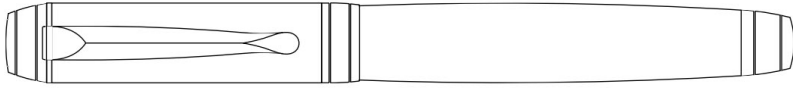


# Beaufort Mistral Rollerball Pen Kit

william wood-write

penblanks.ca



## Needed:

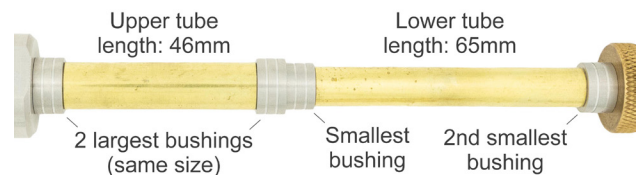
Mandrel A, drills 15/32 and 25/64, bushing MIS-RB-FP-BU

## 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 15/32 drill bit.
3. Drill the blank that will use the longer, thinner tube lengthwise with the 25/64 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 finial and cap centre band have the same diameter. The two largest bushings are identical and can be used in either cap position. The two remaining bushings have different diameters. The larger bushing is for the nib connector end and the smaller bushing 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

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1. Press the accent cabochon into the cap finial. This will be a very tight fit.
2. Push the clip onto the cap finial and press this assembly into the upper (shorter) barrel.
3. When assembling the 3 metal components on the centre band, note that the supplied accent ring has a small chamfer to one side on its inside surface. The accent ring should be fitted with the chamfer nearest to the fixed ring, which will maintain the contour of the assembled centre band and ensure that its two grooves are of equal width. The other loose small ring should be fitted so that its groove is adjacent to the accent ring, not the cap barrel.
4. Once the rings are on the centre band, push the black plastic cap thread into the top of the centre band, inside threaded end first.
5. Press this assembly, cap thread end first, into the upper barrel.
6. On the lower (longer) barrel, press the finial connector into the smaller end of the barrel, and nib connector into the larger end of the barrel.
7. Screw the nib-barrel finial into the finial connector, then insert the spring into the finial connector with the thinner end towards the tube.
8. Insert the refill into the barrel from the nib connector end. Screw the nib on over the refill.

