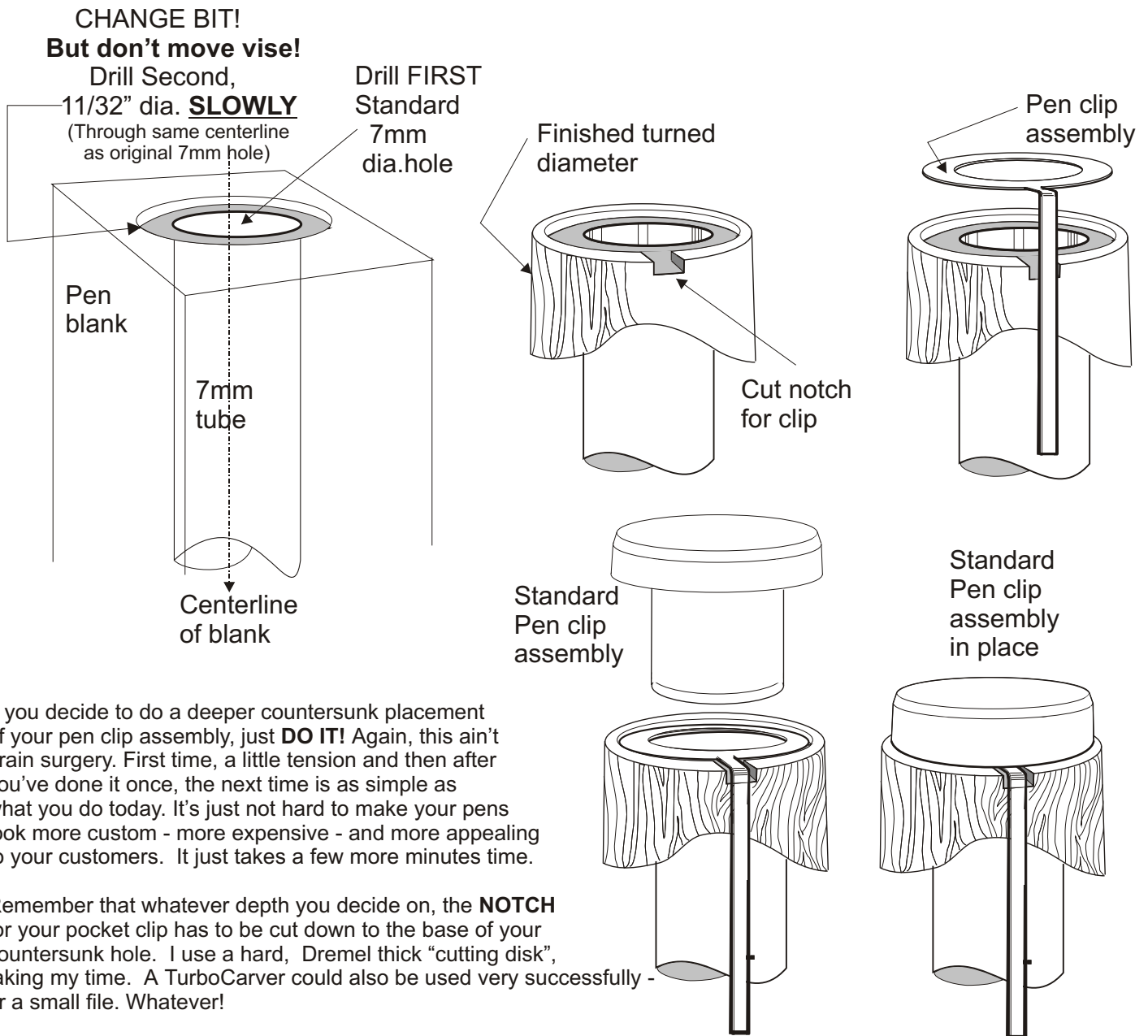


Technique for Making Countersunk Pocket Clip Variations

With pen blank in vise, drill 7mm hole, as usual. ***Without moving the vise***, change drill bit to 11/32". SLOWLY (because a normal twist bit will cut fast and furiously) **re-cut**, letting the 7mm hole act as a "guide" for the 11/32" bit. Your cut will be very shallow for the example below or for using your own turned finial (see "Making a Hand-made Finial") - probably 1/16" to 1/8". This will put the top of your standard finial countersunk to just below the actual height of the pen top.

