

## Parts Required

Pen Mandrel  
Churchill Bush Set 15-247  
Drill Bits Short Tube 33/64"-13mm  
Long Tube 31/64"- 12.25mm  
Pen Mill  
Pen Drill centring Vice  
Pen Assembly Press

**Caution** should be used when drilling these pen blanks as you are using larger than normal drill bits, there is the chance the blank may break apart when drilling through the bottom of the blank. To overcome this make your blank 16mm longer than required and drill 2mm deeper than is required for the tube to fit in comfortably. Trim the blank to length after drilling.

## Preparation

- 1 Cut the desired blank out of 19mm square timber and 16mm longer than the tubes. Remember they are different lengths and drill sizes.
- 2 Drill lengthwise through the centre of the shorter blank using the 33/64"-13mm drill bit then trim to length and square up the ends.
- 3 Repeat above for the longer blank with the 31/64" drill bit.
- 4 Take some 120g sandpaper and rough up the surfaces of the tube, this makes it stick better when gluing.
- 5 Trial fit in the blank before gluing.
- 6 Glue the tube into the blank with a twisting action to allow for even coverage. Allow to dry overnight before turning.

## Turning

- 1 Place the blanks on the mandrel with the bushes matching the tube sizes.
- 2 Turn the blanks to the top diameter of the bushes.
- 3 Sand to your desired finish then apply your choice of finish.

## Assembly

- 1 Disassemble the nib holder and centre band from the nib parts.
- 2 Press the clip and cap assembly into one end of the short blank then press the centre band into the other end of the short pen blank.
- 3 Press the nib holder into the end of the long blank then press the end cap in the other end of the long blank.
- 4 For the rollerball pen insert the refill then screw the nib assembly into the nib holder, your pen is now finished.
- 5 For the fountain pen kit install the ink cartridge into the back of the fountain pen nib assembly, then screw it into the nib holder, your pen is now finished.

# CHURCHILL ROLLERBALL & FOUNTAIN PEN



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