

## Pointers for using Speedball Pen Points

### Hold pen properly.

There should be only 3 points of contact with the paper: the point of the pen, the tip of your ring finger and the outside edge of your palm. Do not hold pen too tightly—a tight grip destroys the beauty and freedom of your work.

### Posture is important.

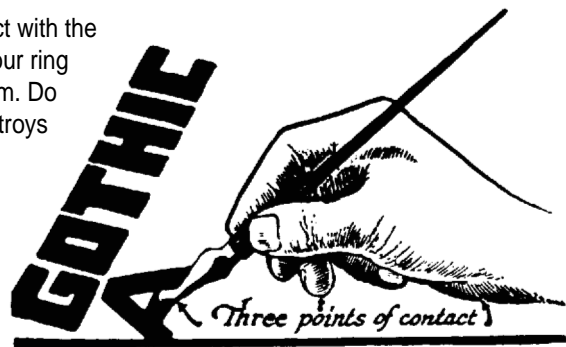
Sit erect or stand close to the desk; keep the feet flat on the floor or the foot rest. Don't lean on the pen.

### Use paper with a hard finish.

The paper you choose is critical to the quality of lines and lettering you create. When you purchase paper, look at the kind and description on front of the pad, for example, "Drawing Paper. Can be used with pencil, crayon, pastel, charcoal, and pen and ink." Bristol paper with a plate surface is also a good choice. If you choose the wrong paper, two things can happen: the ink will feather or bleed, creating messy lines or paper fibers may become stuck in the pen point.

### Hold paper in position.

The best results are secured with the paper or card flat on the desk slightly to the right and turned a trifle to the left. Hold your work in place with your left hand while lettering with the right—do not tack the card to the desk.



### Use free-flowing Speedball ink; dip pen carefully.

Sticky, gummy and glossy inks never give satisfaction. They generally clog the pens and cause spots or streaks. Speedball® Super Black India and Waterproof Drawing Inks (black and colors) are specially formulated for making clean images with Speedball® pens.

Dip the pen deeply enough into the ink to fill the reservoir, then wipe off the surplus by drawing the underside of the pen across the edge of the bottle. This will eliminate any chance of blotting caused by overloading of feeders. Be sure to clean the pen after each use. Clean pens do clean work.

### General lettering tips.

Study the shape and construction of each letter. Note the order and direction of each stroke before using pen. Do not try to work too fast. Strive for quality first and speed will develop later.

Fit strokes together so that "overlaps" do not show in the finished letters. You will improve your stroke by forming the ovals wider. Pay special attention to the positions of the pen point in relation to individual characters and alphabets.

### Work and rest.

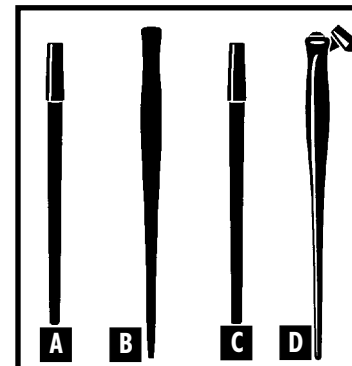
Work with a full arm stroke. Keep the top of the pen flat on the paper and do not contract the fingers. Rest an instant at the finish of each stroke before lifting the pen from the paper. This will produce clean-cut elements with sharp terminals.

### Lettering styles and strokes.

Lettering styles are created with only a few basic strokes—straight horizontal, vertical and diagonal lines, as well as curved lines. Look closely at the examples on this lettering chart to learn the correct direction to use in forming each kind of stroke.

### Lettering style books available.

Speedball® Elementary Alphabet Book (3066); Speedball® Textbook (3067); and the Abraham Lincoln Introduction to Handwriting & Calligraphy (3092). Check with your retailer for prices.



SPEEDBALL New Classic Pen Holders



### HUNT

A 9452 Crow Quill Holder

### SPEEDBALL New Classic Pen Holders:

(shown top right)  
 B 9459 Gold & Black  
 B 9461 Silver & Black  
 B 9464 Gold Multi-Color  
 B 9466 Black  
 B 9468 Mahogany

### Traditional Pen Holders:

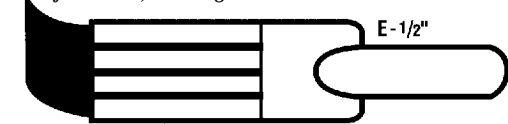
B 9451 Black Plastic  
 C 9454 Holder No. 104  
 D 9455 Oblique  
 All items above are open stock

Ask your Fine Art Dealer for Speedball® Hunt pen points and holders.

