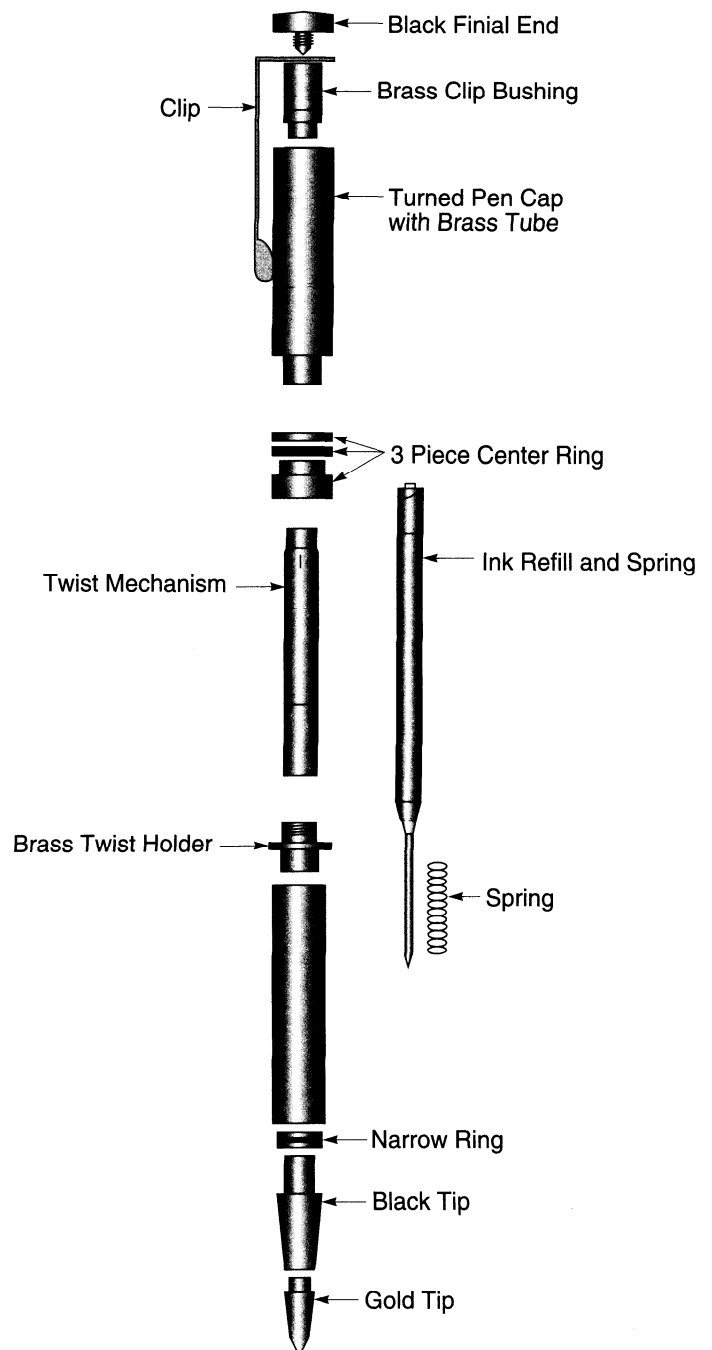


PEN ASSEMBLY - PARKER STYLE

*Moderate force is needed to press fit parts. A drill press or vise may be used to completely press parts together. Use wooden or padded vise jaws. Protect pen parts from scratches with cloth or thin pad. Pen parts are delicate! **Go slowly and carefully.**

- Step 1: Press fit the GOLD TIP into the BLACK TIP.
- Step 2: Slide the NARROW RING over the stem of the BLACK TIP.
- Step 3: Press fit the PEN BODY on to the BLACK TIP, flush to the NARROW RING.
- Step 4: Press fit the unthreaded stem of the BRASS TWIST HOLDER into the PEN BODY.
- Step 5: Slide the SPRING over the narrow end of the INK REFILL and insert them thru the BRASS TWIST HOLDER and into the PEN BODY.
- Step 6: Screw the TWIST MECHANISM onto the threaded end of the BRASS TWIST HOLDER.
- Step 7: Assemble the 3-PIECE CENTER RING as shown in diagram. Slide over the exposed brass tube flush to the should of the PEN CAP. If CENTER RING is loose, carefully glue in place. Use CA (cyanoacrylic) glue in small amounts.
- Step 8: Test the fit. Slide the partially assembled PEN CAP over the TWIST MECHANISM. The CENTER RING on the PEN CAP should slide over the PEN BODY without rubbing or binding when the PEN CAP is rotated. Carefully file brass or PEN BODY as needed for proper clearance.
- Step 9: Insert the threads of the BLACK FINIAL END through the CLIP'S ring and thread onto the BRASS CLIP BUSHING.
- Step 10: With the partially assembled PEN CAP still in place over the TWIST MECHANISM, align the grain patterns as you prefer. Take the BLACK FINIAL END and CLIP assemble (from step 9) and loosely place into open end of brass tube. Taking entire pen, now press fit assembly into PEN CAP until BRASS CLIP BUSHING is flush. This presses the stud end of the BRASS CLIP BUSHING into the TWIST MECHANISM which properly seats it in the PEN CAP.



PEN OPERATION: Turn pen cap clockwise and counter clockwise while holding pen body. Ink point will rotate out and lock for use. Rotates in for storage. To remove the cap for ink refill replacement, turn the cap counter clockwise past the point where the ink point rotates out. Continue to unscrew the top of the pen.

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Flat Top Style Pen

CUT PEN BLANKS - blanks approximately 5/8" x 5/8".

1. Cut one pen blank exact length of brass tube 5/8" x 5/8" x 2" for Pen Body.
2. Cut second pen blank short 5/8" x 5/8" x 1-25/32" (to 1-13/16"). **Note - variation in lengths can effect pen operation.**

It is important that pen blanks be cut square to the brass tubes. SQUARE PEN BLANKS BEFORE DRILLING.

DRILL PEN BLANKS

1. Using a drill press and a letter "O" drill bit, drill a hole lengthwise through the center of each pen blank.
2. Glue pen blanks to brass tubes. Rough surface of brass tubes with fine grit sandpaper or steel wool. Apply CA (cyanoacrylic) glue to the inside of the blank at one end. Once the glue is applied place the blank on end, glue end up, and quickly push tube into blank until it is flush with the end of the blank at the opposite end. The shorter blank will have a small portion of tube remaining outside of the blank, this is correct. Allow glue to dry and remove excess glue from edges and inside of tube. ***Note CA glue dries very quickly and these steps must be done as quickly as possible.**

***Remember pen blanks must be square** - use belt sander to sand flush with brass tubes. Use a file against the shoulder of the pen blank where the brass tube is exposed and square the shoulder while turning slowly.

MOUNT BLANKS ON MANDREL

1. Mount prepared pen blanks on mandrel using correct bushings for pen style, and proper placement of bushings as shown in diagram:
2. Slide large OD Bushing flush to the Fixed Collar.
3. Slide Pen Cap Blank, with exposed tube toward mandrel's threaded end, onto the Large OD Bushing.
4. Slide 3-Step Bushing, largest diameter first, over the exposed brass tube and flush to Pen Cap Blank.
5. Slide Pen Body Blank onto the 3-Step Bushing.
6. Slide Small OD Bushing into Pen Body Blank.
7. Finger tighten nut, snug. Do not over tighten.
8. Turn pen blanks down almost even with diameter of bushings, and then sand flush to bushings. The diameter of the pen blanks should now match the bushing diameters. Final sand with finer grits of sandpaper and finish.

