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Assembly Instruction for Fountain / Rollerball Pen Kit

Required Accessories:

- 7mm Pen Mandrel Kit
- 10mm Colt Drill Bit
- PBTK04 Pen Blank Trimming Tool Kit
- PCPFKIT Sierra Bushing Kit
- 2 Part Epoxy Glue or Insta-Cure (Cyanoacrylate)
- Pen Mandrel Support
- Sanding and Finishing Supplies

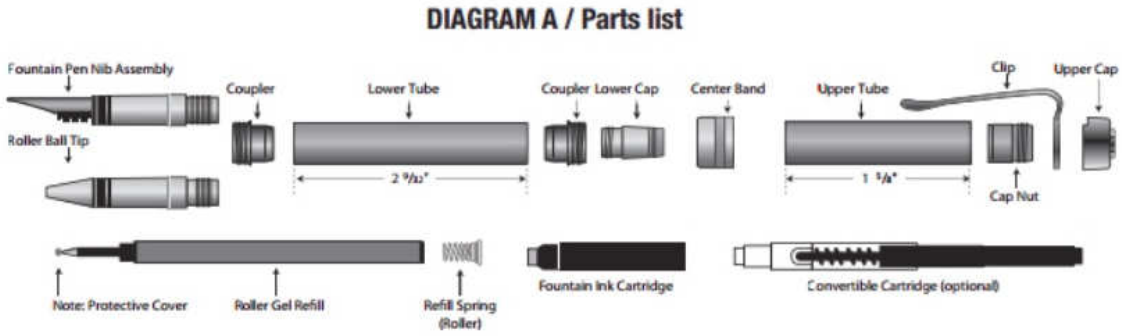


PCPFKIT Bushing Kit

Preparing the Blank

- Prepare a master blank of at least ¾" 5/8" square. Cut to the length of the brass tube (add 1/16" for trimming).
- Drill a 10mm" centre hole through the blank.
- Glue the tube in the blank. Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Centre the tube inside the blank.
- Sand or barrel trim to square the ends of the blank

Diagram A



Turning the Blanks (see Diagram B)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing; narrow end first. Note: The Upper Cap Bushing is the larger end. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut. Do not overtighten the knurled nut, it may damage the mandrel. For best results use the Pen Mandrel Support.
- Turn the blank down close to the bushings. Use a very fine parting tool remove 3mm from the upper blank so the centre band can be fitted.
- Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

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Diagram B

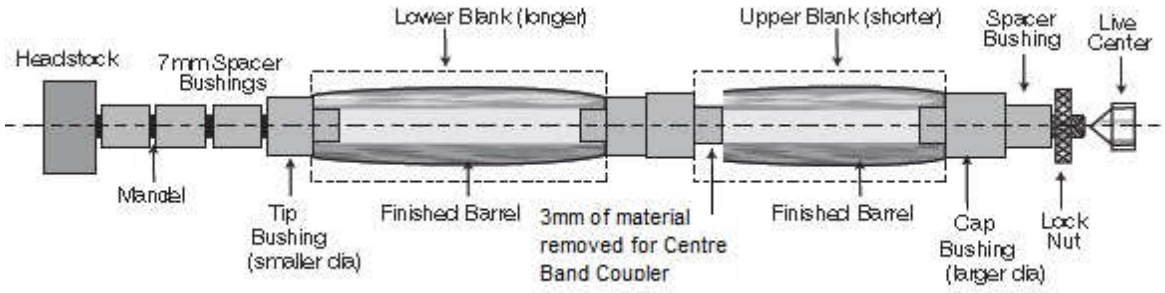
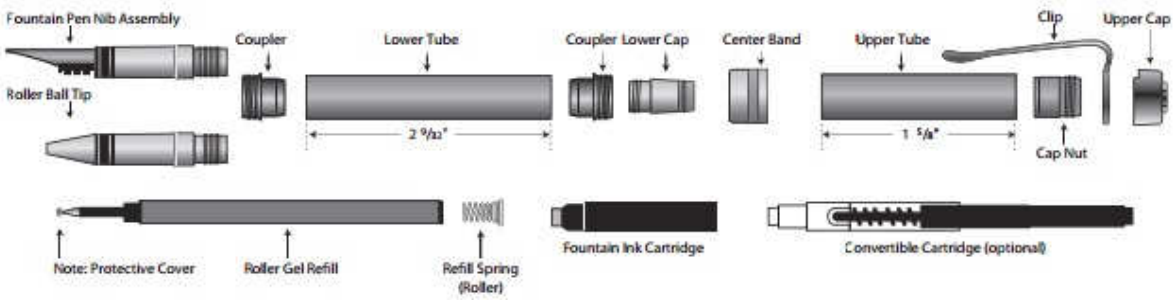


Diagram C



Assembly

- Line up finished parts according to Diagram C.
- To press parts in, use a pen vice or a vice with covered jaws.
- Press parts slowly to avoid scratching and damaging the gold plated parts.

Assembly of Body Barrel:

- Press a coupler into each end of the Lower barrel.
- Screw in the lower cap into either end of the barrel.
- Choose appropriate pen style for final assembly.

Assembly of Cap Barrel:

- Press the centre band, narrow diameter in first into the opening at either end of the barrel.
- Insert and press the cap nut, recessed end in first into the opposite end of the barrel.
- Stop at the shoulder.
- Place the clip over the threads, mount and screw in the upper cap, while aligning the clip rim into the slot in the cap. Tighten cap.

Fountain Pen Assembly:

- Push the ink cartridge (narrow end first) into the open end of the nib assembly to the end to cut an opening and allow the ink to flow. Screw this assembly into the barrel.

Tip: Stroke the pen nib from the small hole to the tip with a damp paper to help start the ink flow.

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