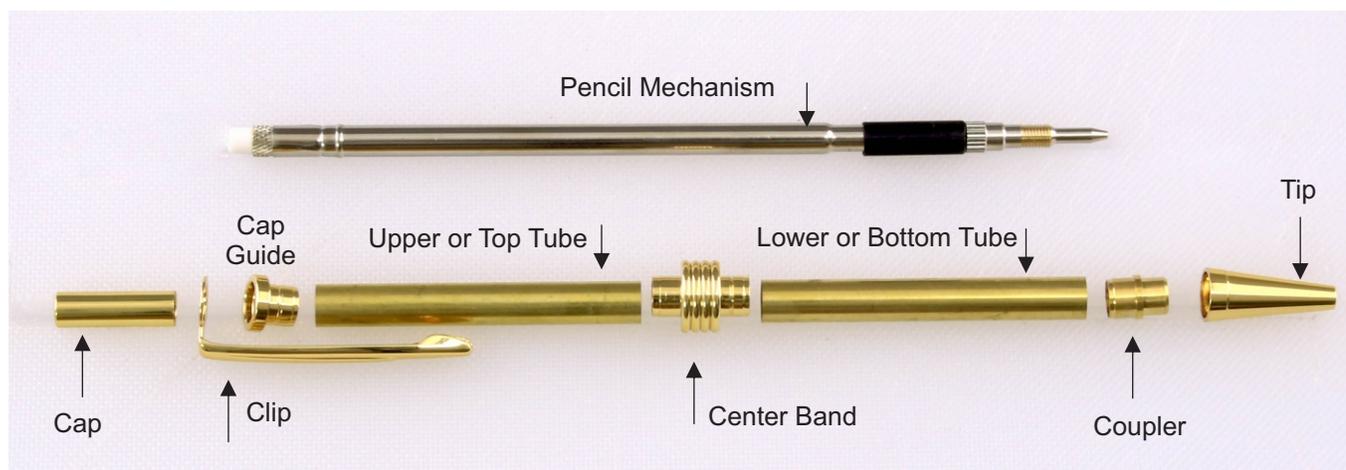
Getting Started:

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

- 1 wood or acrylic blank, approximately 5 inches long x $\frac{5}{8}$ ” x $\frac{5}{8}$ ”
- 7mm drill bit
- Woodturning pen mandrel with 7mm rod
- Streamline pen bushing set (Different than the Slimline bushing set)
- Pen barrel trimmer (7mm)
- Glue (CA, epoxy or polyurethane [Gorilla])
- Lathe, turning tools, sandpaper, pen finish
- Other items may be needed as desired



Parts of the Streamline Pencil 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, each about 2 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 7mm 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 (7mm) 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 pencil kit.
- Your blanks are now ready to be mounted on the lathe.

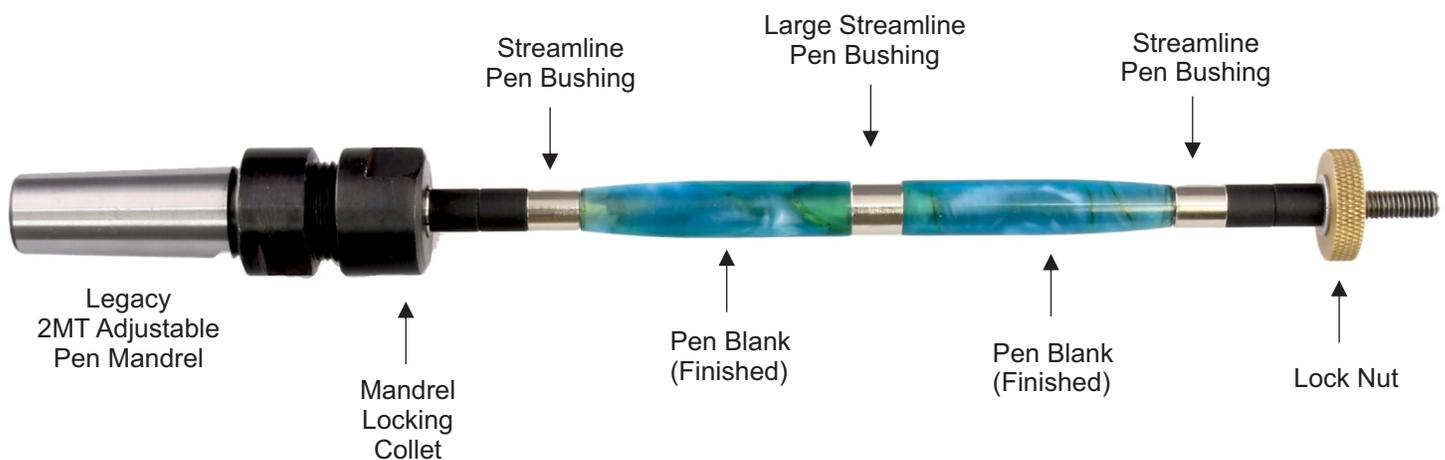
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Turning the blanks on the lathe

