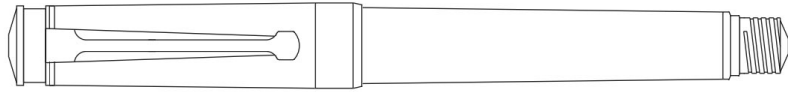


Beaufort Leveche Rollerball Pen Kit

william wood-write

penblanks.ca



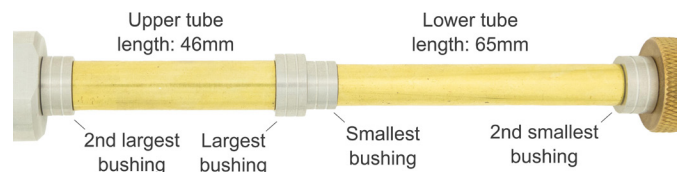
Needed:

Mandrel A, drills 15/32 and 25/64,
bushing LEV-RB-FP-BU

Preparing the blanks

1. Cut the blanks the length of each brass tube, giving a little extra length for the facing of the blanks after the tubes have been glued in.
2. Drill the blank that will use the shorter, thicker (upper) tube lengthwise with the 15/32 mm drill bit.
3. Drill the blank that will use the longer, thinner (lower) tube lengthwise with the 25/64 mm drill bit.
4. Scuff the brass tubes with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
5. Plug the tube ends with a material of your choice – we recommend baseplate wax – to keep the glue from getting into the tube. Just push the ends of the tubes into a thin section of the material to form a plug. This is important: glue inside the tubes is a common cause of kit failure.
6. Roll one of the tubes in glue and insert it into the blank with a twisting motion until the tube is equidistant between both ends of the blank. Repeat with the other tube.
7. Set aside until the glue has had time to reach its maximum strength.
8. When the glue has cured, use a hobby knife to remove the plugs from the ends.
9. Using barrel trimmers of the proper size or the proper jigs and a disk sander, square off the ends of the blanks until you can see bright brass tube. Not having the proper tube length is another common cause of pen failure.

Turning the blanks



1. The cap, centre band, nib connector and finial are all different diameters. Identify the two bushings that fit the upper (shorter) tube. The larger bushing is for the centre band end and the smaller bushings is for the cap end.

The remaining two bushings are for the lower (longer) tube. The larger one is for the nib connector end and the smaller one is for the finial end.

2. Turn the pen blanks to the desired shape using the bushings as a sizing guide.
3. After turning the blanks, sand the surface in progressive steps until you get to 400 or 600 grit.
4. If a higher gloss finish is desired, continue sanding with Micro Mesh through to 12,000 grit. Then apply a finish of your choice and polish.
5. Remove the blanks from the mandrel.

2. Slide the clip over the cap and press this assembly into the smaller end of the upper barrel.
3. Screw the nib into the nib connector, then press this assembly into the larger end of the lower barrel.
4. Put the spring, large end first, into the finial and press this assembly into the smaller end of the lower barrel.
5. Unscrew the nib. Remove the cap from the refill and seat the refill into the barrel with the writing nib exposed.
6. Screw the nib back on over the refill.
7. The lower barrel assembly will now screw into the upper barrel at the centre band.

Assembling the pen

1. Push the black plastic “cap thread” (threaded end first) into the centre band. Press this assembly into the larger end of the upper barrel.

