

Native Pens

Making a Milling Bush

The method to follow shows the process Native Pens uses to create a Milling Bush which can be used with our 7mm Pen Mill for milling Pen Kits with larger tube sizes. Turning a timber bush that will fit inside the pen kits brass tube and support the mill shaft does this. We recommend that no more than 0.5-1mm of timber be milled off using a Pen Mill. Blanks may need to be sanded on a disc before milling.

Required Accessories.

- Pen Mandrel.
- Pen Mill.
- 20 x 20 x 40mm Hardwood Blank

Bushings set for desired pen kit.

Cutting and Drilling the Blank

1. Using a piece of hardwood, Cut a blank 20mm x 20mm x 40mm.
2. Drill the blank through the centre with a 1/4" drill.
3. Using your pen mill, square up the ends of the blank. The picture below shows the blank ready to assemble on the mandrel



4. Sand down the Mill Bush until it is very close to the lower part of the bushings.



Turning the Milling Bush.

1. Using the set of bushings for the pen kit you are making, assemble the Blank and Bushings on the mandrel so the blank is between the bushings.



2. Using a suitable chisel, start turning the bush, remove timber until you are approximately 1mm off the lower part of the bushings.



3. Next, check the diameter of the lower part of the bush, followed by the Milling Bush. It also pays to check the inside diameter of the brass tube as the bush needs to be a snug fit inside the tube.

5. Check the final diameter then remove from the mandrel and check the fit inside the pen tube.



Using the Milling Bush.

1. Place the Milling Bush over the shaft of the Pen Mill, and then slip both into the Brass tube. Now mill the blank as normal.