Both blister-carded packages and open stock are available.

Select the proper pen holder for your pen point.

### STEEL BRUSH for charts, lettering and illustrations



ITEM #	SIZE	TYPE
3084	3/4"	B
3083	1/2"	WITH ALL 4 STEEL BRUSHES
3082	3/8"	
3081	1/4"	

USE PEN HOLDER TYPE

SEE CHARTS 7, 8 & 9 FOR MORE INFORMATION ABOUT STEEL BRUSHES

## SPEEDBALL® Pen Points—Actual Size

### STYLE 'A' SQUARE PEN POINTS for creating black and poster Gothic letters, ornamented borders, designs and decorations

ITEM #	USE PEN HOLDER TYPE
A-5 30050	A5 B
A-4 3004	A4 B
A-3 30030	A3 B
A-2 30020	A2 B
A-1 30010	A1 B
A-0 3000	A0 B

### STYLE 'B' ROUND PEN POINTS is ideal for Gothic or outline letters, cartoons, uniform line drawings, borders and display posters

ITEM #	USE PEN HOLDER TYPE
B-6 3016	B6 B
B-5 1/2 3018	B5.5 B
B-5 3015	B5 B
B-4 3014	B4 B
B-3 3013	B3 B
B-2 30120	B2 B
B-1 3011	B1 B
B-1/2 3017	B.5 B
B-0 3010	B0 B

### STYLE 'C' FLAT PEN POINTS is designed for Roman, texts, and italic lettering, as well as accented line drawings, scrolls or scripts

ITEM #	USE PEN HOLDER TYPE
C-6 3026	C6 B
C-5 3025	C5 B
C-4 3024	C4 B
C-3 30230	C3 B
C-2 30220	C2 B
C-1 30210	C1 B
C-0 3020	C0 B
Left-Handed Pen Points	
3054	LC4
3053	LC3
3052	LC2
30510	LC1
3050	LC0
3055	LC Set of 5

### STYLE 'D' OVAL PEN POINTS is ideal for bold Roman, texts and italic lettering, as well as for bold line poster styles, scrolls and scripts

ITEM #	USE PEN HOLDER TYPE
D-5 3035	D5 B
D-4 3034	D4 B
D-3 3033	D3 B
D-2 3032	D2 B
D-1 3031	D1 B
D-0 3030	D0 B
D-00 3036	D00 B
30090	A Set of 6 Points
3019	B Set of 6 Points
3029	C Set of 6 Points
3039	D Set of 6 Points

## Instruction Chart 1

This chart demonstrates two kinds of Gothic lettering—Type A, which is square, and Type B, which is round.

The art below shows the actual sizes of the pen points and the strokes they make.

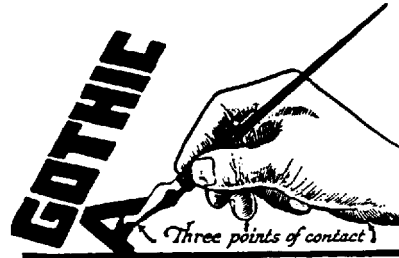
**"A" SQUARE PEN POINTS**

ITEM #	USE PEN HOLDER TYPE
A-5 30050	A5 <b>B</b>
A-4 3004	A4 <b>B</b>
A-3 30030	A3 <b>B</b> *
A-2 30020	A2 <b>B</b>
A-1 30010	A1 <b>B</b>
A-0 3000	A0 <b>B</b>

**"B" ROUND PEN POINTS**

ITEM #	USE PEN HOLDER TYPE
B-6 3016	B6 <b>B</b>
B-5½ 3018	B5.5 <b>B</b>
B-5 3015	B5 <b>B</b>
B-4 3014	B4 <b>B</b> *
B-3 3013	B3 <b>B</b>
B-2 30120	B2 <b>B</b>
B-1 3011	B1 <b>B</b>
B-1½ 3017	B.5 <b>B</b>
B-0 3010	B0 <b>B</b>

## EXERCISES LEADING INTO THE CONSTRUCTION OF GOTHIC LETTERS




Vertical lines, vertical lines with horizontal bars, and horizontal lines with vertical bars.

W A W A V A V . Y X Y X Y X Y . V A W A Y A

M N M N K N K M Z N Z N K M Y N K Z K

HOLD PEN BETWEEN THE TWO FIRST FINGERS AND THUMB.  
WORK WITH AN ARM MOVEMENT TO KEEP TIP IN FULL CONTACT WITH PAPER.



Continuous loops and decorative flourishes.

Vertical lines with decorative curves and loops.

