

Jr. Gentleman I End Capped Pen Kits Assembly Instructions

Required Accessories:

- Big Grabber pen mandrel system
- 10.6mm drill bit RZ-DB106
- 12.3mm drill bit RZ-DB123
- Bushing set RZ-RP380#-BU
- Barrel trimmer sleeves
- Glue (Thick CA or Epoxy)
- Project requires 2 pen blanks

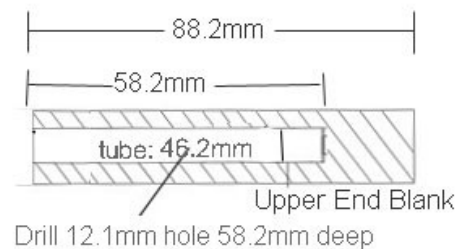
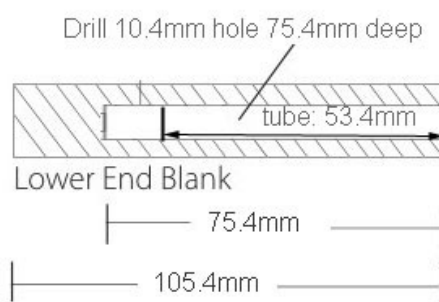


Preparing the Blank:

Cut 2 blank sections

88.2mm for upper end blank.

105.4mm for lower end blank



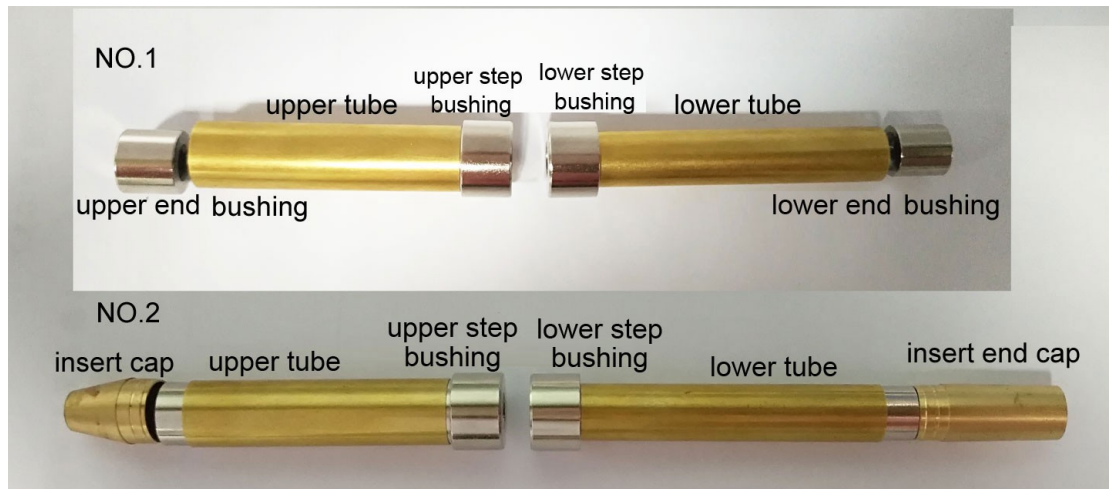
Lower end blank:

- Mark the center of the blank on both ends.
- Drill a 10.6mm hole, 75.4mm deep.
- Press the end cap insert to the tube first and the glue the tube into the hole, let dry.
- Use a sander (the hole is too short for a trimmer shaft) sand the end square.

Upper end blank:

