



Jr Gentleman Pen Kit Instructions

Required Materials

- 7mm pen mandrel
- Set of Jr Gentleman Pen Kit bushings
- 37/64" and 15/32" drill bits
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank of choice (7/8" thickness or larger)
- Pen press, vise, or clamp
- Sanding supplies and finish



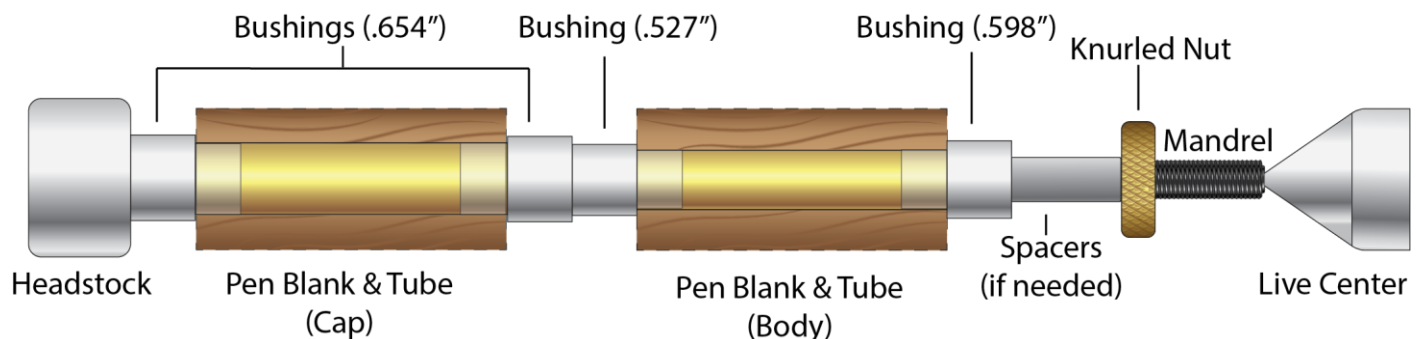
Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 37/64" hole lengthwise through the shorter blank, and a 15/32" hole lengthwise through the longer blank
3. Rub the brass tubes with low-grit sandpaper to roughen them
4. Apply a line of glue to the brass tubes and insert each tube into the middle of the blanks with a twisting motion to spread the glue throughout the blanks
 - Ensure the inside of the tubes are free of any glue
5. Square off the ends of each blank with a barrel trimmer or sander to be flush with the brass tube

Turning the Blank

Follow diagram A below to set up the blanks on the mandrel for turning

Diagram A

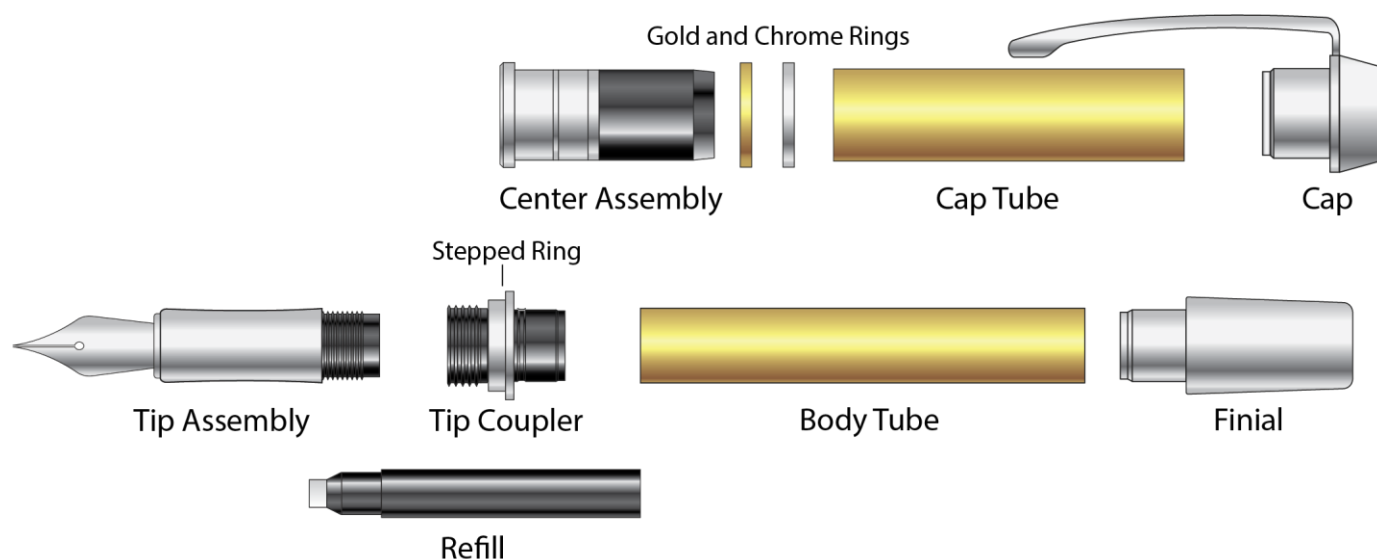


1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish

Assembly

Follow diagram B below for assembly. Press parts using a pen press, vise, or clamp. **Please note that the Lower Tube is threaded inside on one end.** The Upper Tube is unthreaded on both ends.

Diagram B



1. Place the Clip over the Cap and press onto one end of the Cap Tube (shorter tube)
2. If not already done, slide the Gold Ring, then Chrome Ring onto the Center Assembly
3. Press the Center Assembly onto the Cap Tube
4. Press the Finial onto the thinner end of the Body Tube/blank (longer tube)
5. Unthread the Tip Assembly from the Tip Coupler
6. Slide the Stepped Ring, narrower end first, onto the Tip Coupler
7. Press the Tip Coupler onto the thicker end of the Body Tube/blank
8. Insert the Refill (thinner end first) into the Tip Assembly so that it is punctured by the small raised area inside the Tip
9. Thread the Tip onto the Tip Coupler

Additional Information

- Pen uses a standard fountain pen cartridge refill
 - To replace refill, unthread the Tip Assembly