

Required accessories

- 7mm pen mandrel
- 4-piece bushing set
- 37/64 Drill Bit
- 15/32 Drill Bit
- Pen blank
- Universal barrel trimmer
- 2-part epoxy glue or CA glue

Preparing the Blank

- Prepare a master blank of at least 3/4" square. Cut two sections to the length of each tube. (Add 1/16" for trimming)
- Mark the centre of each blank.
- Drill a centred hole lengthwise through each blank.
 - Upper blank (shorter tube)—drill a 37/64" hole through.
 - Lower blank (longer tube)—drill a 15/32" hole through.
- You may wish to paint the inside of your blank before gluing in the tubes
- Glue each tube in the correct blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Centre each tube lengthwise inside the blank.
- When the glue dries, square the ends of each blank using a 7mm barrel trimmer or sander

Turning the Blank

- Mount 7mm spacer bushings on the mandrel followed by the tip bushing (shorter diameter) wide end first.
- Slide the lower blank (long) on next. Follow with the centre bushing, narrow diameter first,
- Slide on the upper blank (short) and follow with the cap bushing, narrow end first. Add additional spacer bushings as necessary to overlap the mandrel. Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel).
- Turn the blanks down close to the bushings.
- Follow with abrasives/Yorkshire Grit until the tube diameters are flush with the bushings
- Finish with your choice of polish.

Assembly

NOTE: Line up the components according to the below pictures

- Slide the clip onto the cap, then press them into the top of the upper barrel (shorter tube).
- Press the centre band coupler, black end first, into the opposite end of the upper barrel.
- Place the end cap coupler into the end of the long tube
- Screw the coupler to the nib, then press them into another end of the long tube.

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

Fountain - Attach the ink cartridge to the back of the fountain nib, then thread the fountain nib into the nib coupler.

