

Cutting and drilling

Measure the length of each brass tube and cut each blank 6mm longer than each tube. Once you have marked the centre of each blank secure the blanks in a clamp or vice. Then drill each blank using the correct size drill bits 27/64". To prevent blow outs stop the drill 3mm from the bottom of the blank then cut off the excess.

Gluing

Lightly sand the exterior of the brass tube with 220g sandpaper to prepare it for gluing. Use Yellow Cyanoacrylate glue to bond the tubes into the predrilled blanks.

Trimming & Truing

Square the ends of each blank with your barrell trimmer. Do not trim away the brass tubes as this will prevent improper fitting when assembling the pens.

Setup and turning

1. Mount the cap bushing then the short tube, centre bushing, long tube and end cap bushing onto your pen mandrel. Advance the live centre to the mandrel and apply light pressure for the live centre to spin, do not over tighten as this will cause the mandrel to bow and cause oval pens.
2. Turn both blanks to the desired shape leaving the blanks slightly larger for final sanding and finishing.

Assembly

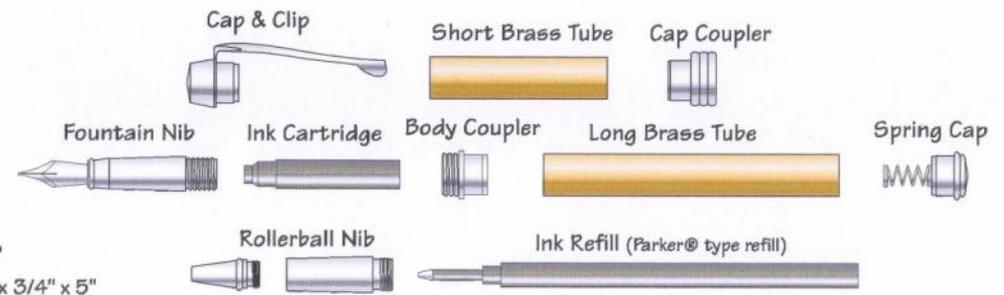
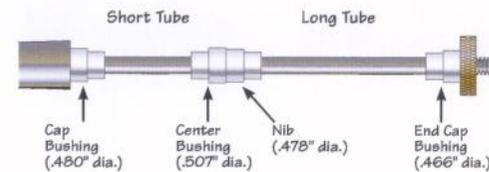
Before assembly lay out all the components to make sure there is no parts missing and you are able to see easily how the pen goes together.

1. Press the spring and cap into one end of the long brass tube.
2. Press the body coupler {large end first} into the opposite end of the long brass tube.
3. Press the clip and cap into one end of the short brass tube.
4. Press the cap coupler into the opposite end of the short brass tube.
5. Insert the refill into the long barrel then screw the writing tip into the body coupler.
6. Thread the short barrel onto the long barrel and the pen is complete.

EXECUTIVE ROLLERBALL & FOUNTAIN PENS

Parts required

19mm x 19mm x 125mm wood or acrylic blank
27/64" drill bit
Pen vice for drilling blanks
Penn assembly press
Mandrel
Bushes
Yellow Cyanoacrylate glue
Barrel Trimmer
Finish of your choice
Sandpaper to desired finish.



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