

Smitty's Pen Works

Jr Gentlemen 1 Rollerball Pen Instructions / CABALLERO

Supplies needed

- 12mm drill bit *or 15/32*
- 10mm drill bit *or 25/64*
- RZ-JR Bushings
- $\frac{3}{4}$ " x $\frac{3}{4}$ " x 5" pen blank

Cut and drill pen blank

1. Cut blank into 2 sections each $\frac{1}{4}$ " longer than one of the brass tubes.
2. Drill a 12mm hole through the shorter section (while drilling back the drill out and clear the hole frequently)
3. Drill a 10mm hole through the longer section (while drilling back the drill out and clear the hole frequently)

Glue tubes into blanks

1. Lightly scruff the outside of the shorter brass tube
1. Using Thick CA glue or 5 min epoxy spread a thin layer of glue over the entire tube and inside the blank
2. Insert the tube into the blank rotating as you go to spread the glue evenly throughout.
3. Position the tube inside the blank so the blank extends beyond the tube on both ends
4. Set aside and allow to cure for a minimum of 2 hours
5. Repeat steps 1 through 5 for the other tube

Squaring the blank

1. Using a properly sized barrel trimmer or a disc sander square both ends of both tubes. **Do not** trim the brass tubes. Use care to get this step right as it is critical to proper fit of the pen components.

Setup and turning'

If using a mandrel slide the bushings and blanks on as shown in Figure 1. Making sure the bushings are well seated into the tubes. Finger tighten the knurled nut being careful not to over tighten. Mount Mandrel on lathe. Turn blanks to desired shape leaving the blanks a little proud of the bushings. Sand to size and finish.

Assemble the pen

1. Lay out pen parts as shown taking care to keep the pen barrels properly oriented. The shorter barrel is the clip/cap end of the pen.
2. Slide the clip onto the cap and press the clip/cap into one end of the shorter barrel
3. Press the center band coupler black end first into the opposite end of the shorter barrel
4. Slide the trim ring aligned as shown over the unthreaded end of the end cap coupler
5. Press the end cap coupler assembly into the smaller end of the longer barrel then screw the end cap onto the end cap coupler
6. Slide the trim ring aligned as shown over the unthreaded end of the nib coupler then press them into the larger end of the longer barrel. Insert the spring then the ink refill into the longer barrel. Thread the rollerball nib into the nib coupler.

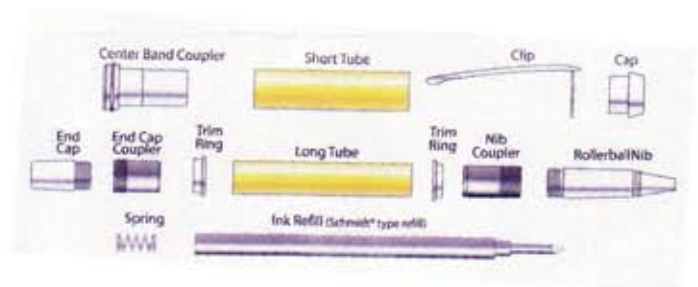


Figure1

