

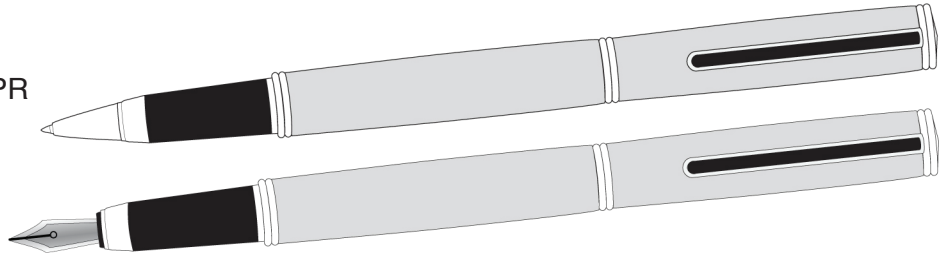
# 24kt TRADITIONAL Roller Ball & Fountain Pen Kits

## Kit Features:

- 24kt Gold Plating with epoxy coating
- Premium Roller Ball Pen Refill—#PK10RPR
- Fountain Pen Kit Refill—#PK10FPR
- Cap posts on end

## Required Accessories:

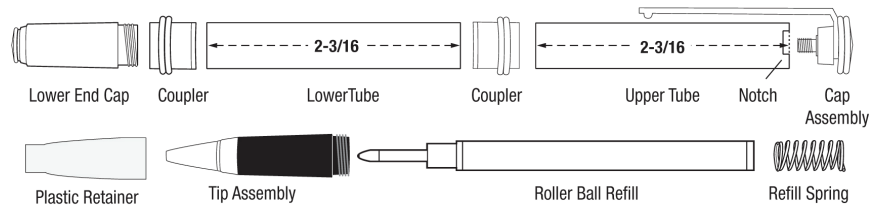
- 7mm pen mandrel
- #PK10-BUSH3—3piece Bushing Set
- #PK10-10—10mm Drill Bit
- #PKTRIMKIT—Universal Barrel Trimmer
- 2 part epoxy glue or instacure glue (cyanoacrylate)



## Preparing the Blanks:

- Use a 5/8" square stock. Cut blanks to the length of the tube, adding 1/16" for trim.
- Drill a centered hole lengthwise through each blank.
- Use epoxy or a gap filling cyanoacrylate (super glue), to glue the tube into the blank. Coat the outside of the tube with epoxy and insert the tube into the blank with a twisting motion to spread the glue until flush. Allow it to dry.
- With a barrel trimmer, square the ends of the blanks to the tubes.

DIAGRAM A-1 / ROLLER BALL PEN PARTS



## Turning the Blanks:

- Slide 7mm spacer bushings onto the mandrel, followed by the end bushing, wide end in first. Slide on the lower blank. Next, add the center bushing, narrow end first. Place the upper blank followed by the end bushing, smaller diameter in first. Add additional spacer bushings as necessary to reach the mandrel threads.
- Thread on the locknut hand tight. Bring the tailstock in snug to the mandrel, lock in place. Tighten the lock nut for turning. DO NOT over tighten the locknut, it could damage the mandrel.
- 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.

DIAGRAM A-2 / FOUNTAIN PEN PARTS

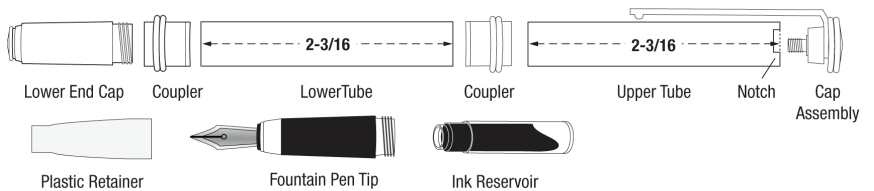
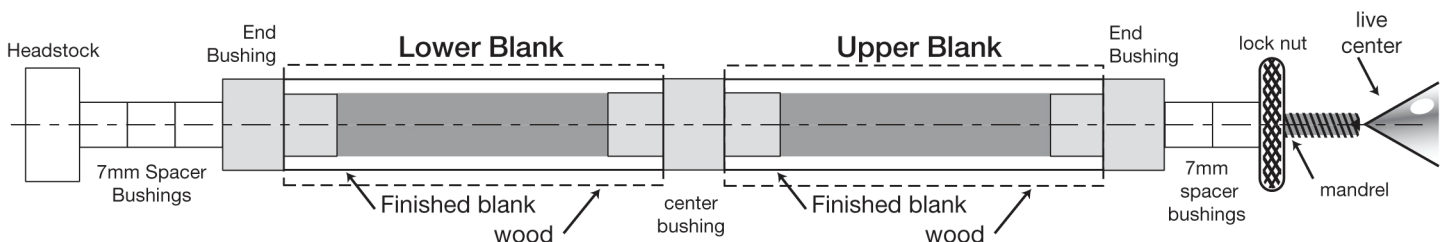


