

Fig. 1

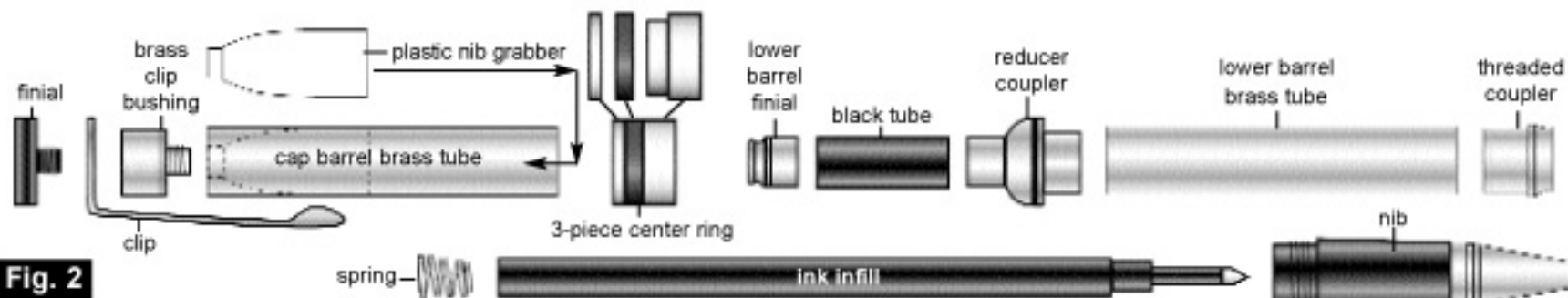


Fig. 2

**Materials:**

- 1) Ameroclassic Rollerball pen kit **522, 523, 532, 1452**
- 2) Pen blank, minimum size 5/8 x 5/8 x 5"
- 3) 25/64" drill bit **173**
- 4) Maxi-cure Extra-thick CA **184**, epoxy **189**, or polyurethane **196**
- 5) 5/8" barrel facing tool **331** with pilot **335**
- 6) Ameroclassic mandrel and bushing set **327**
- 7) Sanding rolls, 4 pk. **1120**
- 8) HUT PPP combo **109**  
Hut Crystal Coat **104** may also be used.

**Preparation:**

- 1) Cut blank in two pieces, each approximately 1/4" longer than its respective tube.
- 2) Drill blanks with a 25/64" drill bit.
- 3) Glue tubes into blanks.
- 4) When glue is dry, square ends with barrel facing tool.
- 5) Turn on an Ameroclassic mandrel with bushing set **327**, 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 barrel will serve as the pen cap. Both barrels should have the straight Ameroclassic (Parker Style) profile.
- 2) Using a parting tool, remove 3/16" of material down to brass tube on the center ring end of cap. (Fig. 3) Make sure all glue is off **brass**.

Fig. 3



- 3) Sand and finish with HUT PPP combo. Finish with a two-step process; first apply PPP Satin Gloss, then PPP High gloss for a perfect pen polish!

**Assembly (Fig. 2):****Cap assembly:**

- 1) Assemble 3-piece center ring and press onto exposed end of cap tube as shown in Fig. 3. Glue as necessary.
- 2) Press brass clip bushing, beveled end first into clip end of cap barrel until flush with wood.
- 3) Clip assembly: Insert finial through clip and screw into brass clip bushing. Glue clip to pen cap to prevent rotation.
- 4) Insert plastic nib grabber, small end first, into open end of cap and screw on with a narrow bladed screw driver. This piece holds and adjusts the cap to the pen during use. This may need to be adjusted for the cap to snap on properly.

**Pen assembly:**

- 5) Press threaded coupler into nib end of lower barrel and press reducer coupler into other end.
- 6) Press black tube onto open end of reducer coupler and lower barrel finial onto other end.
- 7) Drop spring & infill into open end of lower barrel. Screw on nib.

