

Southwest Rollerball Pen Kit

Kit Features:

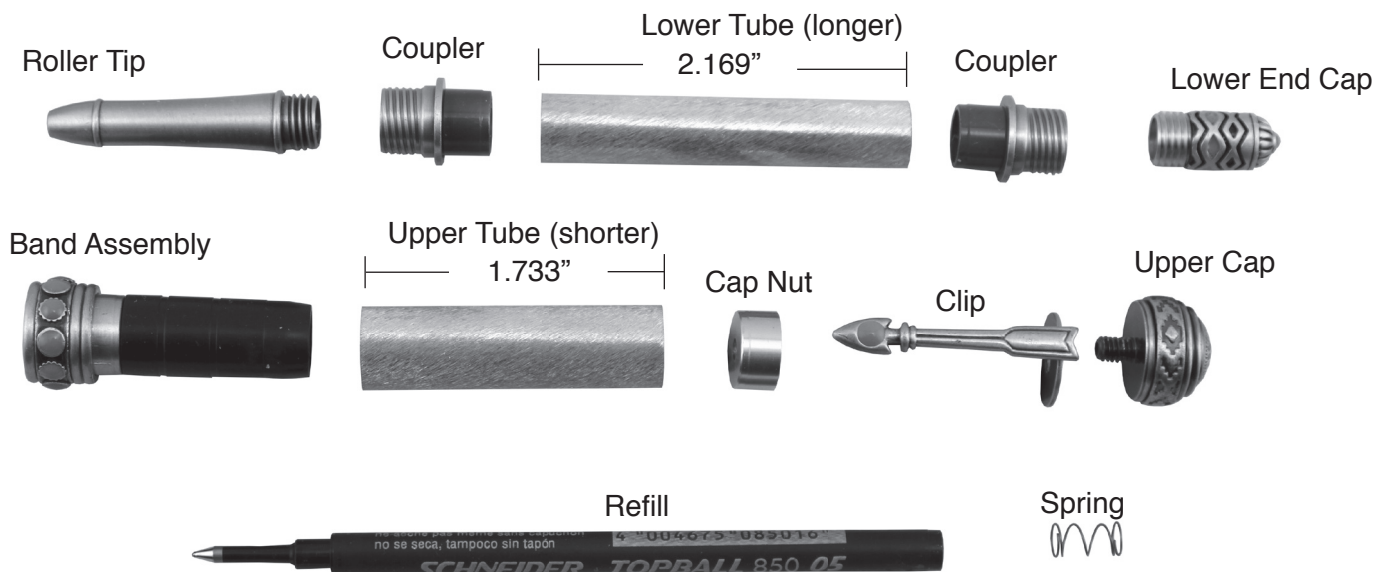
- Intricate and attractive southwest styling
- Postable, Threaded Cap
- Easy to Turn With Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-3/4" Long

Required Accessories:

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

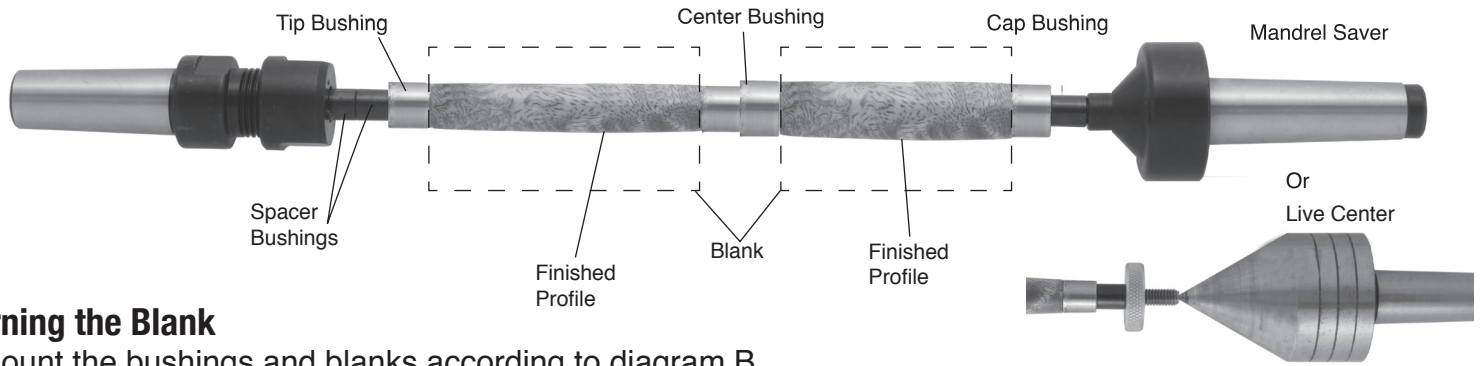


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut 2 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 tubes into 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 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 10.5MM & 12.5MM trimming sleeves on a disc sander. Take the excess material down flush to the ends of the tubes. 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 on the tailstock to steady the mandrel. Do not over-tighten, it could damage the mandrel shaft.
- When using 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 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
- Press cap nut into smaller end of upper barrel.
- Press band assembly into opposite end of upper barrel.
- Insert Upper Cap's screw post through Clip and thread into Cap Nut.
- Press couplers into both ends of the Lower Barrel.
- Place Spring into open end of Lower End Cap.
- Thread Lower End Cap onto either end of the lower barrel.
- Remove Refill tip cap and insert flat side first into open Coupler. Thread the Roller Tip onto the coupler and over the refill.
- Keep cap over pen tip when not in use.

Diagram C / Bushings #PKMAJJRBU