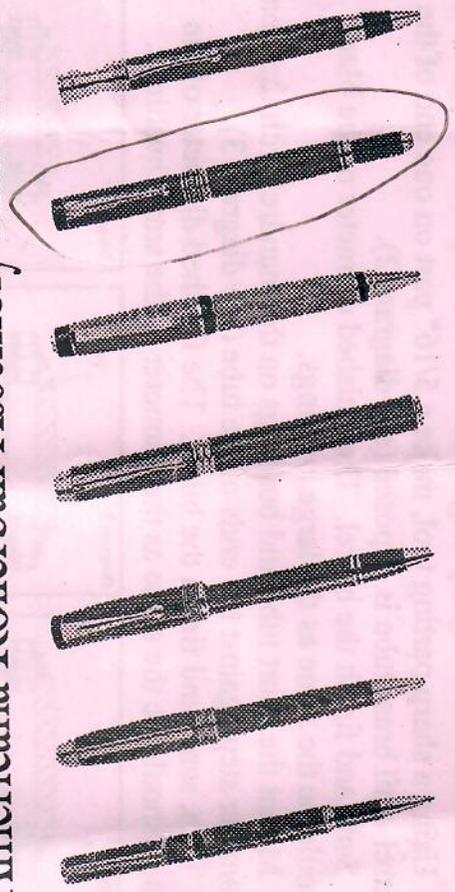


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Americana Rollerball Assembly Instructions

(107SRSD)

Wood Preparation

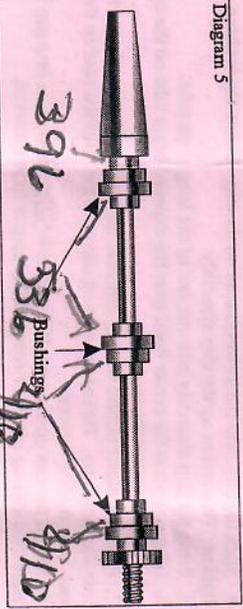
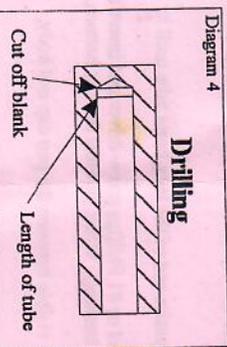
Blank Size and Cutting
 The blank size is determined by the project you are working on. Please refer to the projects assembly instructions for blank and drill sizes. Cut the blanks 1/8" - 1/4" longer than the brass tube being used.

Drilling
 Mark the center of the blank to be drilled and drill to required size. To help prevent blanks from overheating or splitting, clear the drill often and only drill deep enough for the tube length and trimming. (See diagram 4)

Gluing
 Using 220 grit sandpaper, clean the outside of the brass tube. We recommend cyanoacrylate glue for first drying or epoxy and polyurethane glues for slow drying. Apply a coat of glue to the tube and rotate the tube as you push it into the drilled blank.

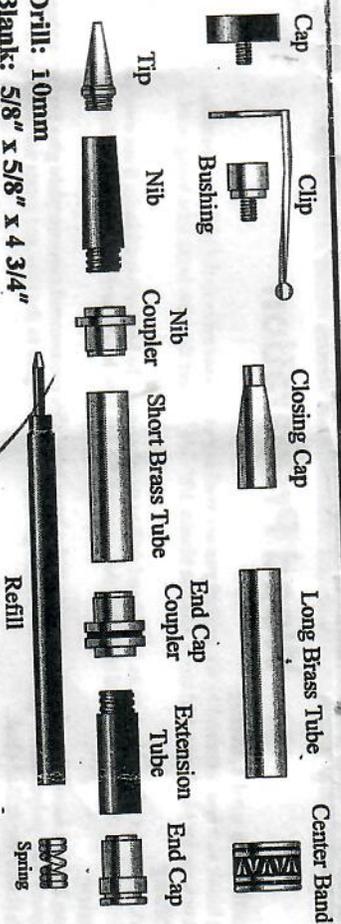
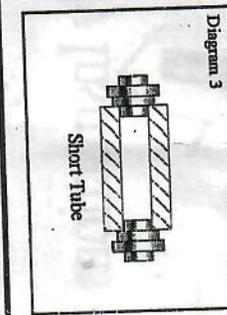
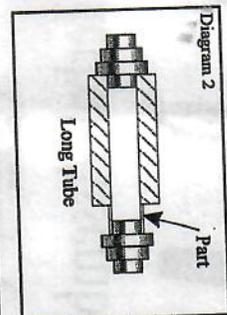
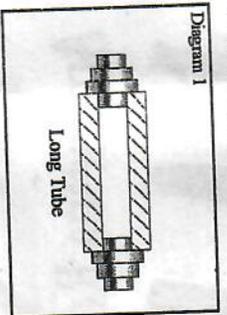
Trimming
 Use a barrel trimmer to square the ends of the blank, this is the fastest and cleanest method. You may use a disc sander to sand the ends square with the tube. **Note:** Make sure you do not remove any of the brass tube as this may affect the finished item.

Mandrel Set Up
 Place the bushing and barrel onto the mandrel (see diagram 5). Some projects and mandrels will require a wood spacer to be made. A wood spacer may be made from a hardwood block, cut to the necessary length and drilled with 7mm hole.



Turning the Americana Rollerball Pen

1. Mount the long tube and bushings on the mandrel with the large diameter end of each bushing against the ends of the long tube (see diagram 1).
2. Turn the wood slightly larger than the bushings (see diagram 1).
3. Using a sharp parting tool, make a 5/16" part on one end of the barrel until brass tube is exposed (see diagram 2).
4. Sand and finish the barrel. The finished diameter of the blank should be the same as the large bushings.
5. Mount the short tube and bushings on the mandrel with the small diameter step against the ends of the tube (see diagram 3).
6. Turn, sand, and finish the blank. The finished diameter of the blank should be the same as the diameter of the small bushings.



Drill: 10mm
Blank: 5/8" x 5/8" x 4 3/4"

Before Assembly:
 Read the assembly instructions completely. Layout the pen parts according to the drawing. This helps familiarize yourself with the parts and how they will go together. We strongly recommend using a vice with wooden jaws during assembly to avoid damaging the parts.

Assembly:

1. Press the nib coupler (glean gold) into the end of the short brass tube.
2. Press the end cap coupler (black striped) into the opposite of the short tube.
3. Press the end cap and extension tube together. Screw the extension tube assembly into the end cap coupler.
4. Slide the clip onto the threaded stud on the cap. Screw the bushing onto the cap (recessed end first) and tighten. This makes up the clip assembly.
5. Press the clip assembly into one end of the long brass tube.
6. Glue and press the center band over the exposed brass tube on the opposite end of the long brass tube until it seats firmly against the wood.
7. Place the white plastic closing cap over the end of the cap adjuster tool or #1 Phillips screw driver and insert into the long tube. Thread the closing cap onto the threaded stud on the bushing. When you feel the cap bottom out, back it off 1 1/2 turns.

If it does not "click" into place or a gap is visible between the pen cap and body,