

Turning the Blanks

NOTE: When turning the wood down on the lower blank at the lower cap, do not take the wood down to the bushings. Leave a little extra wood. *The lower cap bushings diameter is slightly smaller than required.

- Place three or four 7mm spacer bushings on the mandrel shaft. Next, place the upper cap bushing (longer) wide end on first. Slide the (shorter) upper blank on next, follow with the center bushing, wide end in first. Place the (longer) lower blank on. Follow with the lower cap bushing (shorter). Fill in the space to the threads. Thread on the locknut. Bring the tailstock up to engage the live center with the

mandrel. Tighten the locknut. Lock the tailstock in place (do not over tighten, it could damage the mandrel).

- Turn the wood down flush with the bushings using lathe chisels and gradual lighter grits of abrasive.

Removing Wood For Center Band:

- Use a pencil to mark 1-7/8" from the upper cap bushing on the upper barrel. Use a parting tool to remove the excess wood down to the brass tube. Be careful, you must retain a 90° corner at the end of the upper blank when you remove the excess wood.
- Sand both blanks then finish the blanks with your choice of polish and waxes.

Assembly

Line up and identify finished parts according to Diagram A.

General:

- Press the coupler into the lower end of the lower barrel.
- Slip the "O" ring over the thread to rest in the groove.
- Press the lower cap into the opposite end of the barrel.
- Place the center band, gold end in first, over the recessed end of the upper (shorter) barrel (where the wood was removed).
- Press the cap nut, recessed end in first, into the opposite end of the barrel. Stop at the shoulder. Do not press in beyond the threads.
- Insert the clip hole over the threads of the upper cap and screw in tightly

For the Roller Ball Pen

- Drop the spring inside the lower barrel. Remove the gel refill cap. Insert flat end into the pen barrel. Screw the roller tip extension over the refill. The roller pen is now ready to use.

For the Fountain Pen

- Insert the ink cartridge narrow diameter end in first into the open end of the nib assembly. Press in to break the seal. Squeeze the cartridge lightly to advance the ink into the chamber of the nib.
- Screw the assembly into the pen barrel snugly. The fountain pen is now ready to use.

Operating the Pen

- The pen is ready to operate. A quick quarter turn will screw the ends together. When using the pen, screw the cap over the body end. Always keep the tip covered when not in use to avoid the ink from drying up.

Bushings (#PKBIG-BU)