Circles and letters C, G, Q with construction lines. Includes note: "CAN BE MADE IN ONE STROKE".

Letters D, B, P, R, S, 8 with construction lines and decorative variations.

Use A3 and B4 Speedball pen points to create lettering the same size as these examples.

## Instruction Chart 2

This chart demonstrates single-stroke Gothic alphabets.

The art below shows the actual sizes of the pen points and the strokes they make.

**"B" ROUND PEN POINTS**

ITEM #	USE PEN HOLDER TYPE
B-6	B6
B-5 1/2	B5.5 *
B-5	B5 *
B-4	B4
B-3	B3
B-2	B2 *
B-1	B1
B-1/2	B.5
B-0	B0

**"D" OVAL PEN POINTS**

ITEM #	USE PEN HOLDER TYPE
D-5	D5
D-4	D4
D-3	D3 *
D-2	D2
D-1	D1
D-0	D0
D-00	D00

**SINGLE STROKE GOTHIC ALPHABETS**

B2 ABCDEFGHIJKLMNOPQRSTUVWXYZ

B5 ABCDEFGHIJKLMNOPQRSTUVWXYZ

D3 ABCDEFGHIJKLMNOPQRSTUVWXYZ

B2 \$1234567889¢ \$123456789¢

B5-1/2 abcdefeffghijklmnopqrstuvwxyz Flicker

B2 abcdefghijklmnopqrstuvwxyz

B5 abcdefghijklmnopqrstuvwxyz

D3 abcdefghijklmnopqrstuvwxyz








Use B2, B5, B5-1/2, and D3 Speedball pen points to create lettering the same size as these examples.

### Instruction Chart 3




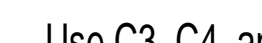

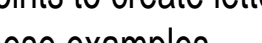
This chart demonstrates two variations of Gothic lettering.

The art below shows the actual sizes of the pen points and the strokes they make.

**"C" FLAT PEN POINTS**

Pen Point	ITEM #	USE PEN HOLDER TYPE
	3026	C6 <b>B</b>
	3025	C5 <b>B</b> *
	3024	C4 <b>B</b> *
	30230	C3 <b>B</b> *
	30220	C2 <b>B</b>
	30210	C1 <b>B</b>
	3020	C0 <b>B</b>

Left-Handed Pen Points	ITEM #	LC
	3054	LC4
	3053	LC3
	3052	LC2
	30510	LC1
	3050	LC0
	3055	LC Set of 5

Use C3, C4, and C5 Speedball pen points to create lettering the same size as these examples.

Manuscript Writing Alphabets

C4 **A B C D E F G H I J K L M N O P Q R S T U V W X Y & Z**  
*abcdefghijklmnopqrstuvwxyz* <sup>a</sup>*abcdefghijklmnopqrstu* <sup>g</sup>*vwxyz* <sup>s</sup>*u* <sup>v</sup>*t* <sup>t</sup>*t*

C5 **A B C D E F G H I J K L M N O P Q R S T U V W X Y & Z**  
*abcdefghijklmnopqrstuvwxyz* 357 \$ 123 4 5 6 7 8 9 0 † 234

C3 **A B C D E F G H I J K L M N O P Q R S T U V W X Y Z & ?**  
*abcdefghijklmnopqrstu* *vwxyz* *abcdefghijklmnopqrstu* *vwxyz*

C4 **A B C D E F G H I J K L M N O P Q R S T U V W X Y Z & ?**  
*abcdefghijklmnopqrstu* *vwxyz* 123456789 †




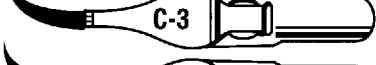
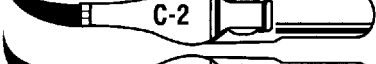
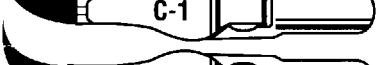

C3 **A B C D E F G H I J K L M N O P Q R S T U V W X Y Z & ?**

C4 **A B C D E F G H I J K L M N O P Q R S T U V W X Y Z & ?**  
*abcdefghijklmnopqrstu* *vwxyz* & \$ 2356 \$ 847

## Instruction Chart 4

This chart demonstrates two variations of Gothic lettering.

The art below shows the actual sizes of the pen points and the strokes they make.

"C" FLAT PEN POINTS		USE PEN HOLDER TYPE
	ITEM # 3026	C6 <b>B</b>
	3025	C5 <b>B</b>
	3024	C4 <b>B</b>
	30230	C3 <b>B</b>
	30220	C2 <b>B</b> *
	30210	C1 <b>B</b>
	3020	C0 <b>B</b>
Left-Handed Pen Points	3054 LC4 3053 LC3 3052 LC2 30510 LC1 3050 LC0 3055 LC Set of 5	

Use C2 Speedball pen points to create lettering the same size as these examples.



