



**FLAT TOP AMERICAN STYLE
ROLLER BALL & FOUNTAIN PEN**

TOOLING-MANDREL-B

BUSHING-2-B

DRILL-V

WOOD- 5/8 X 5/8 OR LARGER-CUT WOOD LENGTH SEE TURNING INSTRUCTION FOR METHOD #1 OR METHOD #2.

TURNING INSTRUCTIONS-CAP METHOD #1

- 1- CUT WOOD LENGTH OF TUBE .
- 2- DRILL WITH V BIT AND GLUE IN TUBE.
- 3- TURN TO DEPTH COLLARS (YOU CAN SAND AND POLISH BEFORE OR AFTER STEP #4.)
- 4- WITH PARTING TOOL PART OFF 1/4 INCH OF WOOD TO BRASS TUBE-LEAVING 1 3/4 INCHES OF WOOD LEFT
- 5- SAND GLUE OFF OF EXPOSED TUBE.
- 6- USE BUSHING 1-2 FOR THIS METHOD.

TURNING INSTRUCTIONS-CAP METHOD #2

1. CUT WOOD 1 3/4 INCHES FINISHED SIZE.
2. DRILL WITH V BIT & GLUE IN TUBE . THIS SHOULD LEAVE YOU WITH PART OF TUBE EXPOSED, BUSHING #3 WILL COVER TUBE.
3. TURN TO DEPTH COLLARS AND POLISH.
4. USE BUSHING 1-2-3 FOR THIS METHOD.

LOWER BARREL-SAME FOR METHOD #1

1. CUT WOOD LENGTH OF TUBE OR A LITTLE LONGER TO SQUARE OFF.
2. TURN TO DEPTH COLLARS #4-5
3. SAND AND POLISH.

ASSEMBLY FOR CAP

- 1- ASSEMBLE 3 PIECE CENTER RING AND PRESS ON EXPOSED TUBE.
- 2- PRESS IN BRASS CLIP BUSHING .
- 3- USING A FLAT HEAD SCREW DRIVER SCREW WHITE PLASTIC NIB PROTECTOR ONTO STUD OF BRASS CLIP BUSHING, SCREW ALL THE WAY IN. THIS IS FOR ADJUSTING THE FIT OF THE CAP, ADJUST IN OR OUT FOR DESIRED FIT. HINT- ADJUST TO FIT ON BACK OF PEN AND IT SHOULD FIT NIB GOOD.
- 4- PUT FINIAL THROUGH HOLE IN CLIP AND THREAD INTO BRASS CLIP BUSHING.

ASSEMBLY FOR LOWER BARREL

1. PRESS NIB HOLDER INTO ONE END OF FINISHED BARREL.
2. PRESS REDUCER COUPLER INTO OTHER END.
3. PRESS ON CAP RECEIVER TUBE.
4. PRESS IN FINIAL (NOT TO HARD, IT WILL SPREAD OUT THE RECEIVER TUBE AND WILL NOT FIT INTO CAP)
5. DROP IN SMALL SPRING LITTLE END UP (ROLLER BALL ONLY)
6. ROLLER BALL ONLY-PUT IN INK INFILL AND SCREW INTO NIB HOLDER.
7. FOUNTAIN PEN ONLY-INSERT CARTRIDGE OR PUMP INTO FOUNTAIN PEN NIB AND SCREW INTO NIB HOLDER.

HINTS- FILLING INK PUMP 1. REMOVE FROM NIB AND SCREW PUMP ALL THE WAY DOWN.

2. PUT IN BOTTLE OF INK THEN BACK OFF PUMP

CAP -LEAVING CAP OFF THIS UNIT WILL CAUSE LEAKAGE OR THE INK TO DRY UP 5/99