

Native Pens

JR Gentlemans II Rollerball Pen Instructions

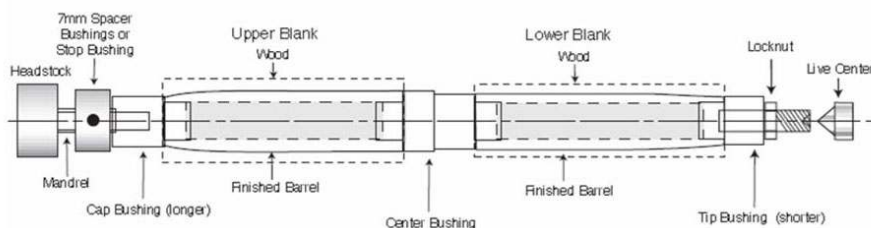
Required:

1/4" Mandrel 10.5mm Drill Bit 3/164" Drill Bit Pen Mill

JR Gentlemans II Bushings

Turning the Pen Barrels.

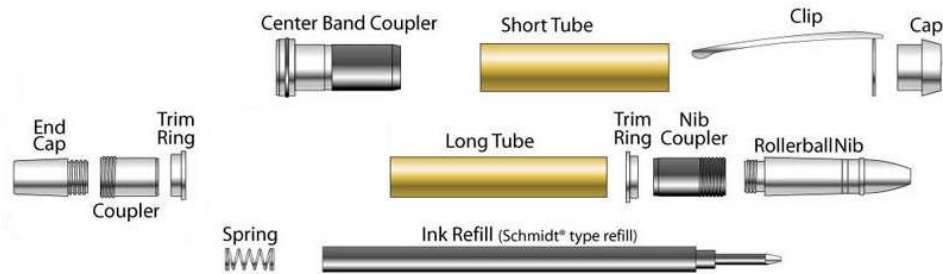
1. Cut a pen blanks slightly longer than the brass tubes.
2. Drill the blanks through the centre, lengthwise. Drill the Shorter tube with the 3/164" bit and the Long Tube with the 10.5mm Bit.
3. Sand the surface of the brass tubes. This can be done by hand or mounted in the bushes on the lathe. This will clean off any oxidation and roughen the surface for a better glue bond.
4. Bond the tubes into the timber blanks. This can be done with CA or two-part epoxy glue. Insert the tube with a twisting motion then push it in until slightly under flush. About equal distance in from each end of the timber blank.
5. Allow glue to cure as required by glue manufacturer.
6. Clean all the dried glue from inside the brass tube. Not cleaning out all the glue from the tube is the most common cause of pen failure.
7. Using a Pen Mill, face off the ends of the blanks until you can just see the bright brass end of the tube. STOP facing at this point. Another method to square the ends is sanding on a disc sander against a square fence or using a jig to hold the tube square to the disc then lightly touching the end with the Pen Mill to finish them.
8. Once the blanks are square and you can see the ends of the tube brighten you can mount the blanks to the mandrel and finish the turning until the desired shape is reached.



9. NOTE: care should be taken to ensure the Long Tube bushings are the correct way around as the Long Barrel Tube has a slight taper on it.
10. Finish the pen to your specifications. Remove the barrels from the mandrel and it is ready for assembly.

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JR Gentlemans II Rollerball Pen Instructions Assembly of the pen.



1. Press the End Cap Coupler, with Trim Ring aligned as shown, into the smaller end of the Long Tube.
2. Slide the Trim Ring, aligned as shown, over the un-threaded end of the Nib Coupler, and then press them into the larger end of the Long Tube.
3. Slide the Clip onto the Cap, and then press them into the top of the Short Tube.
4. To align the grains, thread the Centre Band Coupler onto the Nib Coupler, and ensure it is tight. Slide the Short Tube onto the Centre Band Coupler and align the grains. Then gently press the Centre Band Coupler into the Short Tube until it just holds.
5. Carefully unscrew the Centre Band Coupler from the Nib Coupler, and then finish pressing the Centre Band Coupler into the Short Tube.
6. Insert the spring into the End Cap, and then screw the End Cap onto the end of the End Cap Coupler. Slide the refill in through the Nib Coupler.
7. Thread the Rollerball Nib into the Nib Coupler.
8. Thread the Pen Cap onto the Nib Coupler. Please note the thread on the Nib Coupler has multiple starts. To get the grains to align you may need to un-screw the Cap and restart it at a different place on the thread.
9. You pen is finished.