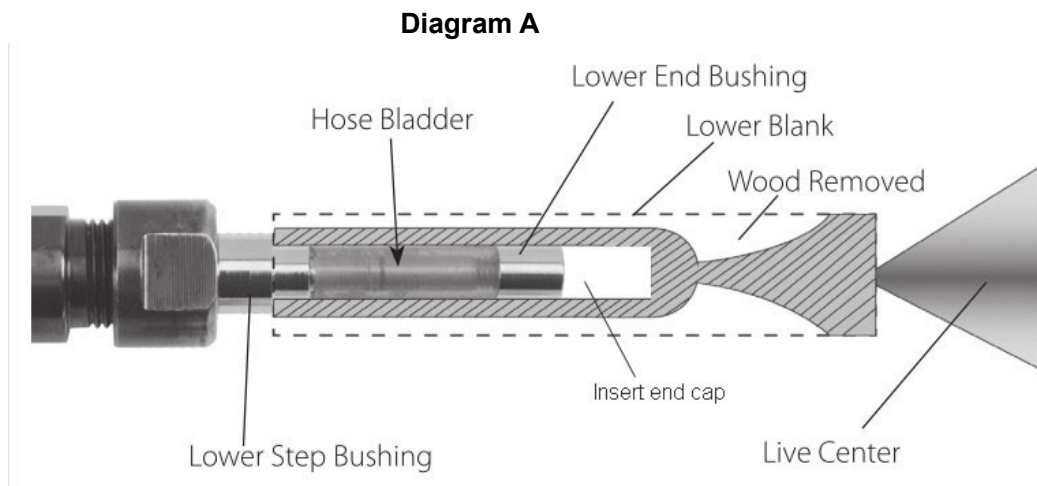
- Mark the center of the blank on both ends.
- Drill a 12.3mm hole, 58.2mm deep.
- Press the cap insert to the tube first and the glue the tube into the hole, let dry.

- Use a sander (the hole is too short for a trimmer shaft) sand the end square.



Turning the Blanks:

Mount the bushings and blanks on the mandrel according to the Diagram above



Turning the Lower Barrel see Diagram A

- Insert the lower step bushing, the bladder and screw the 10.4mm end bushing over the mandrel shaft.
- Slide the blank over, to bottom. Expand bladder with lock nuts.
- Attach the mandrel into the taper of the lathe. Bring the tailstock over so the live center support the blank. Lock set up in place, ready for turning.
- Turn the blank down to the bushing at the front. Measure 90mm as the end of the barrel and shape the end round as shown. Part off then sand off the end and finish the barrel manually

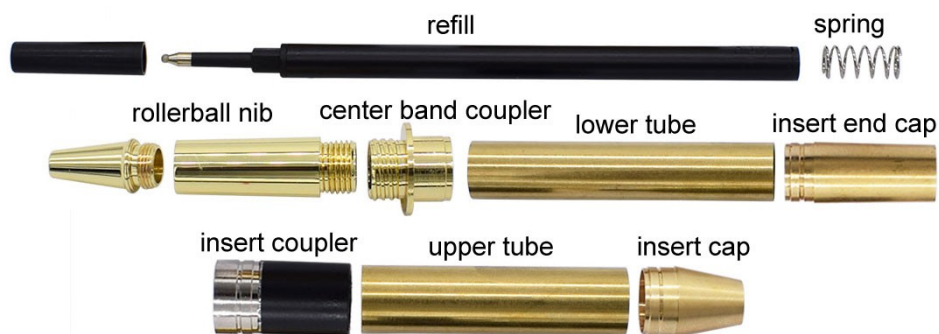
Turning the Upper Barrel (Same the Diagram A)

- Insert the upper step bushing, the bladder and screw the 12.1mm end bushing over the mandrel shaft.
- Slide the blank over, to bottom. Expand bladder with lock nuts.
- Attach the mandrel into the taper of the lathe. Bring the tailstock over so the live center support the blank. Lock set up in place, ready for turning.
- Turn the blank down to the bushing at the front. Measure 64mm as the end of the barrel and shape the end round as shown. Part off then sand off the end and finish the barrel manually

Assembly

- Arrange parts according to Diagram as below.

Rollerball pen



Fountain pen



Upper Tube (short) Assembly .

- Press the insert coupler into the opening at the upper tube.

Lower Tube (long) Assembly

- Press the center band coupler, recessed end first into the opening at the lower barrel.

For Rollerball Pen

- Insert the spring into the recess in the bottom of the refill.
Drop the refill into the opening at the lower barrel.
- Screw the rollerball nib over the refill.

For Fountain Pen

- Affix the ink converter into the back of the nib assembly, then thread the fountain nit into the center band coupler.

GENERAL

- Just screw on both ends of the pen when not in use.