1071 Fountain Pen Kit
1070 Roller Pen Kit
Classic 10mm Pen

The Wooden Post, Inc.
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Kit Features:
- Heavy 24 Kt. Gold Plating
- Pen construction to be similar in appearance to the classic Parker® Pen of the 1920's
- Overall Length 5-3/8''
- High quality German made iridium fountain pen nib
- Uses Parker® type point German made refill
- Needed to turn the pen:
  - 7mm Mandrel
  - Bushings # 1132
  - 10mm Drill Bit 1579
- Pen Parts: See Step 9 for layout assembly

Step 1 - Cut Wood Blanks
From 5/8'' or larger square stock, cut blanks to the size of each tube plus 1/8''. Grain should run length wise.

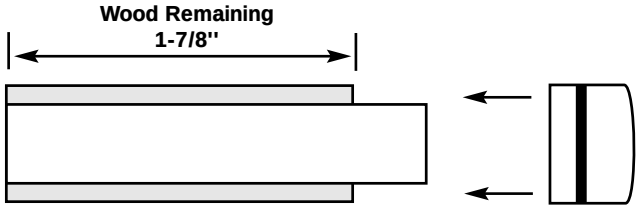
Step 2 - Drill The Wood Blanks
Bore a center hole lengthwise through each blank. Drill carefully since excessive pressure may cause the drill bit to wander and/or split the blank. Slow the feed rate and back the bit out repeatedly for chip removal. For best results use a 10mm HSS drill bit (#PK10-10).

Step 3 - Glue The Tubes Into The Blanks
Apply epoxy or gap filling cyanoacrylate (super glue) to the tube and insert into the blank with twisting motion. This will spread the glue evenly. Center the tube within the blank. Allow to dry.

Step 4 - Square The Ends
With a disc sander or other sanding device, square the ends of the blanks 90 degrees to the tubes. The squared ends should be flush with the brass tubes.

Step 5 - Turn The Wood Blanks
There are three different bushings needed to properly turn the classic pen. A wide bushing at the cap end, a narrow bushing at the tip end and a center bushing. The proper bushings have been made to give you a "template" to help turn the pen blanks accurately. This pen may be turned one section at a time or, both pieces mounted side by side on a long mandrel.

Step 5A - Turning The Pen Cap and Body
When using our long mandrel, mount mandrel on headstock. Place locking bushing on mandrel, place the **smaller** diameter bushing *(Note: There are two end bushings that look similar, but they have different diameters. Be careful not to use the wrong one)* on the mandrel with the narrow end exposed. Next, slide the short brass sleeve over the bushing. Take the center bushing, slide onto the mandrel and insert it into the brass sleeve. Make sure that the **smaller** diameter shoulder is against the short sleeve. Next slide the longer brass sleeve onto the mandrel over the center bushing up against the **larger** diameter of the bushing. Last, slide the remaining end bushing on the mandrel making sure the bushing slides inside the brass sleeve. Install locking nut on the end of the mandrel. Now adjust locking bushing at headstock end to position both pen blanks to be snug against the lock nut. Tighten locking bushing with allen wrench and nut with light pressure. Do not over tighten. Set live center in tailstock into mandrel. Do not over tighten.
For best results the blanks must be turned to the exact diameter of the bushings. After finial turning and before finishing a recess in the cap part will have to be cut out to accommodate the center band.



Recess Cutting for Center Band

Step 5 B - Turning The Recess *(see diagram)*
The cap barrel will have some wood removed to accommodate the center band (see diagram above). Measure and mark the barrel to leave 1-7/8'' of wood on it. Part the rest of the wood using a skew chisel or a parting tool. Be careful not to cut through the brass tube. The shoulder you create must be square. It may be undercut slightly to ensure a good fit. Touch up the edge with sandpaper being careful not to round over the edge or reduce the diameter.

Step 6 - Sand
As with any sanding, progress through a range of grits. The type of wood used and the quality of the beginning surface will dictate your selection.

- 80-100 grit if rough surface or additional shaping is needed (overly thick)
- 120-150 grit if fairly smooth and straight
- 220-240 grit for finial finish with most domestic woods
- 320-400 grit especially on dense or oily exotic woods

Scotch Brite® works well and doesn't tend to scratch. Sand with blank spinning. For initial shaping, stick sandpaper on a board wide enough to remove any hills or valleys.

