

Round Top Style Pen

Instructions

You have 2 brass tubes, one long for BODY, one short for CAP

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

1. Cut one blank exact length of brass tube 5/8" x 5/8" x 2-3/8" for pen body.
2. Cut second blank short 5/8" x 5/8" x 1-25/32" (1/4" short of brass tube length)

It is important that pen blanks be cut square to the brass tubes. **SQUARE 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 blank.
2. Glue 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 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, blanks must be square** - if not square, use belt sander to sand flush with brass tubes. Use a file against the shoulder of the blank where the brass tube is exposed and square the shoulder while turning slowly.

MOUNT BLANKS ON MANDREL

1. Mount prepared blanks on mandrel using correct bushings for pen style, and proper placement of bushings as shown in diagram.
2. Slide LARGER bushing flush to the FIXED COLLAR.
3. Slide CAP blank, with exposed tube toward mandrel's threaded end, onto the bushing.
4. Slide 3-STEP BUSHING, largest diameter first over the exposed brass tube and flush to blank.
5. Slide BODY blank onto the 3-STEP BUSHING.
6. Slide SMALLER bushing into BODY blank.
7. Finger tighten nut, snug. Do not over tighten.
8. MONT BLANC Style has an elliptical taper on both CAP and BODY. Create a mild elliptical taper as you turn blanks down almost even with diameter of bushings and then sand flush to bushings. The diameter of the blanks should now match the bushing diameters. Final sand with finer grits of sandpaper and finish. You are ready for assembly.

Figure 1

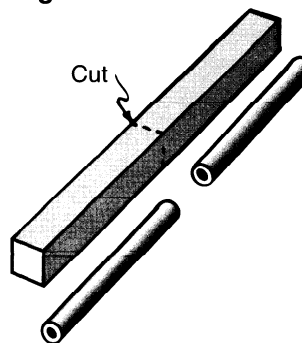


Figure 2

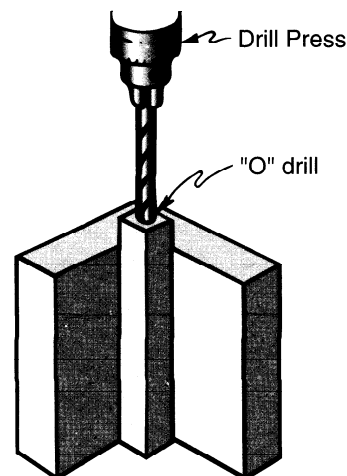
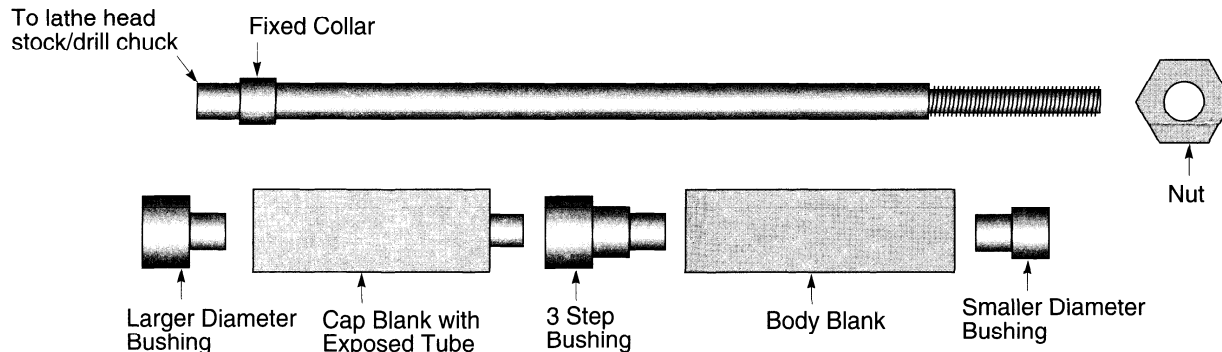


Figure 3



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PEN ASSEMBLY MONT BLANC 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.**

LOWER PEN BODY ASSEMBLY

- Step 1: Press fit the TIP into the pen BODY.
- Step 2: Press fit the unthreaded stem of the TWIST HOLDER into the other end of the pen BODY.
- Step 3: Slide the SPRING over the narrow end of the INK REFILL and insert them thru the TWIST HOLDER and into the pen BODY.
- Step 4: Screw TWIST MECHANISM onto TWIST HOLDER.

UPPER PEN CAP ASSEMBLY

- Step 5: Insert stem of FINIAL CAP through the FINIAL RING then through the CLIP'S ring and press into the pen CAP.
- Step 6: Slide the CENTER RING over the exposed brass tube flush to the shoulder of the pen CAP. If CENTER RING is loose, carefully glue in place. Use CA (cyanoacrylic) glue in small amounts.
- Step 7: Slide CAP over TWIST MECHANISM on pen BODY.

YOUR PEN IS NOW FINISHED.

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. Slide off CAP for INK REFILL replacement. UNSCREW TWIST MECHANISM and slide out the old INK REFILL.