DIAGRAM B / Turning the Blanks



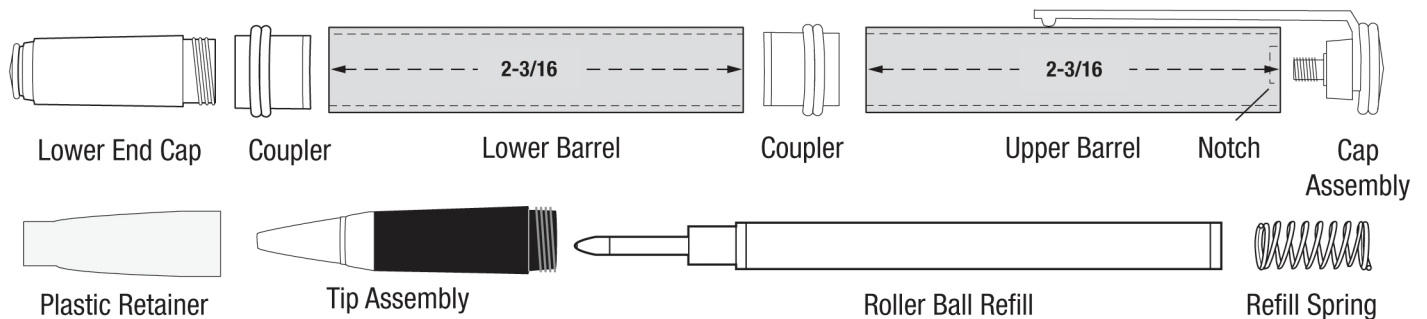
**GENERAL ASSEMBLY**

- NOTE: Line up the components according to the DIAGRAM C-1 (Roller Ball) or DIAGRAM C-2 (Fountain Pen). To avoid damage to the components when assembling the pen, use the PSI Pen Press (#PENPRESS3).
- Cut out a small notch in the wooden blank to match the notch in the brass sleeve. To remove wood over the notch, cut the blank using a sharp utility knife or exacto knife.

**ROLLER BALL PEN ASSEMBLY (DIAGRAM C-1)**

- Line up lower end cap and threaded coupling. Make sure that the longer shoulder of the coupling is inserted in the lower barrel.
- Press components together gently with your pen press.
- Insert spring, flat end first into end cap. Insert roller ball refill blunt end towards spring. Screw tip into coupling.
- Cut out a small notch in the upper wood barrel to match the notch on the upper brass sleeve. Use a cut mill file or a sharp utility knife.
- Line up cap/clip assembly with notched sleeve making sure that the clip is aligned with the notch in the wood.
- Slide the plastic retainer inside the top barrel closed end first.
- Adjust closing the pen for a tight fit by inserting a sharp screw driver and turning the plastic retainer to the left or to the right.

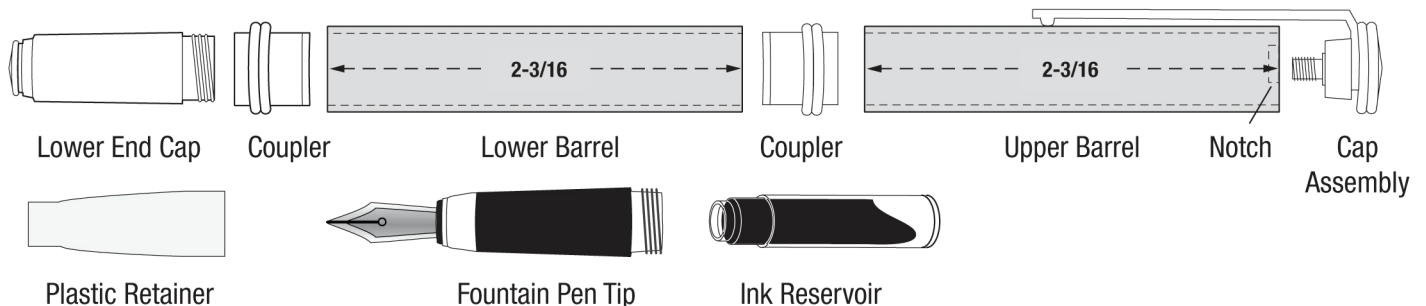
**DIAGRAM C-1 / ROLLER BALL PEN ASSEMBLY**



**FOUNTAIN PEN ASSEMBLY (DIAGRAM C-2)**

- Line up lower end cap and threaded coupling. Make sure that the longer shoulder of the coupling is inserted in the end cap.
- Press components together gently with your pen press.
- Screw fountain tip into coupling.
- Line up cap/clip unit with shorter sleeve making sure that the clip is aligned with the notch in the wood.
- Cut out a small notch in the upper wood barrel to match the notch on the upper brass sleeve. Use a sharp utility knife.
- Slide the plastic pen top retainer inside the top sleeve closed end first.
- Adjust closing the pen for a tight fit by inserting a sharp screw driver and turning the plastic retainer to the left or to the right.
- Insert ink cartridge into the tip assembly and squeeze the cartridge lightly to advance the ink to the nib.

**DIAGRAM C-2 / FOUNTAIN PEN ASSEMBLY**



**DIAGRAM D • BUSHINGS (#PK10-BUSH3)**

