

Patriot Fountain & Rollerball Kit

Kit Features:

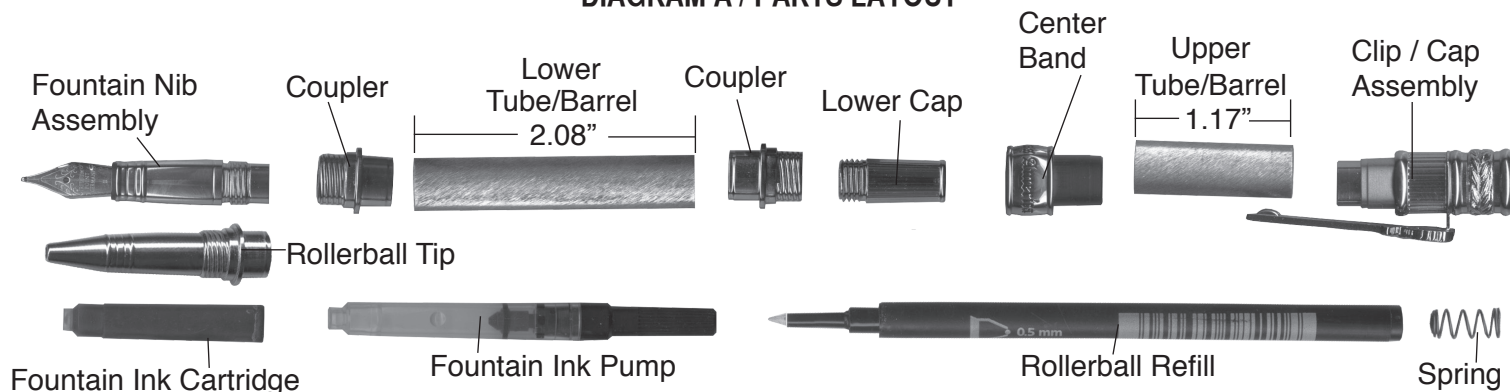
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Rollerball: Houser, Schmidt
- Same diameter tubes upper and lower (requires only one size drill bit)
- Overall Length: 5-1/2"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 10.5mm #PK105MM
- Bushing set(3 pc): #PKPPRBBU
- Barrel Trimming set: #PKMAJJRBTS - Use smaller sleeve in the set only.
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/2"

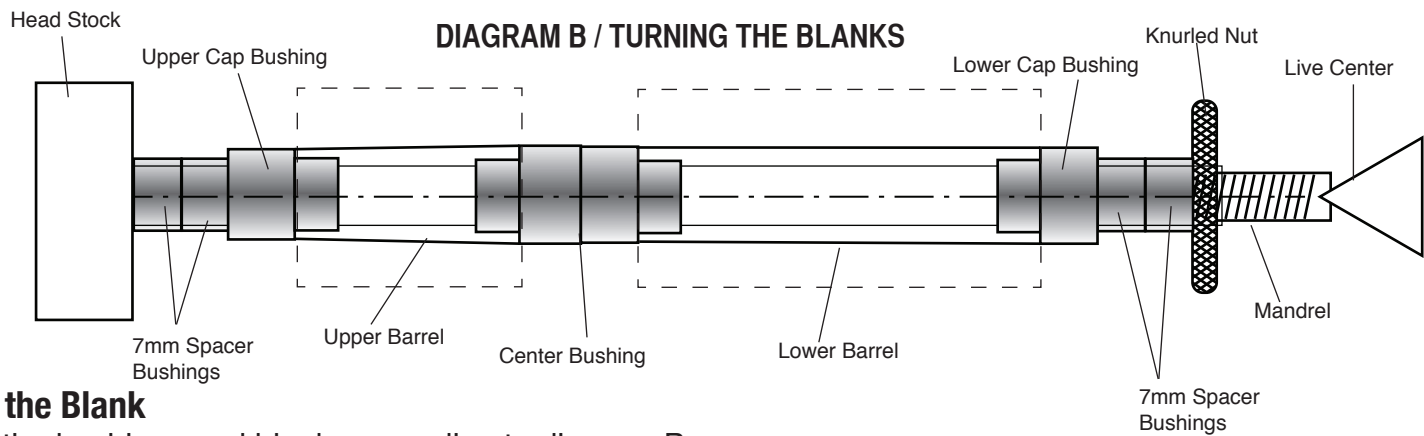


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 blanks to the length of the tubes and add 1/16" for squaring off.
- Drill 10.5 mm holes lengthwise through the blanks.
- Spread glue over the tubes, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 7mm barrel trimmer, or a 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 sharp knife to clean the inside of the tube.



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) Upper barrel is slightly wider than the lower barrel.
- 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 the clip / cap assembly into the smaller diameter of the upper barrel.(Shorter)
- Press the center band into the opposite end of the barrel.
- Press a coupler into either end of the longer barrel.
- Press the other coupler into the opposite end.
- Thread on the lower cap into either end of the barrel.

For Rollerball Pen

- Drop the spring into the opening at the opposite side of the coupler.
- Remove the protector and drop the refill, wide end into the opening.
- Thread the rollerball tip over the refill tip.
- Keep the cap threaded over when not in use.

For Fountain Pen

- Push the nipple end of the ink cartridge into the back of the nib assembly, squeeze for ink flow.
- Thread on this assembly into the coupler.

Using the Ink Pump

- Turn the knob on top counterclockwise. The piston will move to the down position.
- Insert the nipple of the pump into the opening at the back of the assembly. Push in to seat.
- Insert the nib into the open bottle and slowly spin the knob counterclockwise. The ink will fill the chamber.
- Replace the nib assembly onto the coupler.
- In case the ink is dry and will not flow into the nib, remove the nib assembly and turn the knob forward slowly to push the ink toward the nib.

Diagram C / Bushings #PKPPRBBU

