

Over & Under Rollerball Pen Kit



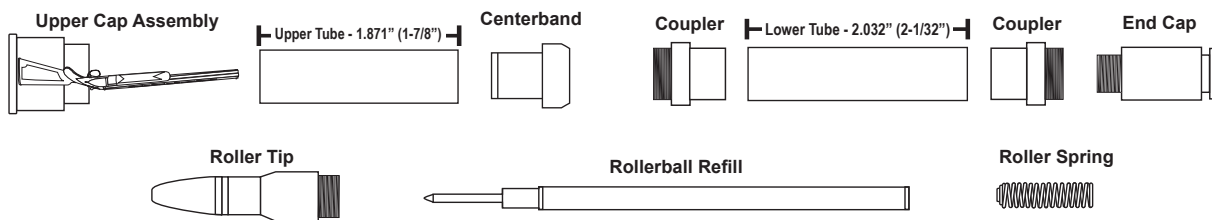
KIT FEATURES

- Pen represents the popular over/under style shotgun
- Simulated 12ga. shotgun Pen Cap
- Simulated .30 cal bullet cartridge body
- Roller Ball uses Premium Refill #PK10-RPR
- Overall length: 6 - 1/2"
- Rose Gold Tip

KIT REQUIRED ACCESSORIES

- 7mm, Pen Mandrel
- 3 pc. bushing set #PKCP6000BU
- 9/16" Drill bit #PKDB916 for the upper blank
- 31/64" drill bit #PK-3164 for the lower blank
- Trimming Sleeves #PKAPBTS (use with 7mm barrel trimmer shaft)
- 2 Part epoxy glue or Insta Cure (cyanoacrylate)
- Extra tubes #PKCP6000TU (2 Sets)

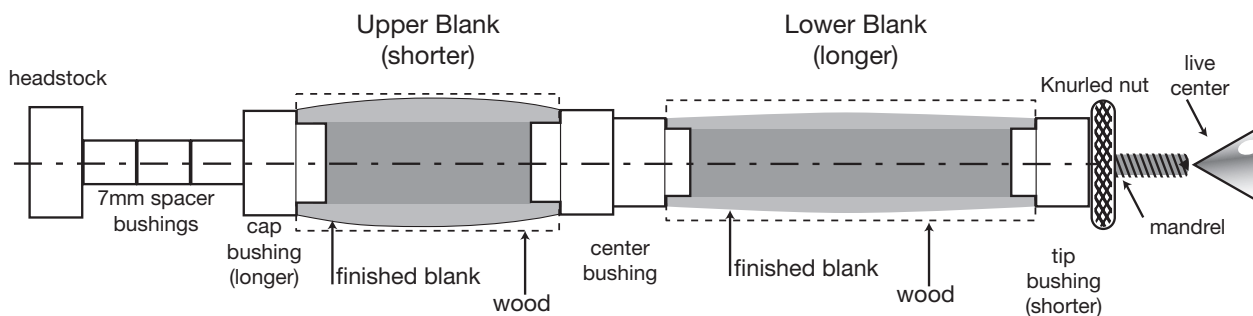
DIAGRAM A – PEN PARTS



PREPARING THE BLANKS

- Before cutting and gluing, make sure to verify tube lengths are correct according to Diagram A
- Cut 3/4" or larger pen blanks to the length of the brass tubes (add 1/16" for trimming).
- Drill a 9/16" diameter hole through the upper blank (shorter).
- Drill a 31/64" diameter hole through the lower blank (longer).
- Spread glue over tubes. Insert each into the proper barrel with a twisting motion to spread the glue evenly.
- When the glue dries, trim the ends of each blank. Use a 7mm barrel trimmer with adapter sleeves (#PKAPBTS). Take the excess wood down to the brass tube. (Do not trim beyond the length of the tube since this may interfere with assembly. Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B – TURNING THE BLANKS



TURNING THE BLANKS

- Slide spacer bushing onto the mandrel shaft, followed by the longer bushing, wide end in first. Slide on the upper blank (shorter). Add the center bushing, wider section in first. Add the center bushing, wider section in first. Place the lower blank (longer) followed by the shorter end bushing, smaller end first. Add Additional spacer bushings as necessary to reach the mandrel shaft threads.
- Thread on the knurled nut hand tight. Bring the tailstock in snug to the mandrel, lock in place. Do not over tighten the knurled nut, it could damage the mandrel.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- Turn the barrels close to the bushing diameter with sharp tools; sand the barrels to match the bushing diameter.
- Finish the wood with your choice of polish.

BUSHINGS #PKCP6000BU

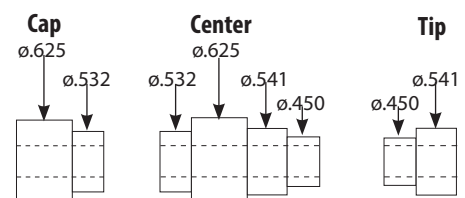
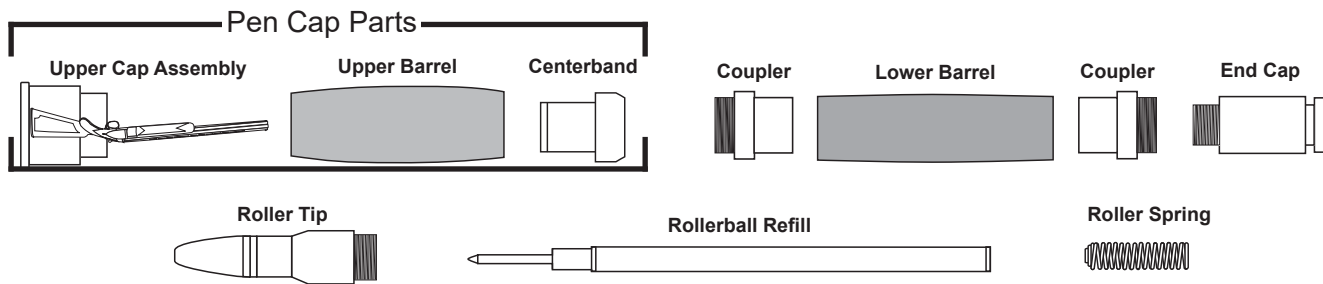


DIAGRAM C - FOUNTAIN PEN / ROLLER BALL**ASSEMBLY**

NOTE: Line up the components according to Diagram C

PEN CAP

- Insert the upper cap assembly, narrow end first into the upper barrel, press in.
- Insert the center band, narrow end in first into the opposite end of the barrel.

PEN BODY

- Press each coupler, narrow end first into the openings at the lower barrel
- Affix the end cap into either one of the couplers Drop the refill spring into the open Coupler so it sits in End Cap.
- Discard the protective cap from the Refill. Insert the Refill, wide end in first into the opening.
- Thread the Roller Tip into the Coupler.
- The Roller Ball pen is ready to operate; Pen Cap can be threaded over End Cap when writing.
- Remember to thread Pen Cap over the Tip end when not in use to prevent ink from drying out.

Pen Cap Posts over End Cap when writing



Pen Cap Posts over Tip when storing