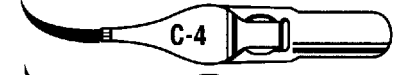
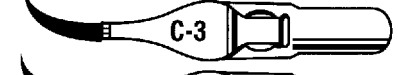
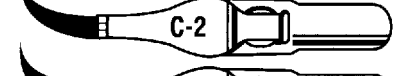
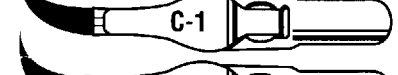

### Single Stroke Speedball Roman Alphabets

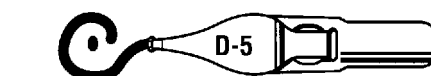
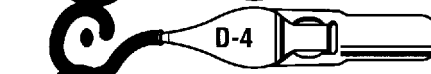
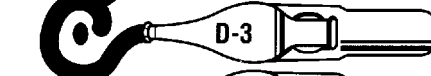
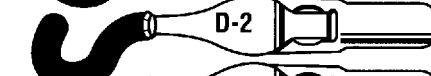





## Instruction Chart 5

This chart demonstrates Roman italics and bold italic alphabets.

The art below shows the actual sizes of the pen points and the strokes they make.

"C" FLAT PEN POINTS		USE PEN HOLDER TYPE
	ITEM # 3026	C6 <b>B</b>
	3025	C5 <b>B</b>
	3024	C4 <b>B</b>
	30230	C3 <b>B</b> *
	30220	C2 <b>B</b>
	30210	C1 <b>B</b>
	3020	C0 <b>B</b>

"D" OVAL PEN POINTS		USE PEN HOLDER TYPE
	ITEM # 3035	D5 <b>B</b>
	3034	D4 <b>B</b> *
	3033	D3 <b>B</b> *
	3032	D2 <b>B</b>
	3031	D1 <b>B</b>
	3030	D0 <b>B</b>
	3036	D00 <b>B</b>

Use C3, D3 and D4 Speedball pen points to create lettering the same size as these examples.

*a e v Roman Italics single-stroke* *w y g,*

*abcdefghijklmnopqrstuvwxyz*

C3 *abcdefghijklmnopqrstuvwxyz*

*ABCDEFGHIJKLMNOPQRSTUVWXYZ*

*VWXYZ & \$ 1 2 3 4 5 6 7 8 9 ¢ WXYZ*

*ABCDEFGHIJKLMN O PQRSTU V*

*Bold Roman Italic Alphabets made single-stroke with style 'D' Speedballs*

D3 *\$ 1 2 3 4 5 . a b c d e f g h i j k l m n o p q r s t u v w x y z 6 7 8 9 ¢*

*ABCDEFGHIJKLMNOPQRSTUVWXYZ & Z*

*abcdefghijklmnopqrstuvwxyz \$ 1 2 3 4 5 6 7 8 9 ¢*

D4 *ABCDEFGHIJKLMNOPQRSTUVWXYZ w ;*

## Instruction Chart 6

Speedball Engrossers' "Old English" is much easier to produce than it looks.

The art below shows the actual sizes of the pen points and the strokes they make.

### "C" FLAT PEN POINTS

ITEM #	USE PEN HOLDER TYPE
C-6 3026	C6 <b>B</b>
C-5 3025	C5 <b>B</b>
C-4 3024	C4 <b>B</b>
C-3 30230	C3 <b>B</b> *
C-2 30220	C2 <b>B</b>
C-1 30210	C1 <b>B</b>
C-0 3020	C0 <b>B</b>

### "D" OVAL PEN POINTS

ITEM #	USE PEN HOLDER TYPE
D-5 3035	D5 <b>B</b>
D-4 3034	D4 <b>B</b>
D-3 3033	D3 <b>B</b> *
D-2 3032	D2 <b>B</b>
D-1 3031	D1 <b>B</b>
D-0 3030	D0 <b>B</b>
D-00 3036	D00 <b>B</b>

Use C3 and D3 Speedball pen points to create lettering the same size as these examples.

