

Dragon Rollerball-Fountain Pen Kits

Kit Features:

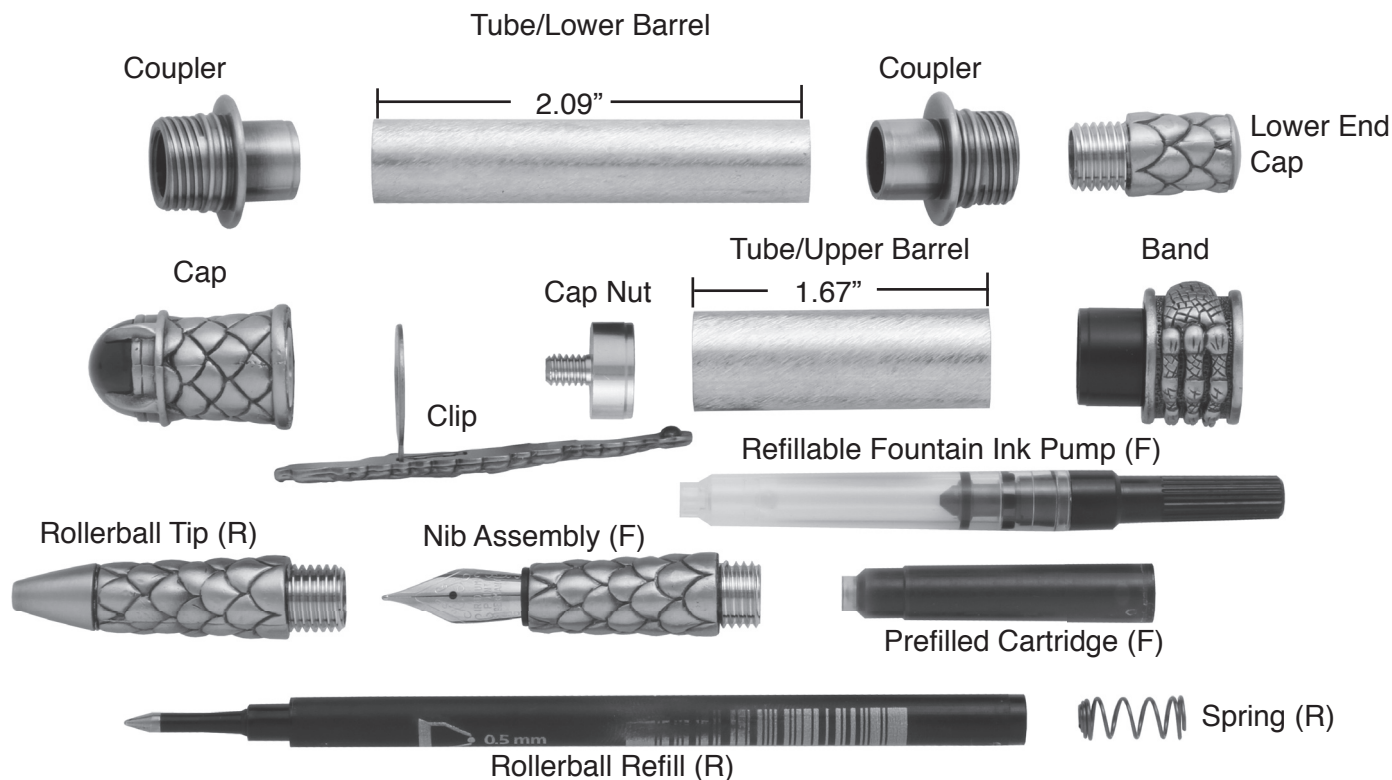
- Intricate and attractive styling
- Post able, Threaded Cap
- Easy to Turn With Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 5-29/32" (R), 6-1/32" (F)

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit:12.5MM #PKPLI-DB; 10.5mm #PK105MM
- Bushing Set(3 pc): #PKDRRBU
- Barrel Trimming set:#PKTRIM7 with #PKMAJJRBTs
- Barrel Trimming Sleeves
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size:4-1/2"x3/4" , 4-1/4" x 3/4"



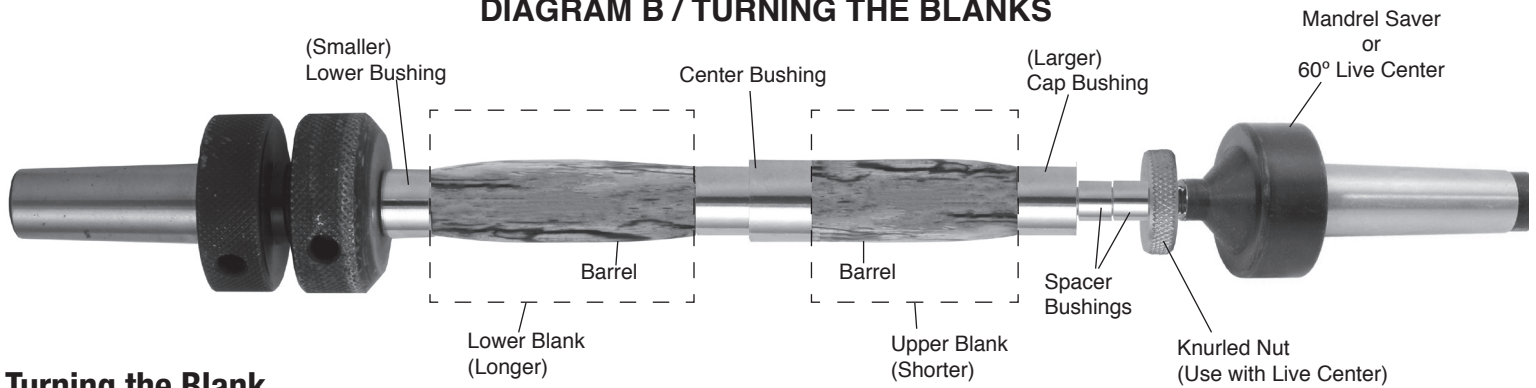
DIAGRAM A / PARTS LAYOUT
(R)-Rollerball Kits Only (F)-Fountain Kits Only



Preparing the Blank:

- Cut blanks to the length of the tubes, adding 1/16" for squaring off.
- Drill holes lengthwise through the blanks.
- Spread glue over the tube, insert each tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 7MM barrel trimmer with #PKMAJJRBTs sleeves, or a pen blank squaring jig with 10.5MM & 12.5MM trimming sleeves on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with fit of the assembly. Use a barrel trimmer or file to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANKS



Turning the Blank

- Mount the bushings and blanks according to diagram B.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple. Lock Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over-tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel straight or to a profile of your choice.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

Assembly

- Arrange finished parts according to Diagram A
- Insert Cap Nuts screw post through Clip and thread into Cap.
- Press cap nut into the smaller dia. end of upper barrel.
- Press band into opposite end of upper barrel.
- Press couplers into both ends of the lower barrel.
- Thread lower end cap onto either end of the lower barrel.
- **For Rollerball pens:** drop the spring into the open end of the lower barrel, followed by the refill-flat side first. Thread the roller tip over the refill.
- **For Fountain pens:** choose either the prefilled cartridge or refillable pump and insert into the back of the nib assembly. Thread the nip assembly onto the open coupler. Note: do not insert ink until ready to begin using pen. Ink can dry up and clog nib if left unused in pen for long periods.
- Keep cap over pen tip when not in use. Store fountain pen with the nib side up.

Diagram C / Bushings #PKDRRBU

