

# Odyssey rollerball pen



## Recommended tooling:

7mm mandrel; drill 25/64"; bushing set 122A

## Preparing the blank

1. Cut the blank about ¼" longer than the length of the brass tube.
2. Drill the blank through the centre, lengthwise, with a 25/64" drill bit.
3. Scuff the brass tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the ends of the tube with a material of your choice – we recommend base plate wax– to keep the glue from getting into the tube. Just push the ends of the tube into a thin section of the material to form a plug. *This is very important: glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in glue.
6. Insert the tube into the blank with a twisting motion.
7. When the glue has cured, use a hobby knife to remove the plugs from the ends. Using a barrel trimmer of the proper size, square off the ends of the blank until you can see bright brass tube. STOP at

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this point. This can also be done with the proper jig and a disk sander. *Not having the proper tube length is another common cause of pen failure.*

## Turning the blank



1. Assemble the blank on the mandrel using the 122A bushings. Both bushings are the same size.
2. Lightly tighten the mandrel and secure. Do not over-tighten – this can bend the mandrel which will result in an oval pen.
3. Turn the pen blank to the desired shape using the bushings as a sizing guide.
4. After turning the blank, sand the surface in progressive steps until you get to 400 or 600 grit.
5. For a smooth finish, sand with Micro Mesh to 12,000 grit. Then use a finish of your choice and polish.
6. Remove the blank from the mandrel.

## Assembling the pen

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1. Press the finial into either end of the barrel.
2. Press the coupler into the other end of the barrel.
3. Drop the spring into the tube, wide end first.
4. Drop the refill into the tube and screw the nib on over top.
5. Screw the cap on over the nib.

