



Jr. Gentleman2 Pen Kits Assembly Instructions

REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 4-piece bushing set #9271
- 12.1mm Drill Bit
- 10.4mm Drill Bit
- 3/4x3/4x5" pen blank
- Universal barrel trimmer
- 2-part epoxy glue or insta-cure glue (cyanoacrylate).



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.

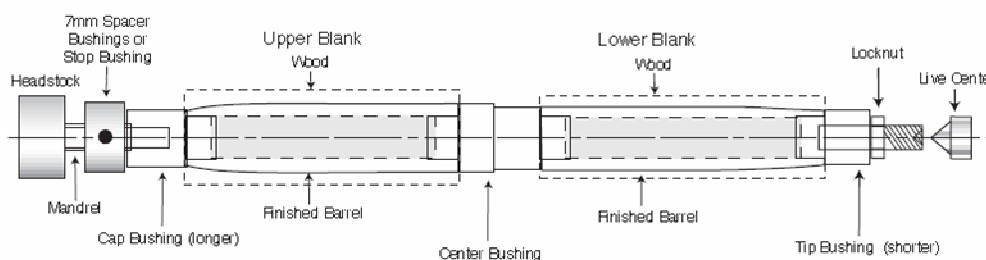
Upper blank (shorter tube)—drill a 12.1mm hole through.

Lower blank (longer tube)—drill a 10.4mm 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

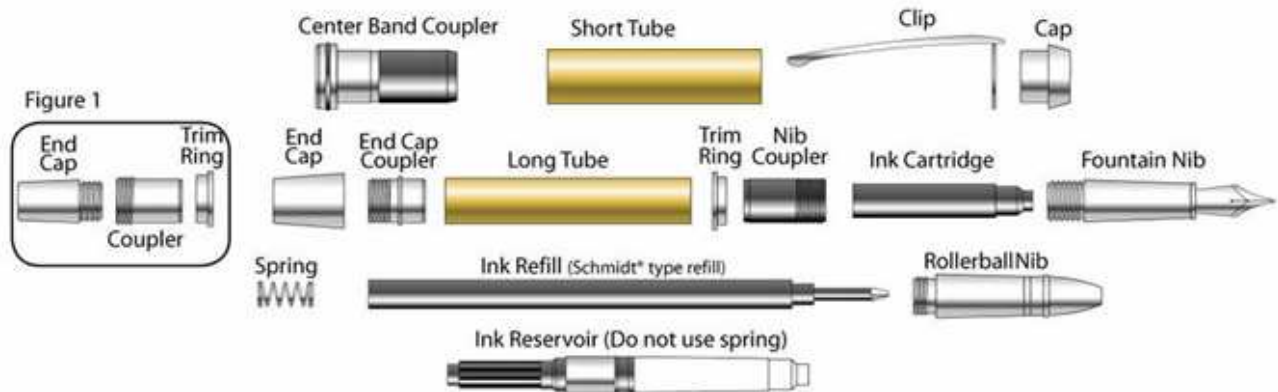
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the mandrel).

- 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.

DIAGRAM A – Assembly



Assembly

NOTE: Line up the components according to DIAGRAM A.

- Slide the clip onto the cap, then press them into the top of the upper barrel (shorter tube).
- Press the center band coupler, black end first, into the opposite end of the upper barrel.
- Place the end cap coupler into the end of the long tube, then screw the end cap onto the end cap coupler. Please see figure1 for the cap assembly.
- Slide the trim ring, aligned as shown below, over the unthreaded end of the nib coupler, then press them into another end of the long tube.

Rollerball---Insert the spring then the ink refill into the long tube. Thread the the rollerball nib into the nib coupler.

Fountain---Attach the ink cartridge to the back of the fountain nib, then thread the fountain nib into the nib coupler. If use the ink reservoir, remove the spring from inside the end cap.