

Designer Roller Ball / Fountain Pen Kit

Kit Features:

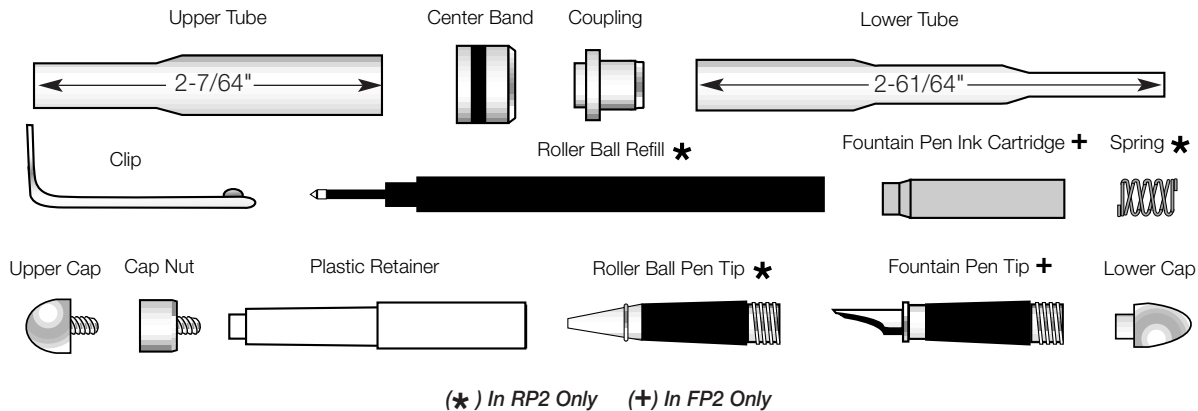
- Heavy 24 kt. gold plating with epoxy coating.
- Designed to match other PSI Mont Blanc® style pens.
- Roller Ball refill with black ink, made in Germany.
- Fountain Pen Iridium nib made in Germany.
- Overall length: 5-3/4" (closed).

Required Accessories:

- 7mm, long mandrel.
- 3 pc bushing set #PKMONT-BU3.
- Step drill bit set (2 bits) #PKMONT-SD3.
- 2 part epoxy glue or inst-cure (cyanoacrylate glue.)

Note: Drawings not to scale

Diagram A / Parts Layout



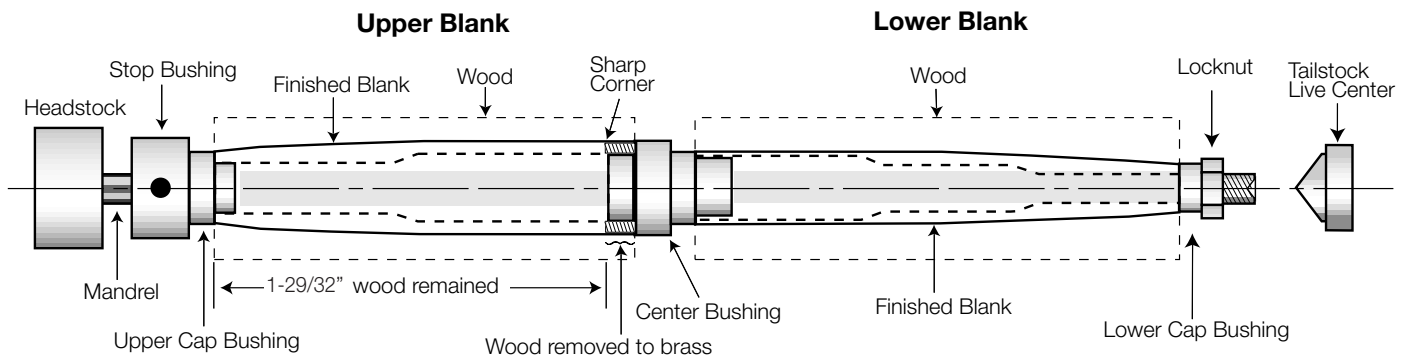
Preparing the Blanks

- Cut 3/4" to 5/8" square blanks to the length of the brass tubes (add 1/16" for squaring off).
- Drill center hole lengthwise through each blank. For the upper blank use the 2 step drill bit. For the lower blank use the 3 step drill bit.
- Spread glue over tubes. Insert into proper blanks with

a twisting motion to spread the glue evenly inside. Center each tube lengthwise in the blanks.

- When the glue dries, square the ends of the blanks. You may use a belt/disc sander to take the wood down flush to the brass tube at each end making sure the ends are perpendicular to the tubes.

