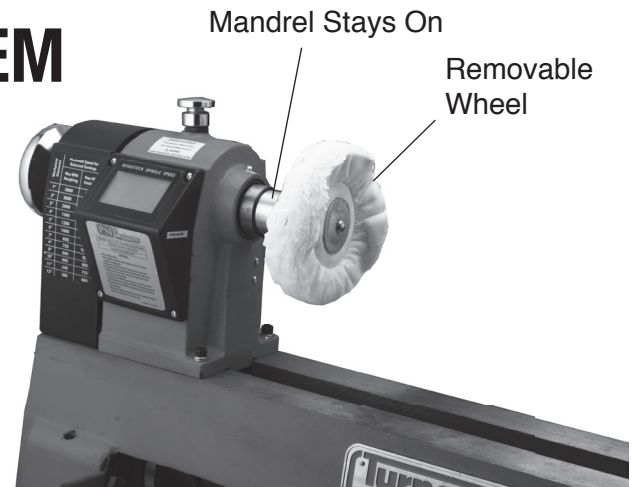


PEN MAKERS' BUFFING SYSTEM

System Includes:

- 3-½" long mandrel rod with 1" x 8 tpi mounts.
- 3 - 4" wheels: **A.** Tripoli, **B.** White Diamond and **C.** Carnuba Wax.
- 3 – Compound Bars: **D.** Tripoli, **E.** White Diamond and **F.** Carnuba Wax.
- Hardware: 3/8" x 16tpi Mounting Bolt, Washer and Allen Wrench.



BUFFING INSTRUCTIONS:

- Sand the wooden pen barrel to a high grit abrasive. (600x or Greater)
- Cover the blank with Mahoney's Utility Oil #LBUFFOIL (or other utility oil of your choice). Let dry overnight.
- Mount the mandrel rod with the Tripoli marked wheel, onto the lathe spindle.
- Turn the lathe on to between 2,500 to 3,000 RPM. Dress the wheel with the Tripoli bar. Engage bar until wheel is loaded.
- Engage the pen barrel to the wheel. Buff in the direction of the grain. Do not push the wood into the wheel. Rather, use a light touch.
- Replace the wheel with the White Diamond wheel. Turn on and dress the wheel with the white bar. Repeat the process using a light touch.
- Replace the wheel with the Carnuba Wax wheel. Dress the wheel and repeat the buffing to achieve the high gloss on the pen barrel.
- The barrel is buffed, ready to assemble.

