

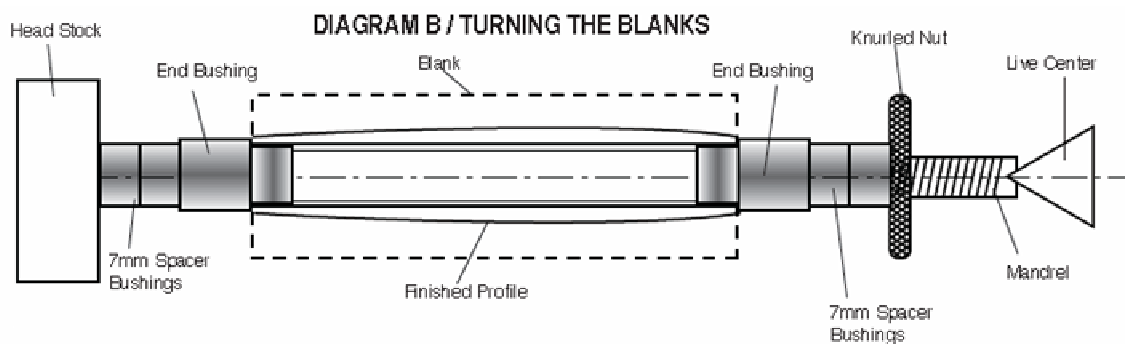
## **Lester Rollberball Pen Kits Assembly Instructions**

### **Required Accessories**

- 7mm Pen Mandrel
- Drill Bit: 3/8" RZ-DB3/8
- 2 pc. bushings set RZ-RP171#-BU
- Barrel Trimming set (3/8 shaft RZ-PM013)
- Glue (Thick CA or Epoxy)
- Pen Blank: Minimum Size - 3/4" x 3-1/2" Long

### **Preparing the Blank:**

- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use a 3/8" barrel trimmer or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the assembly).

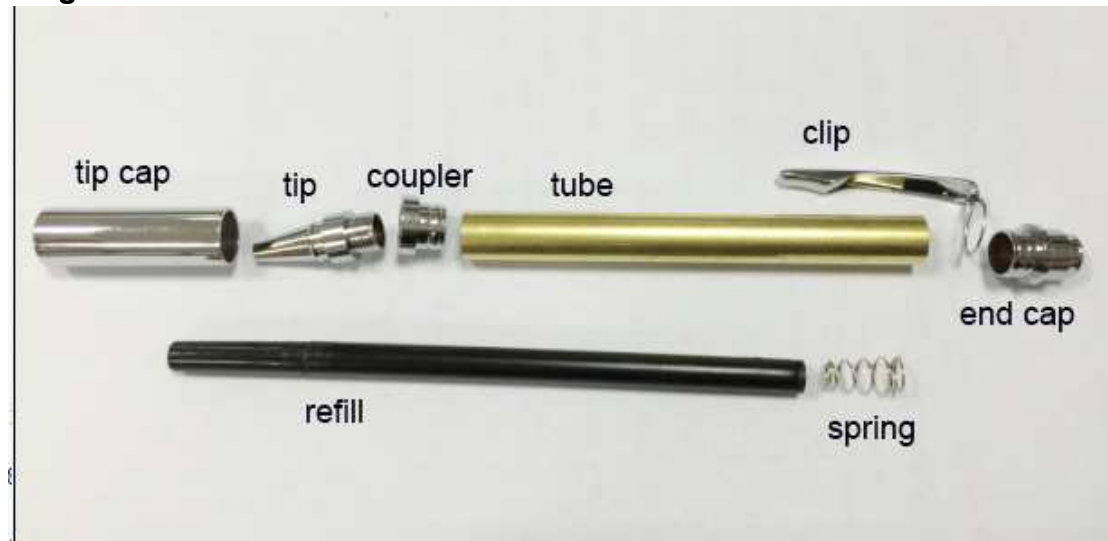


### **Turning the Blank**

- 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.

### Diagram A



### Assembly

- Layout parts according to diagram A
- Press the coupler into either end of the barrel.
- Put the end cap through the clip, press into the opposite end of the barrel.
- Drop the spring into the opening in the coupler.
- Pull the refill cover off the refill, slide the refill into the barrel pushing the spring to the end.
- Screw the tip over the refill into the coupler.
- Place the tip cap over the tip
- When not in use, just keep the tip cap on.