Diagram B / Turning the Wood Blanks



Turning the Blanks

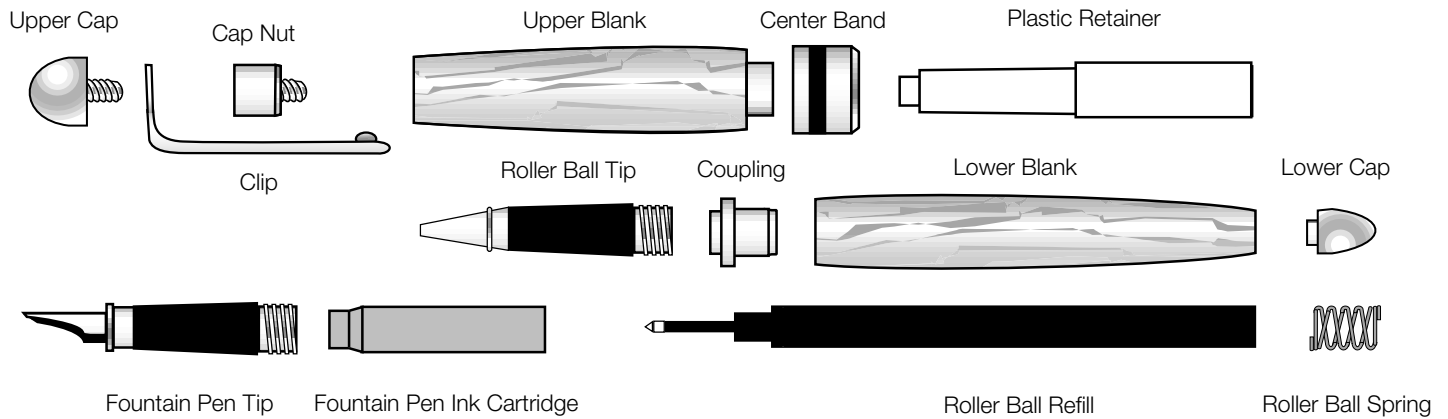
- Place the stop bushing in the mandrel.
- Place the upper cap bushing onto the mandrel, then slide on the upper blank. Next, insert center bushing with the larger diameter first, into upper blank. Slide the lower blank onto mandrel up over the center bushing. Insert the lower cap bushing and thread the lock nut hand tight. Bring up the tailstock snug with the live center (do not over tighten live center, it could damage the mandrel). Tighten both the stop bushing and the lock nut.
- Turn wood down, flush with the bushings using a lathe

chisel and sand paper. Taper the ends of the blanks (see diagram 'B' for profile) to conform with upper and lower brass end cap bushings.

Note: The lower cap needs to fit inside the upper blank. Be sure to check the fit before completing the sanding.

- **Removing wood for center band:** Place a mark 1-29/32" from the end of the upper blank. Use a parting tool to remove the excess wood down to the brass tube. Continue until brass is completely shined. Be careful, you must retain a sharp 90° corner at the end of the upper blank when you remove the excess wood. Sand both blanks then varnish and/or wax the wood.

Diagram C / Assembly



Note: These instructions can be used for both the Roller Ball Pen and Fountain Pen. Follow assembly procedures below to properly handle either style.

Assembly Tips

- Line up finished parts according to diagram C.
- To press parts together use a vice or a clamping

instrument with wooden jaws. Press slowly with caution keeping all parts aligned to avoid cracking the wood or scratching the gold plated parts.

Upper Blank

- Press cap nut (screw end first) flush into tapered end of blank.
- Place center band (square end first) over exposed brass and press. (Band must be flush with wood with no gaps).
- Insert upper cap thread into clip - screw together into cap nut.
- Slide the retainer inside the upper blank (narrow end first) use a 1/4" Philips head or a sharp screw driver to screw the retainer inside. Back off about half a turn. Final adjustment will follow.

Lower Blank

- Press end cap into tapered end of lower blank.
- Press coupling into opposite end of lower blank.

Roller Ball:

- Drop spring into blank and insert refill in blank up against the spring. Remove refill tip protective cover.
- Place tip assembly over point of refill and screw in snugly against coupling.

Fountain Pen:

- Place Fountain Pen ink cartridge into fountain pen tip with enough pressure to pierce the ink cartridge.
- Screw tip into coupling with cartridge attached.
- Place upper blank over the tip to complete pen. Pen should click with no play between ends.
- Adjust the retainer position with the tool in or out as necessary to achieve a good fit. The pen is ready to operate.

Bushings (#PKMONT-BU3)

