

Baron rollerball/fountain pen



Needed:

Mandrel A, drills 15/32 and 25/64, bushing 19A, wood size 3/4" x 3/4"

Preparing the blanks

1. Cut the blanks 1/4" longer than the length of each brass tube, giving a little extra length for squaring the ends off after the tubes have been glued in.
2. Drill the upper blank – the shorter one – with the 15/32-drill bit (larger bit).
3. Drill the lower blank – the longer one – with the 25/64-drill bit (smaller bit).
4. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
5. Plug the tube ends with a material of your choice – we recommend baseplate wax – to keep the glue from getting into the tube. Just push the ends of the tubes into a thin section of the material to form a plug. *This is important: glue inside the tubes is a common cause of kit failure.*
6. Roll one of the tubes in glue and insert it into the blank with a twisting motion until the tube is equidistant between both ends

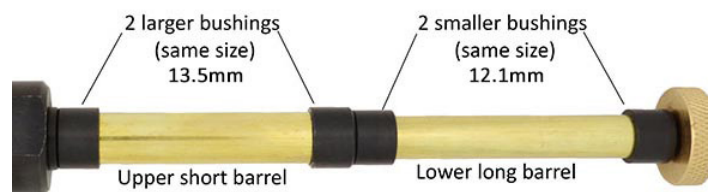
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of the blank. Repeat with the other tube.

7. Set aside until the glue has had time to reach its maximum strength.
8. When the glue has cured, use a hobby knife to remove the plugs from the ends.
9. Using a barrel trimmer of the proper size, square off the ends of the blanks until you can see bright brass tube. STOP at this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another common cause of pen failure.*

Turning the blanks



1. Put the bushings and barrels onto the mandrel referring to the image above.
2. Lightly tighten the mandrel and secure. DO NOT over tighten the brass thumbnut or apply excessive force to the mandrel as this can bend the mandrel and cause your pen to come out oval. A spacer may be installed to give you more room between the thumbnut and the last bushing.

3. Turn the pen blanks to the desired shape using the bushings as a sizing guide.
4. After turning the blanks, sand the surface in progressive steps until you get to 400 or 500 grit. For a smooth finish, continue sanding with Micro Mesh through to 12,000 grit. Apply a finish of your choice and remove the blanks from the mandrel.

Assembling the pen

1. Insert the finial/clip assembly into the short upper barrel and press fit.
2. Slide the black center band coupler (smaller end first) into the plated center band body. Slide the black trim ring followed by the plated trim ring on to the plated center band body. Press the entire assembly into the upper barrel.
3. Press a black threaded coupler and shouldered trim ring into one end of the long lower barrel. Be sure the larger part of the shouldered trim ring faces the barrel.

barrel. Press the remaining coupler and shouldered trim ring into the other end of the long pen blank. Note: the couplers and shouldered trim rings are identical.

4. For the rollerball:
 - a. Press the threaded chrome coupler into the end cap. Then install the spring into the end cap assembly. Screw the end cap assembly on the appropriate end of the long pen blank.
 - b. Insert the refill and screw the rollerball nib in the coupler.
5. For the fountain pen:
 - a. Press the threaded chrome coupler into the end cap. Screw the end cap assembly on the appropriate end of the long pen blank.
 - b. Install the ink cartridge or pump into the back of the fountain pen assembly and screw the entire assembly into the coupler.

