

## Canadiana rollerball/fountain pen



### Needed:

Mandrel A; drills 31/64 and 33/64; bushing 48A

### Preparing the blanks

1. Cut the blanks the length of each brass tube plus 1/4".
2. Drill the short blank with the 33/64 bit.
3. Drill the longer blank with the 31/64 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 – CA glue or two-part epoxy – and insert the tube with a twisting motion until it is equidistant between both ends of the blank. Repeat with the other tube.
7. Set aside until 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,

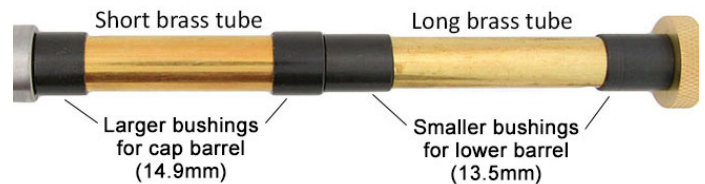
william wood-write

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or a jig and disk sander, square off the ends of the blanks until you can see bright brass tube. STOP at this point. *Not having the proper tube length is another common cause of pen failure.*

### Turning the blanks

Mandrel A bushing set-up for bushing 48A



1. Assemble the blanks on the mandrel referring to the diagram above.
2. Lightly tighten the mandrel and secure. DO NOT over-tighten or apply excessive force to the mandrel as this can bend the mandrel, causing 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 600 grit.
5. For a smooth finish, we recommend using Micro Mesh to 12,000 grit before applying a finish of your choice.
6. Remove the blanks from the mandrel.

## Assembling the pen

1. Press the nib holder into one end of the lower tube (longest tube). Make sure you choose the appropriate end of the tube to preserve the pattern or grain to match your pen.
  2. Assemble the 3-piece receiver holder. Slide the decorative ring on first and then the thin accent ring. Press the decorative receiver holder assembly into the other end of the lower tube.
  3. For rollerball pen: Drop the spring, small end up, into the receiver. Screw the receiver onto the receiver holder. Remove cap from refill and drop it in with the point sticking out of the tube.
  4. For fountain pen replace step 3 with this: insert refill cartridge or converter pump on the writing nib. Lay this aside for a minute.
  5. Assemble the three piece center band as follows: place the decorative ring and the thin accent ring over the black plastic threaded insert (see image at right)
  6. Press this assembly into the end of the large brass tube.
  7. Press the clip bushing brass insert into
8. the other end of the same tube with the threaded end up. Press it in until the shoulder is flush with the blank. This will leave the threads sticking out.
  8. Place the clip over the threaded part of the brass clip insert.
  9. Place the clip ring over the clip with the notch over the clip.
  10. Screw on the finial.
  11. If the clip is not quite tight, you can disassemble the clip and press the threaded insert into the tube just slightly more.
  12. One other adjustment. If your pen looks like the image below when finished, with the nib holder showing below the center band, then place the cap on the pen and push downward slightly to hide the nib holder.

