

FACE ROLLER KIT

Kit Features

- Easy to Turn with Straight Tubes
- Minimal Parts—easy to assemble
- Available in multiple finishes
- Attaches two face rollers
- Overall Length: 5-13/16"

Required Accessories

- Face Roller Stones (chosen separately)
- 7mm Pen Mandrel
- Drill Bit: #PK-7MM for Wood, #PK-7MMSG for Plastic
- Bushing Set(2pc): #PKDRIP7BU
- Barrel Trimming: #PKTRIM7 or squaring jig on disc sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy
- Pen Blank Minimum Size: 5/8" x 5/8" x 3-1/16"L

Preparing the Blank:

- Prior to cutting and gluing, always verify tube length is correct (see parts diagram on back page)
- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 7mm hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank while twisting to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 7mm Barrel Trimmer or a pen blank squaring jig on a disc sander. Take the excess material down flush to the ends of the tubes. Use a barrel trimmer to clean the inside of the tube.

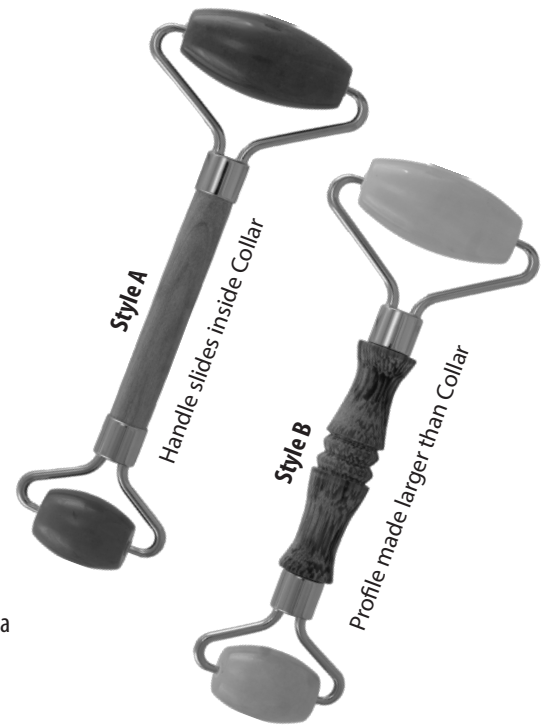
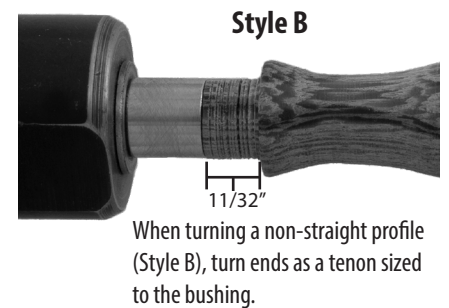
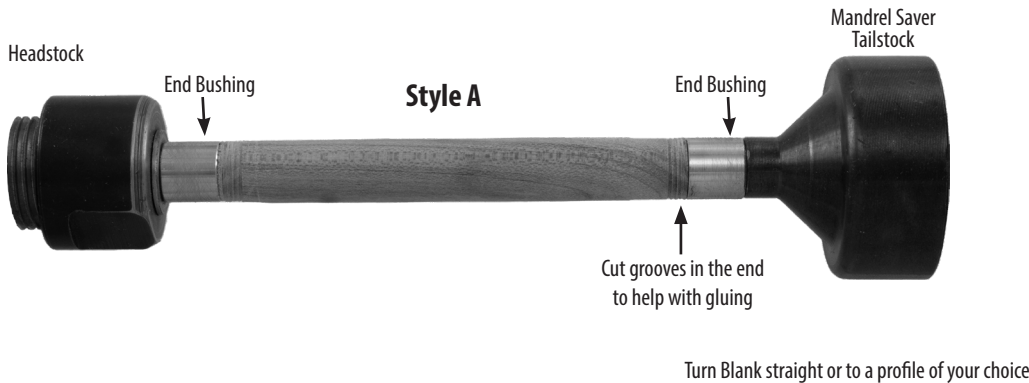


DIAGRAM B / TURNING THE BLANK



Turning the Blank:

- Mount the bushings and blanks according to diagram B.
- 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.
- To use Knurled Nut Setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- Thread on the Knurled Nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple.
- Lock Tailstock and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- Using sharp tools, turn the blank down. The ends of this blank will be glued into the holders so the last 11/32" of each end must be turned straight to the bushing diameter. In addition we recommend adding grooves to help glue adhesion.
- Turn the rest of the barrel straight or to a profile of your choice.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish manufacturer's instructions.

