

# Bullseye Turning Supply

## Apollo Fountain & Rollerball Kits

### Supplies Required:

Drill Bits: 3/8, 29/64, 23/64, 5/16, 1/4"  
Collet Chuck with 3/8" Collet  
5 Min Epoxy  
Apollo Mandrel Set  
Live Center  
Personal Protective Equipment  
3/4" x 3/4" x ~6" Blank (Resin, Hybrid, or Stabilized Wood)

### Recommended:

Calipers  
Pen Jaws Or Collets To Drill On The Lathe

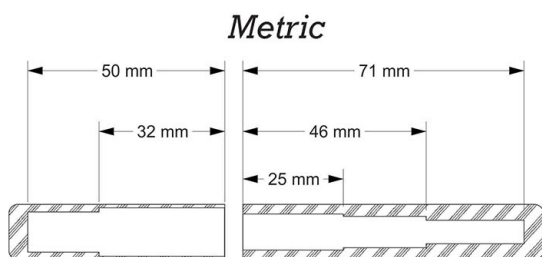
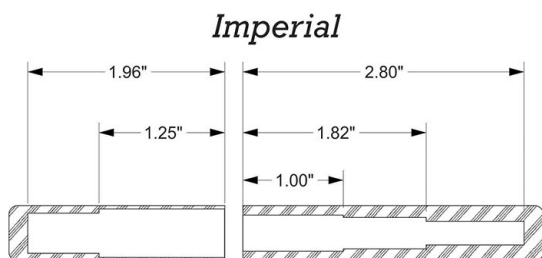


### Getting Started

1. Make a mark on the blank at 2.5" from the edge. This side will be the cap, and should leave 3.5" for the body of the pen.
2. Cut the blank on your line with your tool of choice.

### Drilling the Body Blank:

1. Hold your blank in a vice on the drill press or, preferably, in pen jaws on the lathe.
2. Before drilling, clean up the cut edge with a tool and/or sandpaper to ensure the parts sit flush to the blank.
3. Start with the 1/4" drill bit, and drill 2.8 inches into the blank. DO NOT DRILL ALL THE WAY THROUGH
4. Using the 5/16 drill bit, drill 1.825" into the blank.
5. Using the 23/64 drill bit, drill 1" into the blank.
6. Check the fit of your body assembly in the blank. Set aside.



### Drilling the Cap Blank:

1. Hold your blank in a vice on the drill press or in pen jaws on the lathe. Clean up the cut end like you did on the body blank.
2. Start with the 3/8 drill bit, and drill 1.96" into the blank. DO NOT DRILL ALL THE WAY THROUGH
3. Using the 29/64" drill bit, drill 1.25" into the blank.
4. Check the fit of the cap sleeve in the cap blank.

### Gluing The Components:

1. Mix up some 5 min epoxy & lightly coat the outside of the body & cap sleeves. If you can, it helps to also lightly coat the inside of the cap blank with epoxy.
3. Press the body sleeve into the body blank. Wipe off any epoxy squeeze out.
4. Thread the cap insert onto the body hardware. Press the cap sleeve into the cap blank, and line up your two blanks. Wipe off any epoxy squeeze out.

### Turning:

1. Set up your collet chuck with 3/8" collet on your headstock. Insert the body mandrel into the collet and tighten snugly.
2. Once th
3. Turn the blank to the desired shape & part off the bit where the tailstock will leave a dimple.
4. Sand & polish. Repeat for the cap blank.

**Assemble the pen section onto the body blank & enjoy the fruits of your labor!**

**Updated 08/01/2023**