

# Oxford Rollerball Kit

## Kit Features:

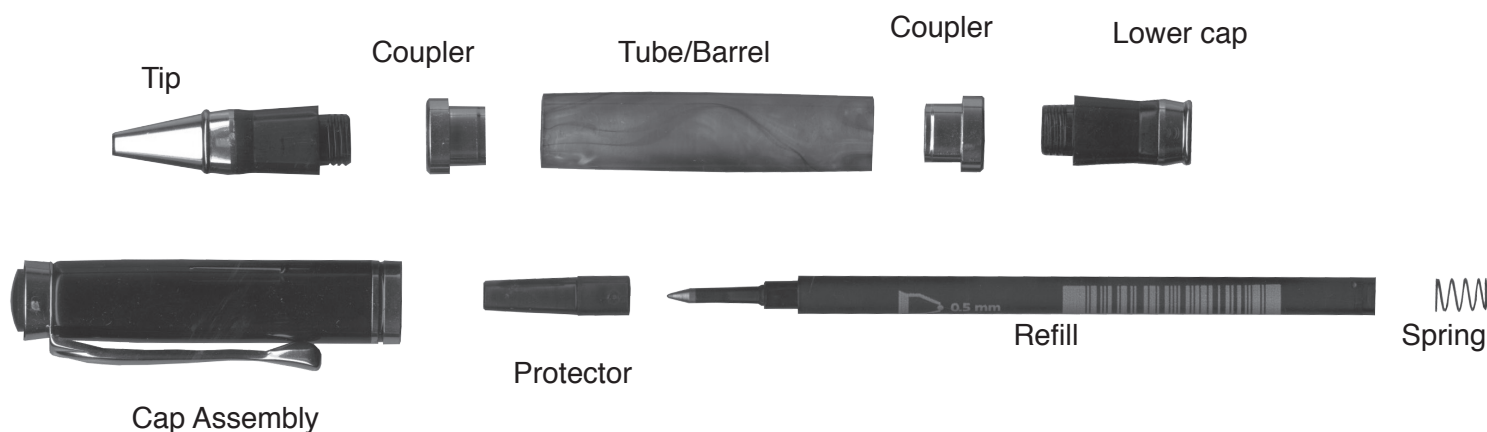
- Easy to turn with straight tube
- Minimum parts - easy to assemble
- Available in multiple finishes
- Includes Rollerball Refill
- Overall Length: 6" open, 5-1/2" closed

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s): 13/32" #PK-1332
- Bushing set(2 pc): #PKL750BU
- Barrel Trimming set: #PKTRIM10 (Wrap Tape\*)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 5/8" x 2-1/2"



## DIAGRAM A / PARTS LAYOUT



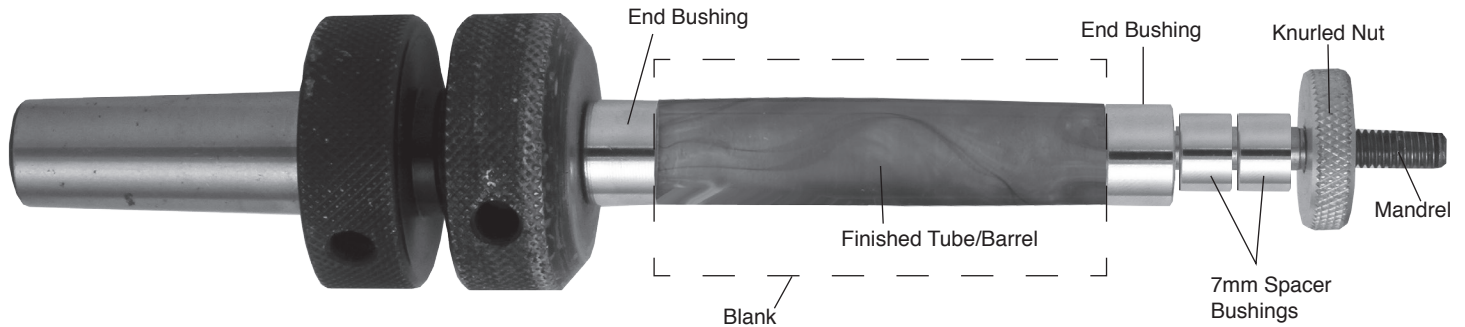
**\*Wrap masking tape around a 10mm barrel trimmer shaft for a snug fit in hole to trim**



## Preparing the Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill a 13/32" hole lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the end of the blank. (NOTE\*) Use a 10mm barrel trimmer wrap tape around shaft, or use the universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly). Use a barrel trimmer to clean the inside of the tube.

## DIAGRAM B / TURNING THE BLANKS

**Turning the Blank**

- Mount the bushings and blanks according to diagram B.
  - 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 in place.
  - Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
  - Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
  - Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
  - Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.
- Refer to polish instructions.

**Assembly**

- Layout parts according to diagram A
- Press a coupler into either end of the barrel.
- Press the other coupler into the opposite end of the barrel.
- Screw the lower cap into the barrel.
- Drop the spring into the lower cap.
- Remove the protector and insert the refill into the opening.
- Screw the tip over the refill.
- Affix the cap assembly over the tip (Closed) or over the cap (open) end to write.

**Diagram C / Bushings #PKL750BU**