

Skullerball Rollerball & Fountain Pen Kit

Kit Features:

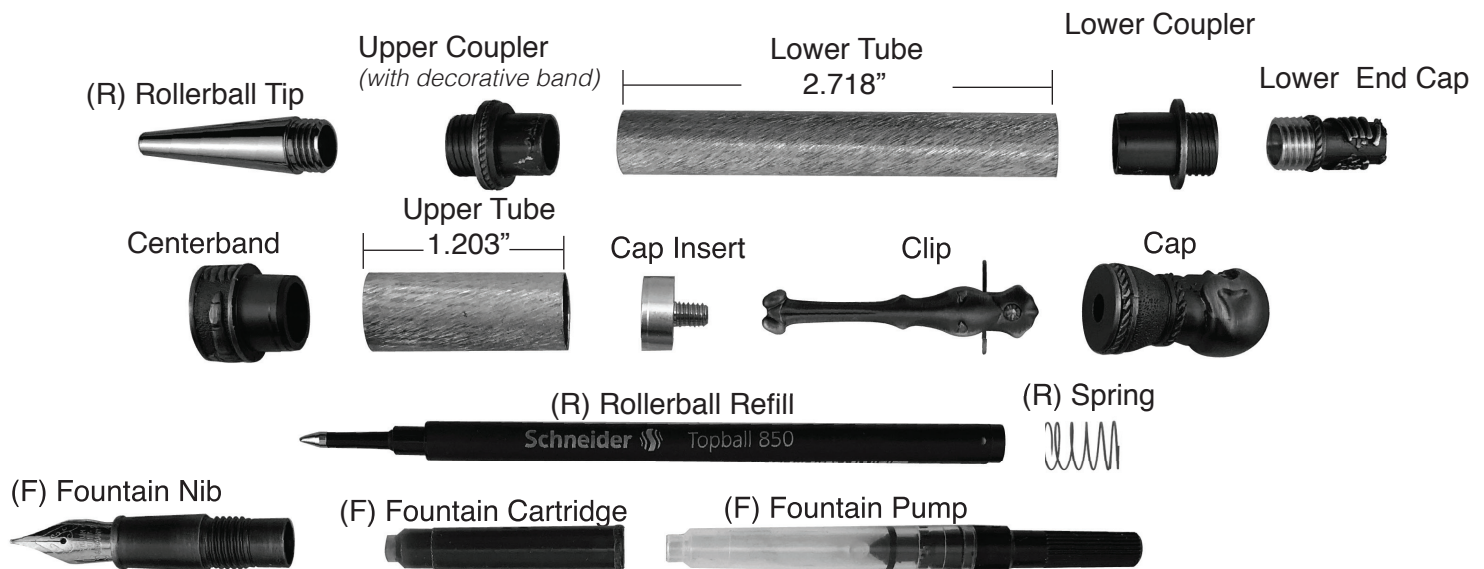
- Intricate and bold styling
- Postable, Threaded Cap
- Easy to turn with straight tubes
- Minimum parts--easy to assemble
- Available in multiple finishes
- Overall Length: 6-3/16" Long

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s): 12.5mm #PKPLI-DB; 10.5mm #PK105MM
- Bushing set(3 pc): #PKSKULRBU
- Barrel Trimming set: #PKMAJJRBTS Barrel Trimming Sleeves with #PKTRIM7 or disc sanding jig
- Live Tailstock or Mandrel Saver
- 2 Part Epoxy Glue or Thick CA (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" X 3/4" X 4-1/8" Long

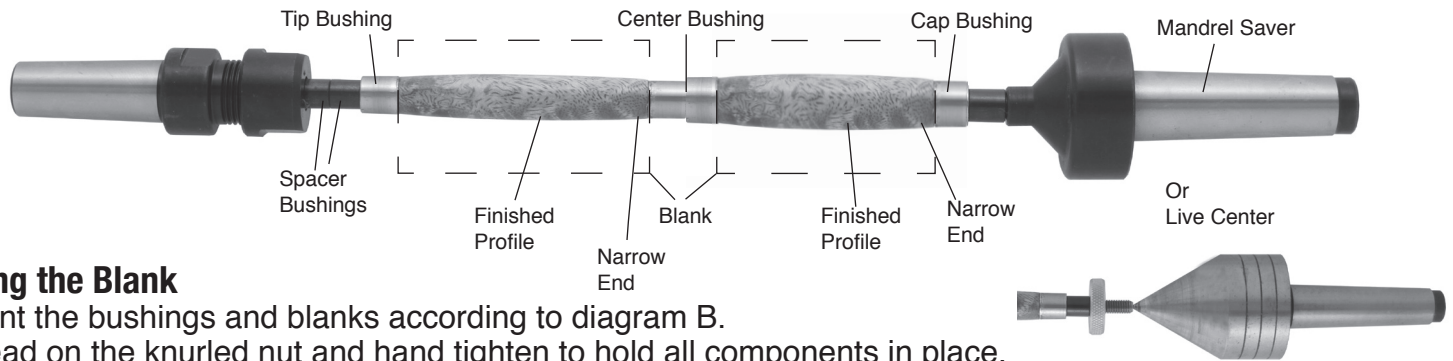


DIAGRAM A / PARTS LAYOUT



Preparing the Blanks:

- Cut blanks to the length of the tubes, allowing at least 1/16" for squaring off on each blank.
- Drill holes lengthwise through the blanks.
- Spread glue over the tubes, insert the tube into 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, making sure the trimmed ends are 90° to the tube. Use a 7mm barrel trimmer with #PKMAJJRBTS sleeves, or a pen blank squaring jig with 10mm & 12.5mm trimming sleeves on a disc sander. Take the excess material down flush with the ends of the brass tube. Do not trim past the end of the tube since this may interfere with fit of the assembly. Use a barrel trimmer or file 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 Tailstock.
- Hand tighten the quill adjustment to firm up the mandrel. Do not over-tighten, it could damage the mandrel shaft.
- When using the Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide Tailstock directly against bushings and tighten until blank and bushings are secure.
- 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 using your choice of polish. Allow sufficient time for the polish to cure -- refer to polish instructions.

Assembly

- Arrange parts according to Diagram A
- Place Clip over screw post on Cap Insert and thread Cap onto post, tighten so Clip aligns with skull face.
- Press Cap/Clip Assembly into Narrow end of Upper Barrel.
- Line up Centerband Design with Clip and Skull and press into open end of Upper Barrel.
- Press Upper Coupler into Narrower side of Lower Barrel
- Press Lower Coupler into open side of Lower Barrel
- Thread Lower End Cap into Lower Coupler
- For Rollerball pens: Remove refill cap, drop the Spring into the Upper Coupler, followed by the refill (flat side first). Thread the Tip over the refill into Upper Coupler.
- For Fountain pens: Thread Nib into Upper Coupler. You can choose the prefilled cartridge or refillable pump, either can be inserted into the back of the Nib Assembly. Note: Do not insert pre-filled ink until ready to begin use. Ink can dry up and clog nib if left unused in pen for long periods. To use pump, twist back end until plunger is all the way forward. Dip tip into inkwell, and twist back of pump to draw ink upwards. Once ink is installed, thread Nib into Upper Coupler and pen is ready to use.
- Keep cap over pen tip when not in use. Store fountain pens with nib side up.

Diagram C / Bushings #PKSKULLRBU