

# Victorian Rollerball/Fountain Pen Kit

## Kit Features:

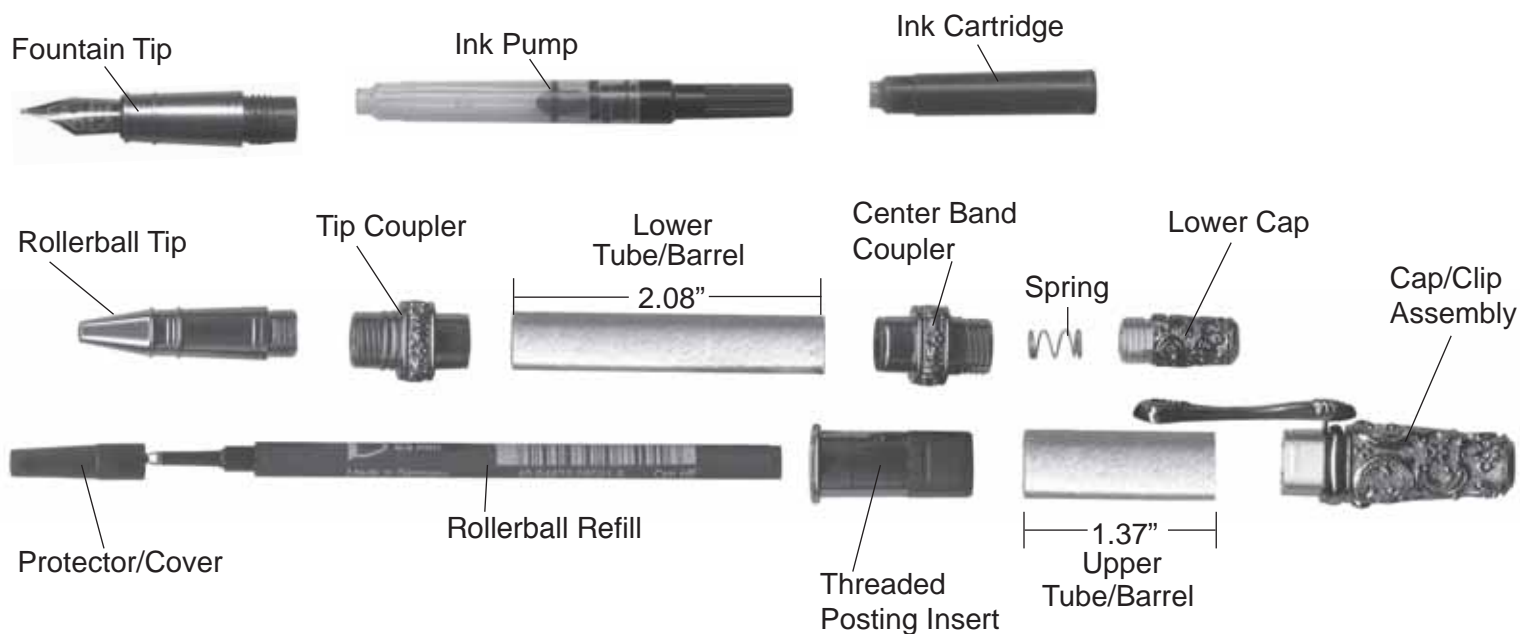
- Easy to turn with straight tubes
- Minimum parts - easy to assemble
- Available in multiple finishes
- Overall Length: 6-1/8"
- Threaded posting on both ends

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit(s): 10.5mm #PK105MM (for bottom)  
12.5MM #PKPLIDB (for top)
- Bushing set (3 pc): #PKVICRBU
- Barrel Trimming set: #PKTRIM7  
(use with #PKMAJJRBTs sleeve set)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" x 3-1/2" Long

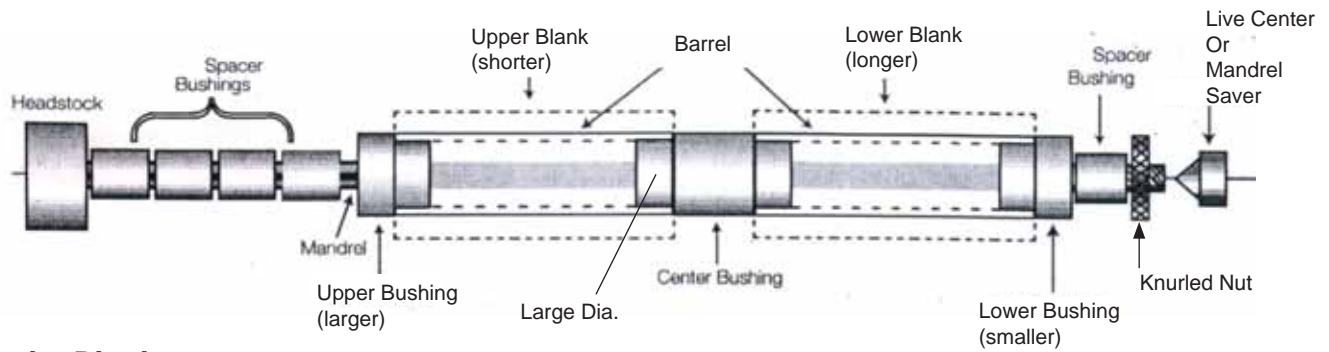


## DIAGRAM A / PARTS LAYOUT



## Preparing the Blank:

- Prepare a master blank of at least 3/4" square. Cut two sections to length of each tube. (Add 1/16" for trimming)  
Mark the center of each blank.
- Upper blank (shorter tube) - drill a 12.5mm (.492") hole through.
- Lower blank (longer tube) - drill a 10.5mm hole through.
- Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center each tube lengthwise inside the blank.
- When glue dries, square the ends of each blank using a 7mm barrel trimmer with adapter sleeves (#PKMAJJRBTs), mount the proper sleeve (larger diameter for the short tube, smaller diameter for the longer tube) over the shank with the brass tube.



## Turning the Blank

- Mount the bushings and blanks according to diagram B.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.)
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.  
Refer to polish instructions.

## Assembly

- Layout parts according to diagram A
- Press the threaded posting insert into the upper barrel (shorter tube).
- Press the end cap clip assembly into the opposite end of the upper barrel.
- Press the tip and center band couplers into either end of the lower barrel.
- Thread the lower cap into the top of the lower barrel.

## Rollerball

- Drop the refill spring into the lower barrel.
- Discard rollerball refill cover. Insert rollerball refill, flat end first, into the threaded coupler over the spring.
- Thread the rollerball tip over the refill into the threaded tip band coupler.

## Fountain

- Press the ink cartridge or ink pump, narrow end first into the back of the fountain nib. Push in to break the seal, then press lightly on the nib to advance the ink forward.
- Thread the fountain nib assembly over the threaded coupler.

Diagram C / Bushings #PKVICRBU

