

# Sailor Gear Pen Kits Assembly Instructions

## Supplies Needed

- 7mm pen mandrel
- 3-piece bushing set RZ-FP116#-BU
- Drill Bit 10 mm RZ-DB010 and 11.7mm RZ-RSDB117
- Universal barrel trimmer
- Glue (Thick CA or Epoxy)



## Preparing the Blank:

- Prepare a master blank of at least 3/4" square. Cut two sections to the length of each tube. (Add 1/16" for trimming)

Mark the center of each blank.

- Drill a centered hole lengthwise through each blank.

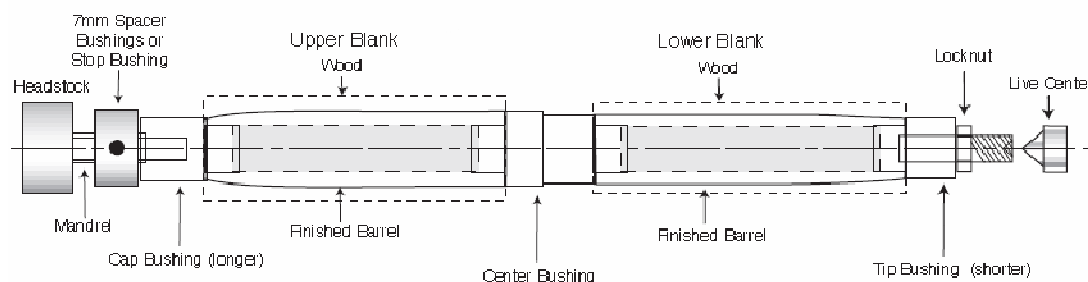
Upper blank (shorter tube)—drill a 11.7mm hole through.

Lower blank (longer tube)—drill a 10mm hole through.

- Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center each tube lengthwise inside the blank.

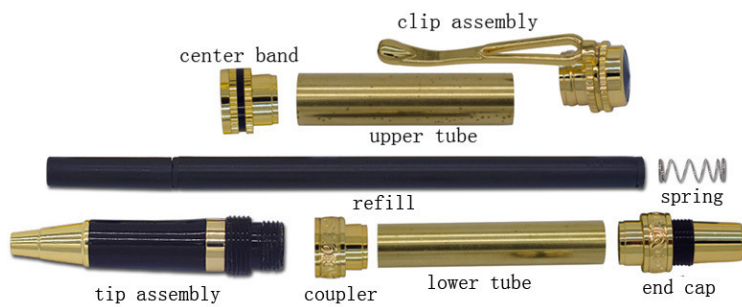
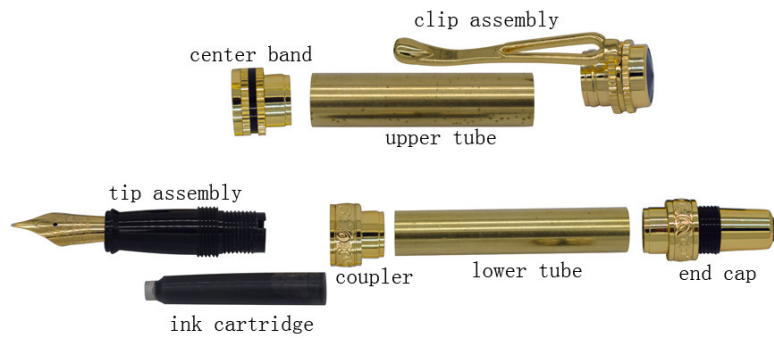
- When glue dries, square the ends of each blank. Using a 7mm barrel trimmer with adapter sleeves, mount the proper sleeve (large diameter for the short tube, smaller diameter for the longer tube) over the shank with the brass tube.

## Turning the Blanks



## Turning the Blank

- Mount 7mm spacer bushings on the mandrel followed by the tip bushing (shorter diameter) wide end first.
- Slide the lower blank (long) on next. Follow with the center bushing, narrow diameter first, Slide on the upper blank (short) and follow with the cap bushing, narrow end first. Add additional spacer bushings as necessary to overlap the mandrel. Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel).
- Turn the blanks down close to the bushings. Follow with abrasives until the tube diameters are flush with the bushings
- Finish with your choice of polish.



## Assembly

NOTE: Line up the components according to the above picture.

- Press the clip assembly into the top of the upper barrel (shorter tube).
- Press the center band into the opposite end of the upper barrel.
- Place the end cap into the end of the long tube
- Press the coupler into another end of the long tube.
- Fountain—Attach the ink cartridge to the back of the fountain nib, then thread the fountain nib into the nib coupler.
- Rollerball—Insert the spring then the ink refill into the long tube. Thread the rollerball nib into the nib coupler.