

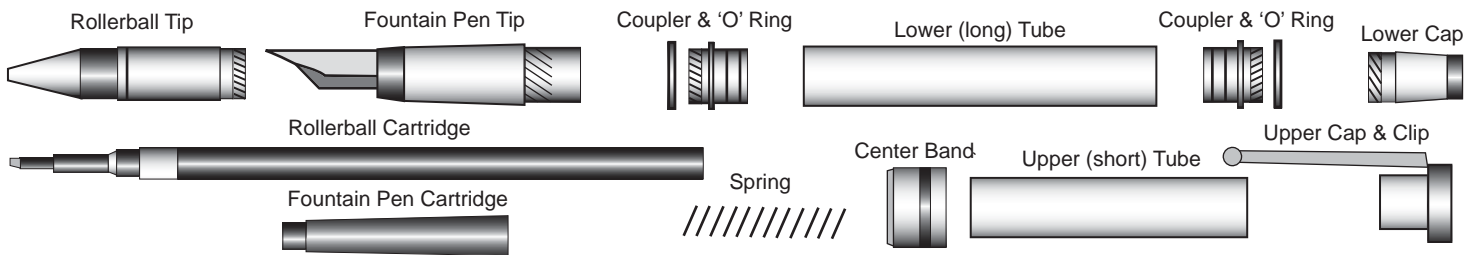
Kit Features

- Cap screws on either end of the pen with a quarter-turn of the barrel
- Fountain pen uses ink cartridges or available converter cartridge
- Rollerball pen comes with a black gel refill
- Two different kits but assembled the same way!

Required Accessories & Materials

- 7mm mandrel
- 3-pc. Classic bushing set (PARK10BU)
- 10mm drill bit (DB10MM or DB10MMCT)
- 10mm barrel trimmer or belt sander to square the ends of the blanks to the tubes
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

Diagram A - Parts List



BLANK PREPARATION

The tubes in a Classic pen kit are of different lengths. The upper tube—the cap end—is 1-13/16". The lower tube, which holds the pen tip and cartridge, is 2-9/32". Cut your blanks approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. If using wood blanks, mark the blanks so it is easier to keep the grain running in the same direction when you place them on the mandrel for turning. Use a medium drill speed to drill the blanks. Raise the bit from the wood every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blanks, sand the exterior of the brass tube to roughen its surface and use a CA glue to insert the tube inside the blank. Sand or barrel trim to square the ends of the blanks.

TURNING THE PEN

Set up the mandrel as shown in Diagram C. In setting up your bushings, you will use the smallest of the three bushings (bushing 1) at the tip of the pen. The lower barrel goes on the mandrel followed next by the large combined bushing (bushing 2). Orient this middle bushing so the smaller end is toward the pen tip. Slide on the upper barrel, and then the last of the three bushings (bushing 3) will go at the top end of the pen. Keep in mind which pen barrel you are turning as the top and bottom. Cut a tenon on the upper (short) barrel by making a mark 1/8" from the end and use your parting tool to cut down the tenon to the brass. Be sure the edge of the tenon is a sharp 90-degree angle. **Sand** with abrasives and finish with your choice of polish.

ASSEMBLY

(Line up finished parts according to Diagram A)

To avoid damage to components when assembling, use a vise with covered jaws or one of WoodTurningz' pen presses.

1. Fit the 'O' ring into the groove on the thread of each coupler.
2. Press one coupler onto each end of the lower (long) tube.
3. Screw in the lower cap.
4. Assemble the upper cap and clip, if necessary, by inserting the threaded stud through the hole in the clip and pressing the assembly into the flat end of the upper (short) tube.
5. Press the center band over the bare brass tube, square end first. Carefully use a drop of glue if needed.
6. **Rollerball:** Drop the spring into the lower (long) tube and insert the ink refill, flat end first. If the refill tip is covered, remove the cover. Screw the rollerball tip over the refill into the tube.
7. **Fountain Pen:** Push the ink cartridge (or optional converter cartridge) firmly into the threaded end of the tip assembly. Screw the assembly into the lower (long) barrel.

Diagram B - Bushings

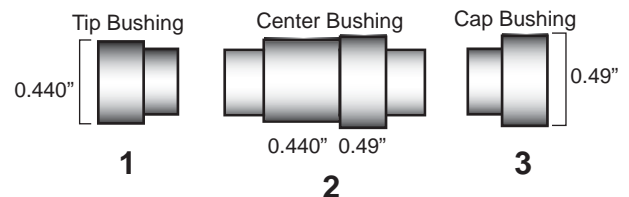


Diagram C - Turning the Pen

