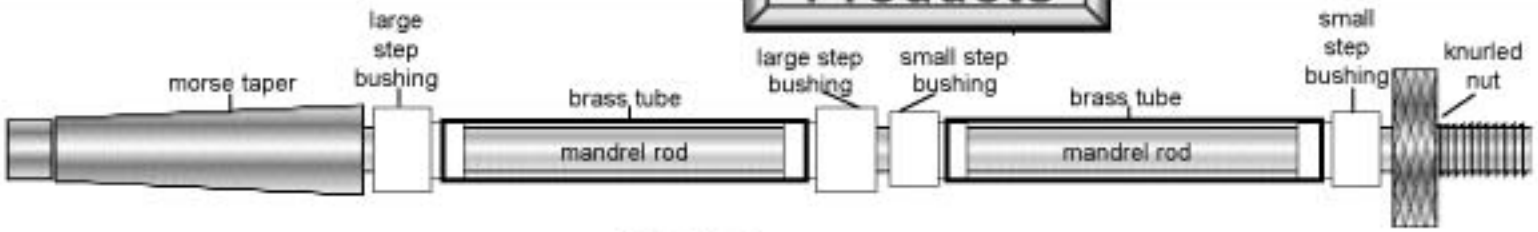

Fig. 1

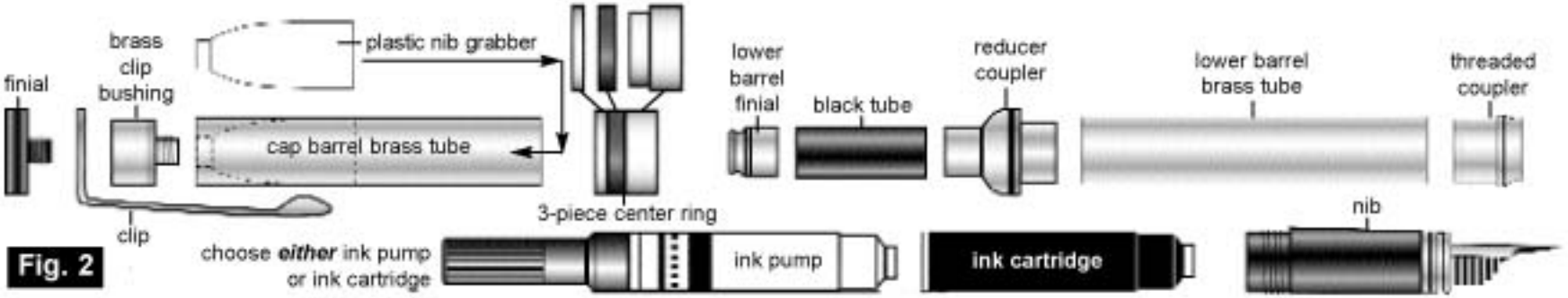

Fig. 2

Materials:

1) Ameroclassic Fountain pen kit **524, 525, 534**
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** w/pilot **335**
6) Ameroclassic mandrel and bushing set **327**
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 blanks with a 25/64" drill bit.

3) Glue tubes into blanks.

4) When glue is cured, 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 the 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 adjusting for the cap to snap on properly.

Pen assembly:

5) Press threaded coupler into nib end of brass tube 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) Press either ink pump or ink cartridge into nib and screw on.

2-18-08

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