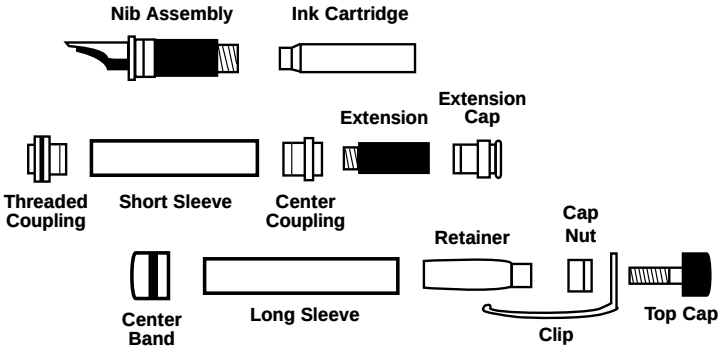
Step 7 - Finish
Try a finish of your choice but be careful if brushing on poly, etc., you could stick the tube, bushings, and mandrel together. The following friction polish works well on most woods:
1/3 wood alcohol (methanol), 1/3 white/clear shellac, 1/3 boiled linseed oil.
Mix equal parts of the three ingredients in a bottle and shake before using. Apply with a rag to the spinning tube. Apply two coats. Remove the tube from the mandrel. We recommended "Hut" perfect pen polish (satin finish #PK-PF1) and (high gloss finish #PK-PF2) to finish your project.

Step 8 - Touch Up
With tubes off mandrel, lay them end to end to decide how to arrange the pen body to look best with the cap when assembled. Remember, they will be 7/16'' apart (due to the center ring) so minor differences will not show. A light sanding of the tube ends on a block will square them and improve the fit during assembly.

General Assembly Hints:

- Use a clamp or vise to press parts together, using gentle pressure.
- Front and rear tubes can be matched to display a continuous grain pattern for added beauty.

Step 9 - Fountain Pen Assembly



a) Identify & line up parts as indicated in diagram above.

Assembly Of Body:

b) Press together the threaded coupling. The short sleeve and the center coupling.

c) Screw extension into center coupling (without black stripe).

d) Press the gold extension cap into the end of the black extension.

e) Screw nib assembly into threaded coupling (with black stripe) thus completing the pen body.

Cap Assembly:

f) Press cap into end of the long sleeve above, tapered end first.

g) Insert thread of top cap into clip and screw into cap nut on end of cap assembly.

h) Spread a thin coating of glue on the exposed recess of the brass tube. Push the center band on the tube with the sharp corner side in, flush against the wood.

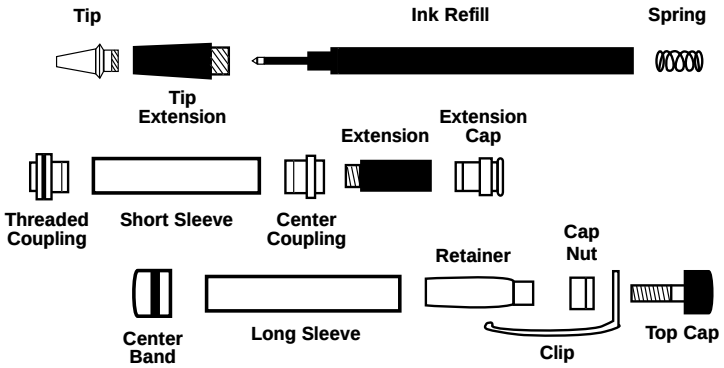
i) Slide the plastic pen retainer inside the cap assembly, closed end first. Use a 5/16'' Phillips head screw driver inserted into the top sleeve to screw the pen retainer onto the top cap thread.

j) Adjust closing mechanism for a tight fit by turning the retainer clockwise or counter clockwise with your screw driver until an exact fit is made. Test fit by snapping cap over pen point and on extension end of pen body.

Loading Ink:

k) Place two cartridges in the pen barrel, back to back. Screw nib assembly into coupling thus piercing ink cartridge for use.

Step 9 - Roller Ball Pen Assembly



a) Identify & line up parts as indicated in diagram above.

Assembly Of Body:

b) Press together the threaded coupling. The short sleeve and the center coupling.

c) Screw extension into center coupling (without black stripe).

d) Press the gold extension cap into the end of the black extension.

e) Insert the tension spring in the body assembly and remove protective cover from ink refill.

f) Insert the refill, blunt end first, into body assembly against spring.

g) Screw tip into tip extension, then screw this tip assembly over refill, thus completing the pen body.

Cap Assembly:

h) Press cap into end of the long sleeve above, tapered end first.

i) Insert thread of top cap into clip and screw into cap nut on end of cap assembly.

j) Spread a thin coating of glue on the exposed recess of the brass tube. Push the center band on the tube with the sharp corner side in, flush against the wood.

k) Slide the plastic pen retainer inside the cap assembly, closed end first. Use a 5/16'' Phillips head screw driver inserted into the top sleeve to screw the pen retainer onto the top cap thread.

l) Adjust closing mechanism for a tight fit by turning the retainer clockwise or counter clockwise with your screw driver until an exact fit is made. Test fit by snapping cap over pen point and on extension end of pen body.

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