### Speedball Engrossers' "Old English"

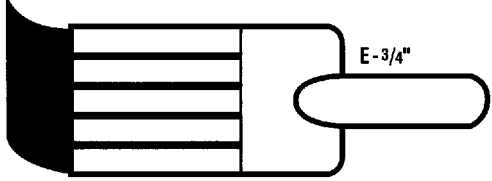
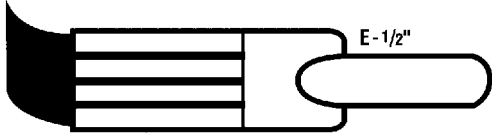
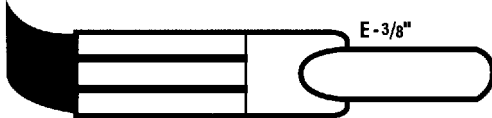

C4  
 ABCDEFGHIJKLMNOPQRSTUVWXYZ  
 ABCDEFGHIJKLMNOPQRSTUVWXYZ

C3  
 ABCDEFGHIJKLMNOPQRSTUVWXYZ  
 abcdefghijklmnopqrstuvwxyz  
 abcdefghijklmnopqrstuvwxyz  
 abcdefghijklmnopqrstuvwxyz  
 Speedball Bold English Text simplified with the Style D oval tip pens  
 D3  
 ABCDEFGHIJKLMNOPQRSTUVWXYZ  
 abcdefghijklmnopqrstuvwxyz aefgs

# Instruction Chart 7 (Part I)

## HANDCRAFT LETTERING

Steel brushes are used to make large lettering for posters. Actual sizes of brushes and strokes are shown here:

STEEL BRUSH	ITEM #	USE PEN HOLDER TYPE
 E-3/4"	3084	3/4" <b>B</b>
 E-1/2"	3083	1/2" <b>B</b>
 E-3/8"	3082	3/8" <b>B</b>
 E-1/4"	3081	1/4" <b>B</b> *

Use E-1/4" Speedball steel brush to create lettering the same size as these examples.



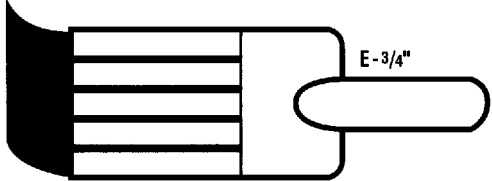
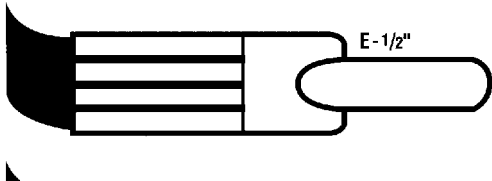
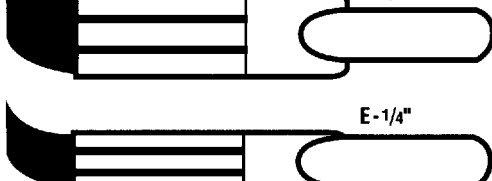
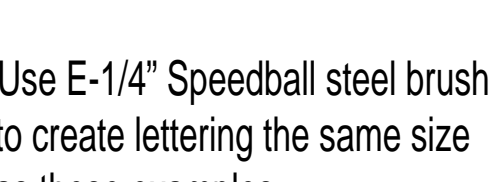


## Instruction Chart 7 (Part II)

### HANDCRAFT LETTERING

Lower case letters for Condensed Roman are shown here. Use steel brushes as shown on Chart 8.

Pay attention to brush positions and directional arrows for best results.

STEEL BRUSH	ITEM #	USE PEN HOLDER TYPE
 E-3/4"	3084	3/4" <b>B</b>
 E-1/2"	3083	1/2" <b>B</b>
 E-3/8"	3082	3/8" <b>B</b>
 E-1/4"	3081	1/4" <b>B</b> *

Use E-1/4" Speedball steel brush to create lettering the same size as these examples.



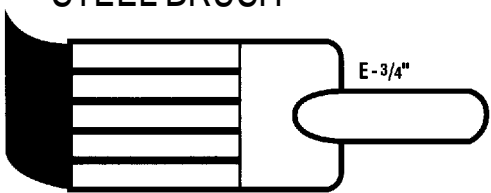
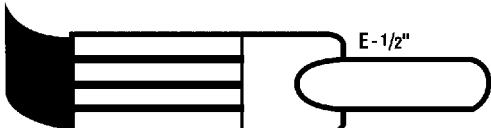
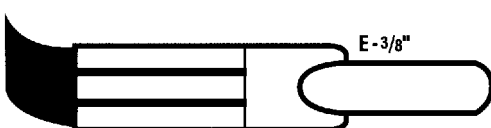

# Instruction Chart 8

## HANDCRAFT LETTERING

A variation on the steel brush strokes used for Condensed Roman can produce beautiful Old English lettering.

