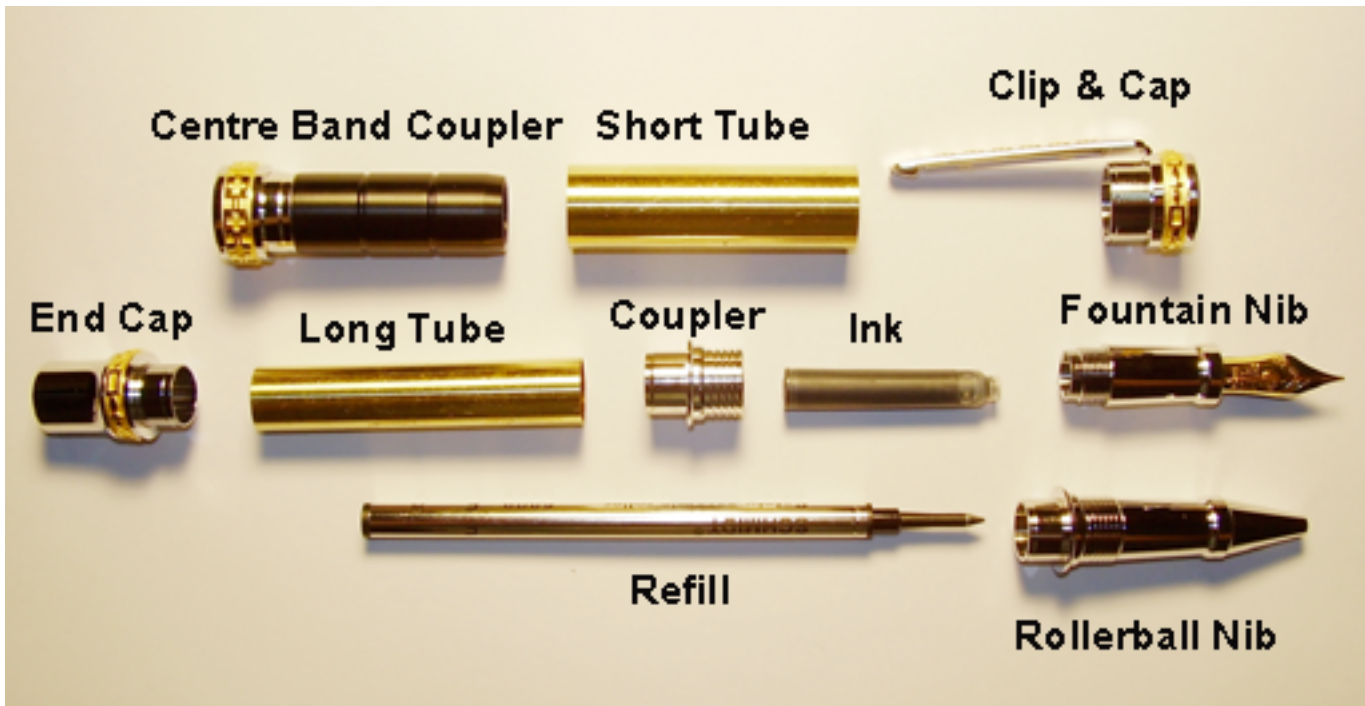


JR EMPEROR



Parts required

Pen mandrel (PM-1 or PM-2)

pen bush (SPB)

27/64" (Q2764)

Pen mill (QPM)

1/2" (Q12)

Sandpaper

GPW Gap filling ca super glue

Preparation

1. Cut the desired blank to 3/4 x 3/4" and slightly longer than the tubes.
2. Drill Through the short blank with 1/2" drill and use a 27/64" for the long tube.
3. Take some coarse sandpaper and rub it on the brass tube to roughen it up, this makes the glue stick better.
4. Trail fit tube in blank before gluing.
5. Glue the tube into the blank with a twisting action to allow even coverage, allow to dry before turning.
6. Mill the ends of the tubes with a pen mill.

Turning

1. Position bushes on mandrel as per diagram above.
2. Turn blank to the top diameter of the bushes.
3. Sand to desired finish, then apply your choice of product to protect the wood such as a friction polish or shellac.

Assembly

1. Press the clip & cap in to the top of short tube.
2. Press the centre band coupler into the other end of the short tube.
3. Press the end cap into the end of the long tube.
4. Press the coupler into the other end of the long tube.
5. For Fountain pen insert ink cartridge or plunger into the nib and screw nib on
For Rollerball insert ink refill and spring and screw nib on.
6. Your Pen is now finished.