However, if you want your standard brass finial to sit down deeper - even up to 1/4" - 5/16" below the top surface of your blank, then simply drill your 11/32" hole to the depth you want. The 11/32" drill diameter is just a tad larger than the **diameter** of your pen clip and the brass "holding finial". They both slip easily down into the hole. Drilling a deep 11/32" hole, will allow you to (after the pen is turned to size) grind your top at an angle (your choice) and give the top a great designer-custom look. (See photo examples to follow).



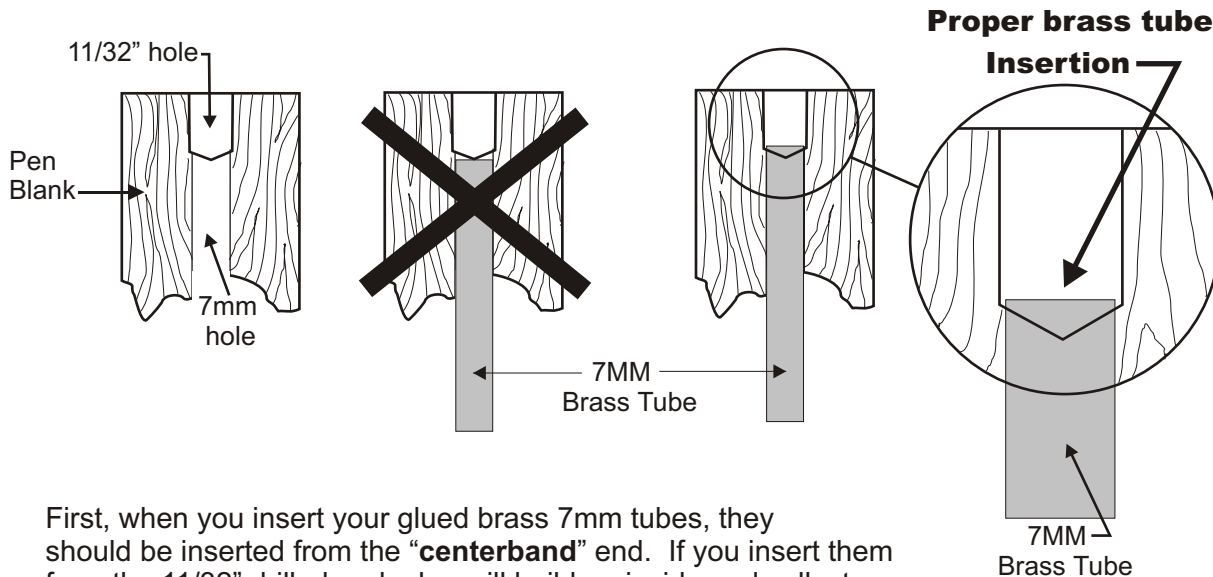
If you decide to do a deeper countersunk placement of your pen clip assembly, just **DO IT!** Again, this ain't brain surgery. First time, a little tension and then after you've done it once, the next time is as simple as what you do today. It's just not hard to make your pens look more custom - more expensive - and more appealing to your customers. It just takes a few more minutes time.

Remember that whatever depth you decide on, the **NOTCH** for your pocket clip has to be cut down to the base of your countersunk hole. I use a hard, Dremel thick "cutting disk", taking my time. A TurboCarver could also be used very successfully - or a small file. Whatever!

I also use a **black** felt marker and color the cut **edges** I've made for the pocket clip cutout. I also blacken all the interior of the 11/32" hole I've drilled. It just hides any discoloration or imperfection in drilling through different materials, which can leave the normal scratches of a drill or file or cutting disk - the black marker is permanent and waterproof - just makes it all look "finished"- AND more professional.

A WORD ABOUT HOW TO GLUE IN YOUR 7mm BRASS TUBES

When drilling with the 11/32" drill bit, the "profile" of its cutting edge appears somewhat POINTED at the bottom of the hole.



First, when you insert your glued brass 7mm tubes, they should be inserted from the "centerband" end. If you insert them from the 11/32" drilled end, glue will build up inside and collect inside the cavity immediately around the end of the tube. This area must be kept pristine and clear of glue, so that when the brass nib and pocket clip is put into place it can be "pressed" into place without any glue obstruction or build-up.

Therefore, the tube should be pushed in until it "clears" the pointed or concave portion of the drilled hole - see "enlarged" illustration above.

I'm sure I've left out some things, but hopefully a view of some of the finished pens might really clear things up. Again, this isn't hard - it just might be something new for you. Give it a try - you might just find that doing something unusual might just make you stand out a bit more than those that wont budge from their Euros or Slimlines.

Enjoy! Jay Pickens

