

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 12.5mm and 10.5mm. 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

Mount the clip cap bushing then the short tube, centre band bushing then the long tube and end cap bushing onto your mandrel. Advance the live centre and apply enough tension so the live centre spins do not over tighten as this may cause the mandrel to bow slightly and produce an oval pen. Turn both blanks to a desired shape leaving the blanks slightly larger to allow for final sanding. Apply your favourite finish.

Assembly

Before assembly place all the parts on the bench in order of assembly to make sure there is no parts missing and you are able to assemble in the correct order.

1. Slide the clip onto the cap then press them into the top of the short tube.
2. Press the centre band coupler, black end first into the other end of the short tube.
3. Press the end cap coupler into the smaller end of the long tube then screw the end cap onto the end cap coupler.
4. Slide the trim ring, aligned as shown over the unthreaded end of the nib coupler then press them into the larger end of the long tube.

Rollerball

Insert the spring into the ink refill into the long tube. Thread the rollerball nib into the nib coupler.

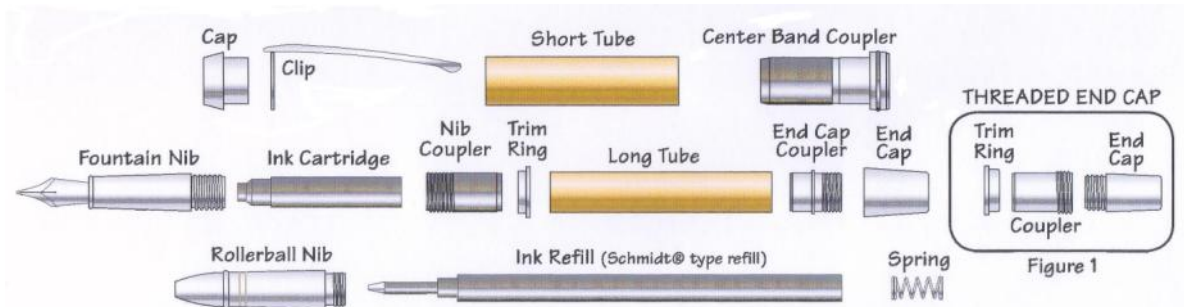
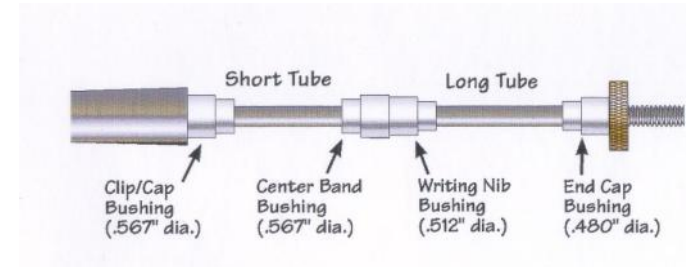
Fountain pen

Attach the ink cartridge to the back of the fountain pen nib then thread the fountain pen nib into the nib coupler.

JR. GENTLEMENS 2 ROLLERBALL & FOUNTAIN PEN

Parts required

19mm x 19mm x 125mm wood or acrylic blank
12.5mm & 10.5mm drill bits
Pen vice for drilling tubes
Pen assembly clamp
Mandrel
Bushes
Yellow Cyanoacrylate glue
Barrell Trimmer
Finish of your choice
Sandpaper to desired finish



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