

Fig. 1

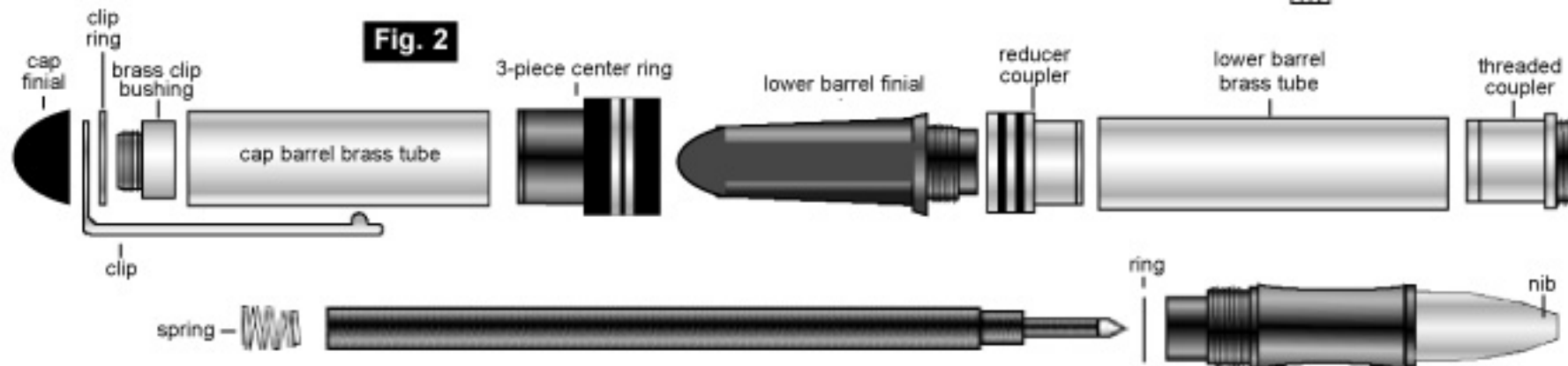


Fig. 2

Materials:

- 1) Churchill Rollerball Pen kit **583, 585**
- 2) Pen blank, recommended size: 3/4 x 3/4 x 5".
- 3) 17/32 drill bit **149**, & 31/64" drill bit **176**
- 4) Maxi-cure Extra-thick CA **184**, epoxy **189**
- 5) 5/8" barrel facing tool **331** with pilot **335**
- 6) Amero-classic mandrel and bushing set **306**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP combo **109**

Preparation:

- 1) Cut blank in two pieces, each approximately 1/4" longer than its respective tube.
- 2) Drill shorter blank with a 17/32 drill bit. Drill longer blank with a 31/64" drill bit.
- 3) Glue tubes into blanks.
- 4) When glue is cured, square ends with barrel facing tool.
- 5) Turn on an Amero-classic mandrel with bushing set **306**, which consists of four step bushings (2 large & 2 small). Arrange bushings and tubes as shown. (Fig. 1)

Turning:

- 1) Turn blanks down to bushings. The larger, shorter barrel will serve as the pen cap.
- 2) Sand and finish with HUT PPP combo. Finish with a two-step process; first apply PPP Satin Gloss, then PPP High gloss or try HUT Crystal Coat for a perfect pen polish!

Assembly (Fig. 2):

- 1) Assemble 3-piece center ring holder and insert in end of large short tube.
- 2) Press the brass clip bushing into other end of tube. Put clip into notch on clip ring and slip both over clip bushing. Screw on finial.
- 3) Push threaded coupler into one end of lower barrel. Press reduced coupler into other end. Screw in lower finial.
- 4) Drop in spring into lower barrel and insert refill. Screw on nib.

