

Navigator Rollerball & Fountain Pen Kits

Product : #146018, #148851, #149177, #149909, #149910, #149911, #149871, #147479, #147480, #147481, #147482 7/30/2015



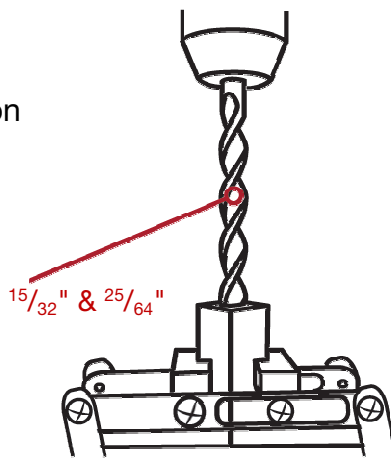
From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- $15/32$ " Pen Maker's Bit Cap Blank
- $25/64$ " Pen Maker's Bit Body Blank
- 1 - $3/4$ " x $3/4$ " x 2" Cap Blank
- 1 - $3/4$ " x $3/4$ " x $2\frac{1}{4}$ " Body Blank
- Pen Mandrel
- Navigator Bushings (146019)
- Thick CA or 5 Minute Epoxy
- Drill or Drill Press
- Sandpaper/Micro-Mesh
- Barrel Trimmer
- Pen Press
- Eye & Ear Protection
- Dust Mask

Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.

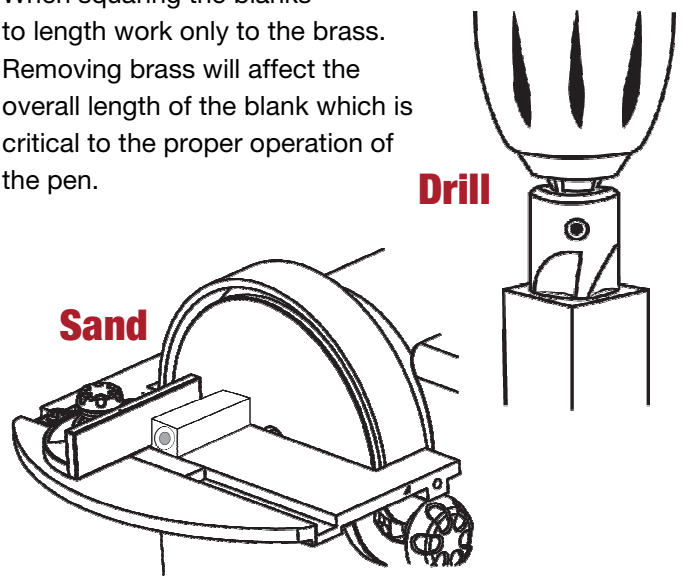


Gluing Blanks to Tubes:

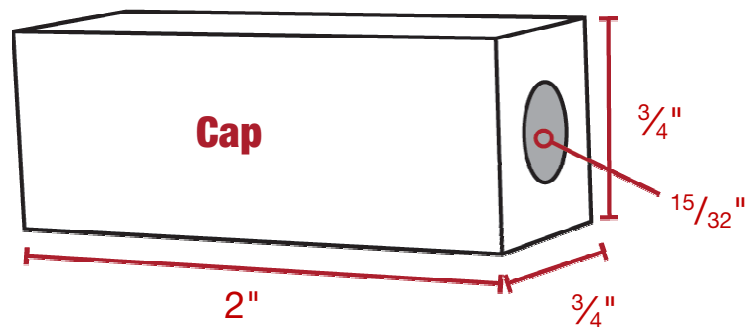
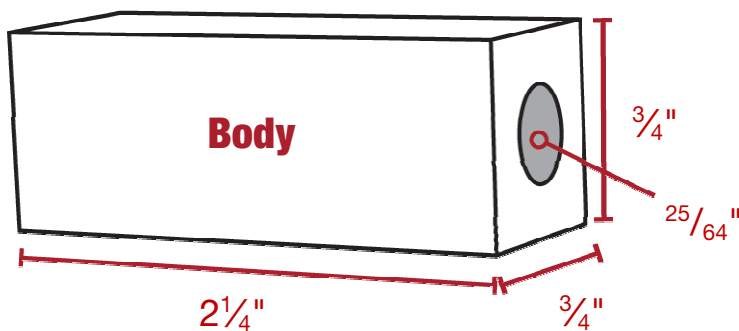
Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5-Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube into the inside of the blank make sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.