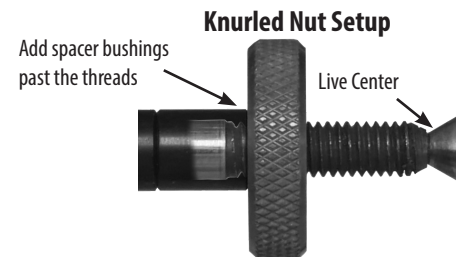


Diagram C / Bushing #PKDRIP7BU

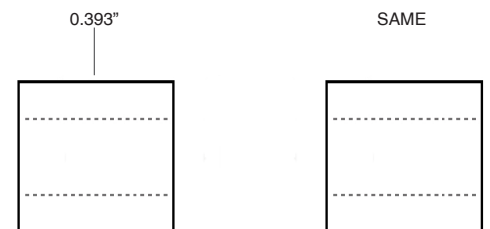
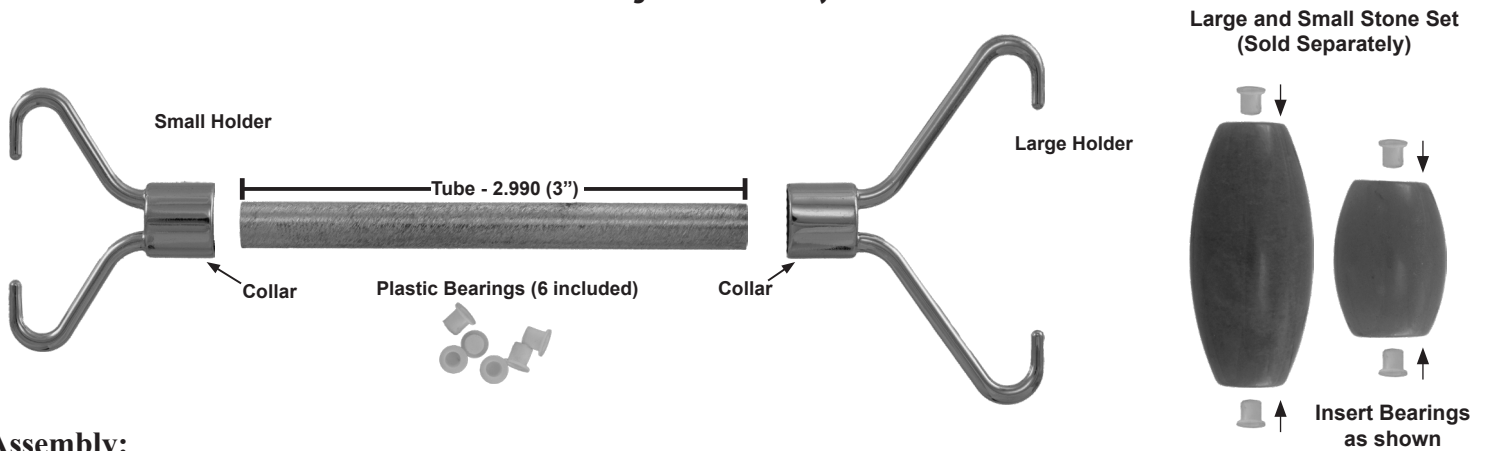


Diagram D / Parts Layout

**Assembly:**

- Insert Plastic Bearings into holes in the ends of the stones. These will help keep the rolling motion steady and smooth.
- Insert one tip of Large Holder into Bearing on one end of Large Stone. Pull other arm of Holder until it can slip over the other end of Stone and into the other Bearing.
- Repeat the same action with the Small Holder and Small Stone.
- Mix and apply a small amount of epoxy into the collar of the holders and the ends of the Barrel. Do not use an excessive amount or it may squeeze out and ruin the finish on the Barrel.
- Carefully insert the ends of the Barrel into the Collars of the Holders. Twist to align the Holders with each other and set aside to allow the glue to cure. To help keep the parts clamped in position while glue cures, you can use stretch wrap such as is available for moving and wrap it over the kit several times from end to end.