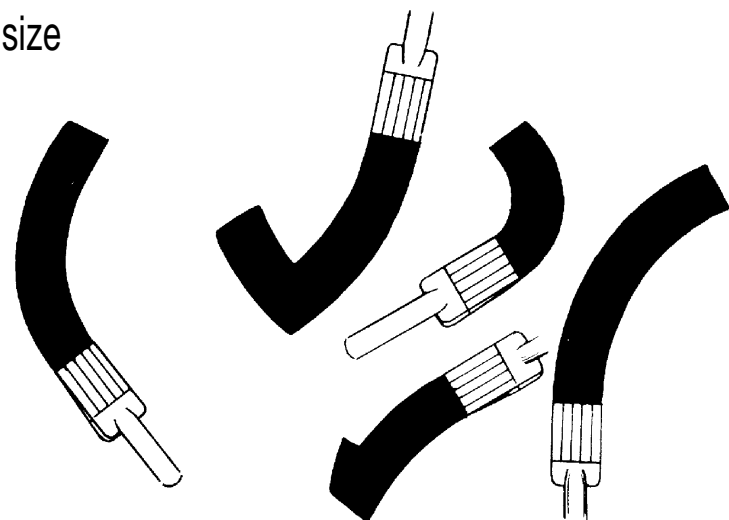
The art below shows the actual sizes of the brushes and the strokes they make.



STEEL BRUSH	ITEM #	USE PEN HOLDER TYPE
	3084	3/4" <b>B</b>
	3083	1/2" <b>B</b>
	3082	3/8" <b>B</b>
	3081	1/4" <b>B</b> *

Use E-1/4" Speedball steel brush to create lettering the same size as these examples.

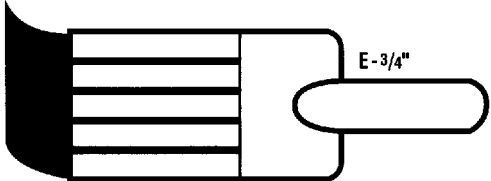
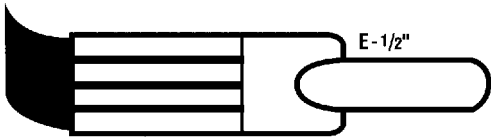
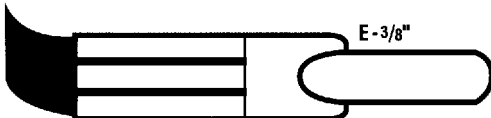

**BASIC STROKES** to create this fast Gothic alphabet wherein the full width of the steel brush is used in any direction. Arcs made by twirling the brush.



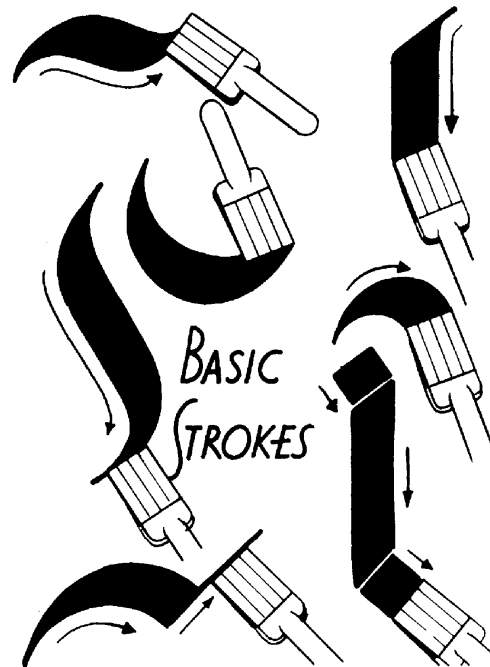
# Instruction Chart 9

## HANDCRAFT LETTERING

Bold Gothic lettering can be accomplished with only five steel brush strokes.

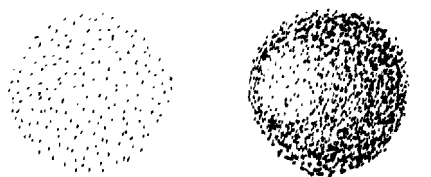
STEEL BRUSH	ITEM #	USE PEN HOLDER TYPE
 E-3/4"	3084	3/4" <b>B</b>
 E-1/2"	3083	1/2" <b>B</b>
 E-3/8"	3082	3/8" <b>B</b>
 E-1/4"	3081	1/4" <b>B</b> *

Use E-1/4" Speedball steel brush to create lettering the same size as these examples.