- Use a pen turning mandrel with a 7mm shaft and streamline pen bushings (available at our store). The Streamline bushing kit includes three bushings, the center bushing is slightly larger in diameter than the end bushings.
- Mount the 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.
- 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

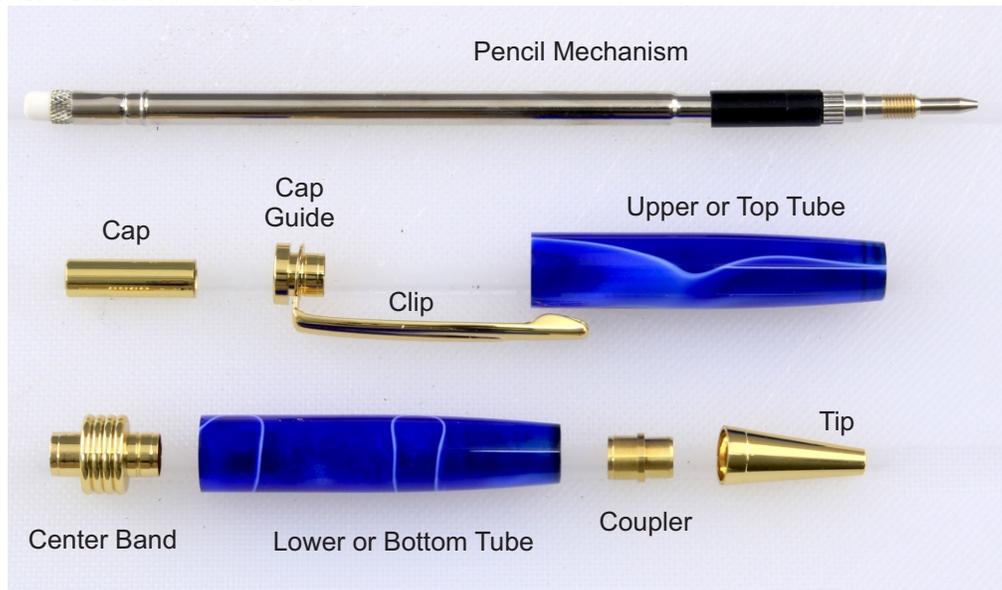
- Most pens are finished to a high luster and finished with a durable coating of protective finish. Depending on your skill level and the material being used, you will need to sand with aluminum oxide paper of progressively finer grits, starting with a grit coarse enough to remove all tool marks and 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 pencil!)
- 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 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, press the coupler into the lower or bottom tube. The wider end of the coupler is the end that gets inserted into the end of the front tube. Insert the coupler until it hits the shoulder of the coupler.
- Press the center band into the top end of the front tube.
- Press the upper tube into the top end of the band.
- Press the upper cap guide through the clip and into the top end of the upper tube.
- The pencil should now be a single piece.
- 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.
- Place the cap over the pencil eraser and your pen is complete! Click the mechanism to advance the lead.