Squaring the Blank to Length:

When squaring the blanks to length work only to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation of the pen.

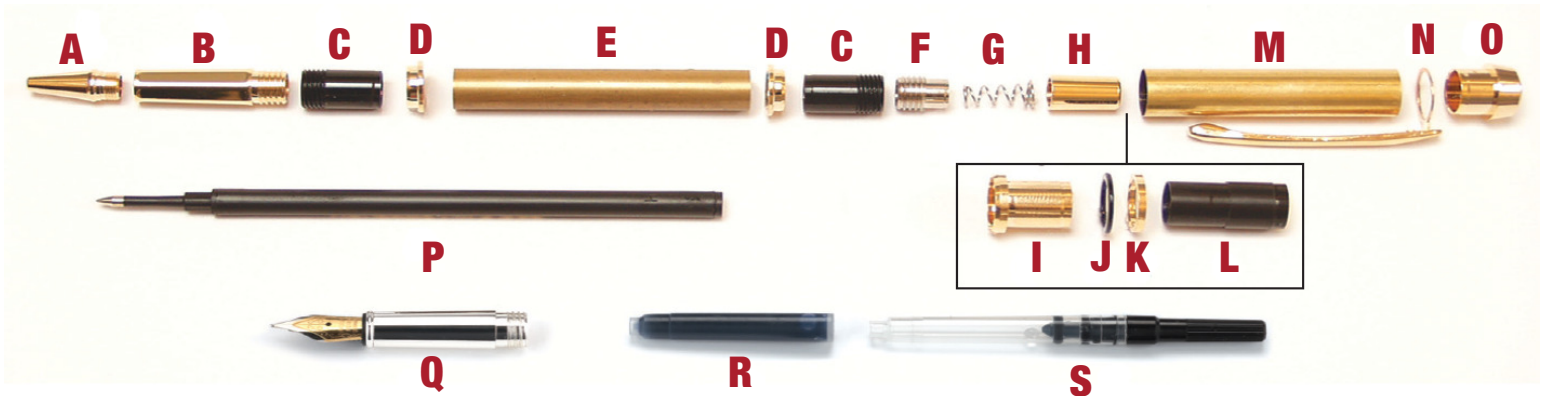


Mandrel Preparation:



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Turning & Finishing the Blanks:

Turn the blank to your desired profile, leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120-grit paper, and progress through the finer grits finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

Assembly:

Roller Ball Body:

- ❑ Slide one of the Threaded Body Connectors (C) through one of the Shouldered Trim Rings (D), as shown in the diagram above, shoulder of the Trim Ring facing the threads of the Body Connector.
- ❑ Next press the Body Connector Assembly (C, D) into one end of the finished Body (E). Repeat the above steps for the other end of the finished Body (E).
- ❑ Press the Finial Holder (F) non-threaded end first into the Finial (H). Insert Spring (G) large end first into the Finial Assembly (F, H) and thread into one end of the finished Body (E).
- ❑ Thread Nib (A) into Nib Holder (B). Insert Ink Refill (P) into the open end of the finished Body (E) followed by threading the Nib Assembly (A, B) over the Ink Refill and into the Threaded Body Connector.

Fountain Pen Body:

- ❑ Plug Pump (S) or Ink Cartridge (R) into the Fountain Pen Nib (Q), thread assembly (Q, S or R) into the Threaded Body Connector.

Cap:

- ❑ Slide the Black Trim Ring (J) onto Center Band (I), followed by Trim Ring (K).
- ❑ Next slide the Threaded Cap Tube (L) small diameter end first into the Center Band (I). Press the assembly (I, J, K, L) into one end of the finished Cap (M).
- ❑ Slide the Finial Cap (O) through Clip (N) and press the assembly (O, N) into the open end of the finished Cap (M).