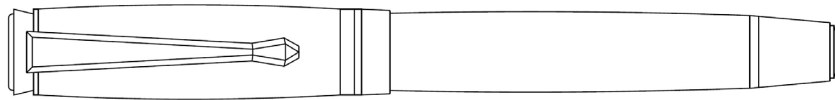


Beaufort Cyclone Rollerball Pen Kit

william wood-write

penblanks.ca



Needed:

Mandrel A, drills 10.5 mm and 12.5mm, bushing CYC-RB-FP-BU

Preparing the blanks

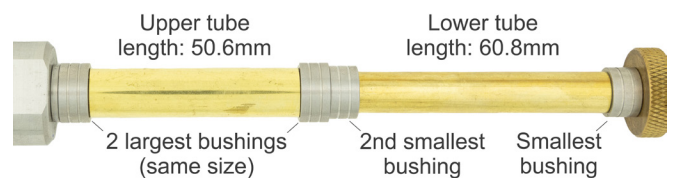
1. Cut the blanks the length of each brass tube, giving a little extra length for the facing of the blanks after the tubes have been glued in.
2. Drill the blank that will use the shorter, thicker tube lengthwise with the 12.5 mm drill bit.
3. Drill the blank that will use the longer, thinner tube lengthwise with the 10.5 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.

Note: The 12.5mm pen mill is very tight inside the upper tube for this kit. We recommend sizing down to a 31/64" pen mill, or squaring up on a disk sander.

Turning the blanks



1. For the upper barrel, the cap finial and centre band ends have the same diameter bushings. For the lower barrel, the larger of the two bushings is for the nib connector end. The smaller of the two bushings is for the nib barrel 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.

Assembling the pen

1. The nib, nib barrel finial and centre band all have factory fitted accent rings, however they are not fixed in place and may be loose in their bags. Ensure the accent rings are in place before pressing each component into place.
2. Push the black plastic “cap thread” (threaded end first) into the centre band. Press this assembly into either end of the upper barrel.

3. Slide the clip over the cap finial and press this assembly into the other end of the upper barrel.
4. Screw the nib into the nib connector, then press the nib connector into the end of the lower barrel with the larger diameter.
5. Press the nib barrel finial into the end of the lower barrel with the smaller diameter.
6. Unscrew the nib and drop the spring, large end first, into the barrel. Removed the cap from the refill and seat the refill into the barrel with the writing nib exposed.
7. Screw the nib back on over the refill.