**Instruction Chart 10**  
**7 BASIC STROKES**

**STIPPLING**



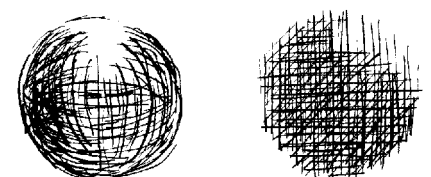
C5

**PARALLEL LINES**



22-B Extra Fine

**CROSSHATCHING**



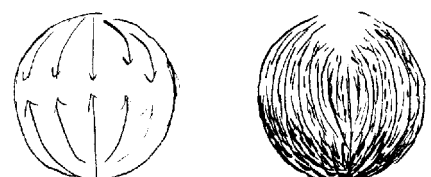
22-B Extra Fine

**CRISSCROSS LINES**



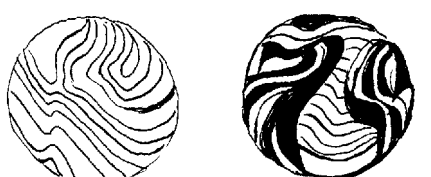
C5

**CONTOURED LINES**



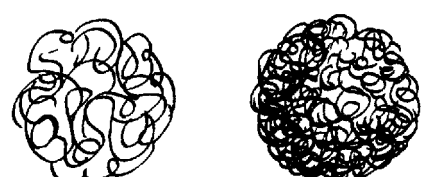
22-B Extra Fine

**WAVY LINES**



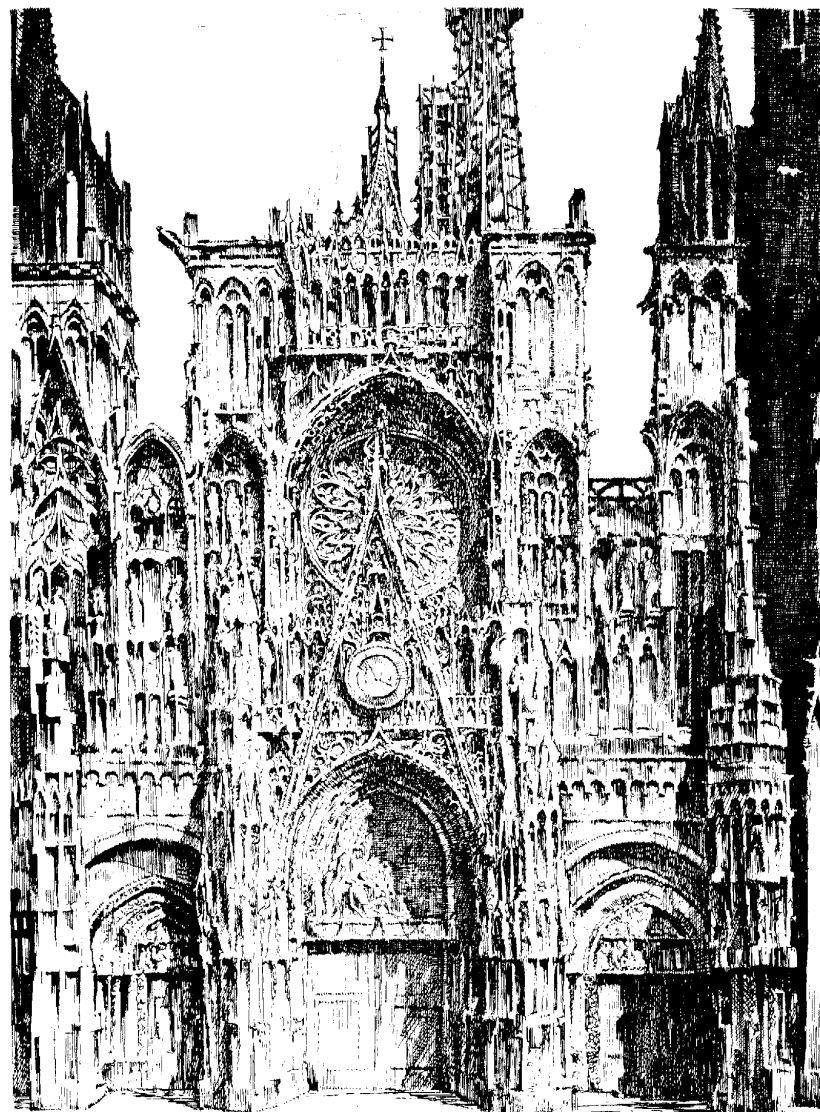
22-B Extra Fine

**SCRIBBLE**



C5

**HUNT**®  
Drawing, Artist & Mapping Points & Holders

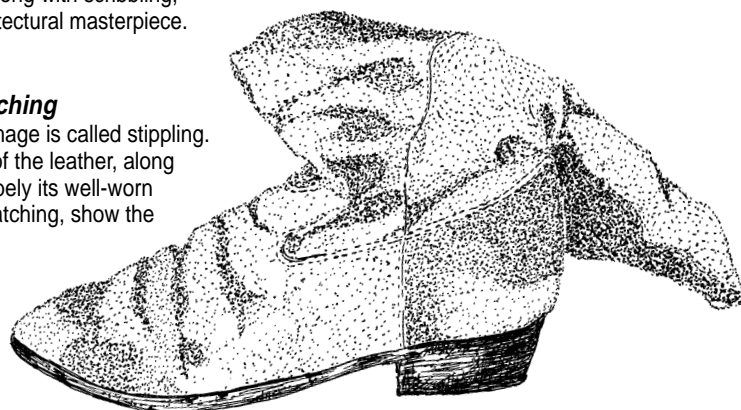


**Combination**

The Rouen Cathedral—one of Earl Horter's last pen drawings. Superb combination of parallel, crosshatched, and contoured lines, along with scribbling, provide contrast and exquisite detail in this drawing of an architectural masterpiece.

**Stippling, Curved Lines & Crosshatching**

The grouping of dots to create an image is called stippling. It works here to create the grainy texture of the leather, along with the folds, creases, and shadows that bely its well-worn state. Curved lines, combined with crosshatching, show the contrasting leather of the sole and heel. C5 Speedball pen point was used. Original reduced at 37%.



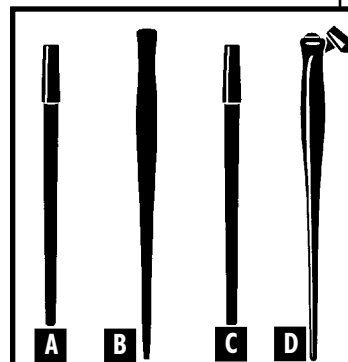
**Combination**

Crisscross lines give feathery texture to angel's wings, while contoured and wavy lines, along with crosshatching and scribbling, portray the flowing lines, layers, and deep folds of her robe and stole. 22B pen point was used. Original reduced.



**Cartoons & Line Art**

Commercial artists know Speedball and Hunt pens are versatile, consistent, and dependable. 22B pen point was used. Original reduced at 67%.



**HUNT**

A 9452 Crow Quill Holder

**SPEEDBALL**

New Classic Pen Holders:

(shown on front page)

B 9459 Gold & Black

B 9461 Silver & Black

B 9464 Gold Multi-Color

B 9466 Black

B 9468 Mahogany

**Traditional Pen Holders:**

B 9451 Black Plastic

C 9454 Holder No. 104

D 9455 Oblique

All items above are open stock

Use Holder A, B, or C as shown with pen points below.

22-B EXTRA FINE - Bronze finish pen for ornamental writing and fine ruling-medium stiff.



ITEM #  
9405

USE PEN  
HOLDER  
TYPE  
**B**

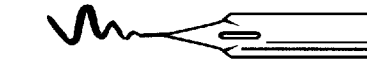
56-SCHOOL - Fine, bronze finish drawing pen for art school, stiff action.



9406

**B**

99-DRAWING - Extra fine point for draftsmen and lithographers.



9409

**B**

100 ARTIST - Very delicate line for experts.



9400

**C**

101 IMPERIAL - Very flexible for ornamental work, bronze finish.



9401

**D**  
**B**

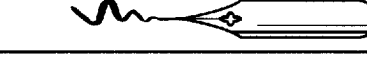
102-CROW QUILL - America's most popular art pen. Superfine and flexible.



9402

**A**

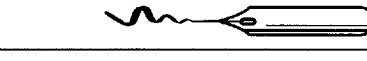
103-MAPPING - For mapping and fine line work.



9403

**D**  
**C**

104-FINEST - Superfine art pen for the fine hair lines and smallest details.



9404

**C**

107-HAWK QUILL - Superfine point, stiffer than 102, very durable. For long even lines and cross-hatching details.



9407

**A**

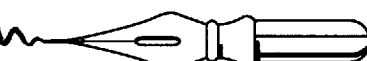
108-FLEXIBLE QUILL - Bronze finish quill pen for cross-hatching, flourishing, lithography.



9408

**A**

512-BOWL POINTED - Bowl pointed fine pen for ruling and lettering.



9412

**B**

513EF-GLOBE - Extra fine bowl pointed for industrial arts.



9413

**B**

**SCRATCH KNIVES**



9442

**C**



9443



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Manufacturer of  
Speedball Pen Points, Holders and Inks

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