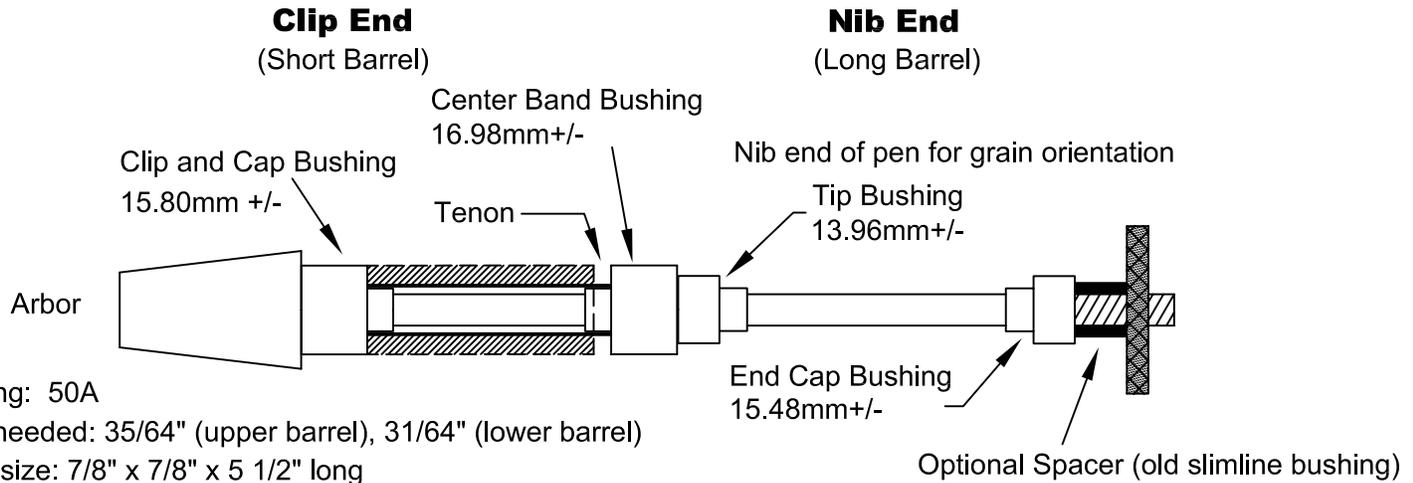


Instructions for the El Presidente Rollerball Pen



Bushing: 50A

Drills needed: 35/64" (upper barrel), 31/64" (lower barrel)

Blank size: 7/8" x 7/8" x 5 1/2" long

1. Slide the clip & cap bushing, upper (short) pen blank, center band bushing, tip bushing, lower (long) pen blank, the end cap barrel bushing and screw the threaded brass thumb nut on to the mandrel. Lightly tighten the brass thumb nut. Carefully slide the tail stock (with a 60° live center installed) up to the concave center of the mandrel and secure. **DO NOT** over tighten or apply excessive force to the mandrel as damage may result! Do not over tighten the brass thumb nut as this can cause the mandrel to bend and cause your pen to come out oval. A spacer may be installed to give you more room between the thumb nut and the last bushing.
2. Turn the **SHORT** barrel blank leaving the wood a little oversize. Cut a 1/8" tenon down to the brass tube in order to mount the **CENTERBAND**. Try not to remove any metal. Now finish turning the short blank to the desired size.
3. Assembly:
 - A. Carefully press the black **PLASTIC SLEEVE**, unthreaded end first, into the centerband end of the **SHORT** brass tube.
 - B. On the same end as the black threaded insert: Press the **CENTERBAND** onto the brass tube where the 1/8" tenon had been cut. Secure with glue if required. Press the **CLIP/CAP** into the other end of the **SHORT** tube.
 - C. Slide the **LARGE TRIM RING** onto the **END CAP** internal step first. The **END CAP** will sit inside the trim ring. Press the **END CAP ASSEMBLY** into the appropriate end of the **LONG** tube.
 - D. Slide the **SMALL TRIM RING** onto the **NIB COUPLER** internal step first. Press the **NIB COUPLER ASSEMBLY** into the other end of the **LONG** tube.
 - E. Insert the **SPRING** into the bottom of the **LONG** tube. Insert the **REFILL** and screw the **NIB** into the **NIB COUPLER**.

