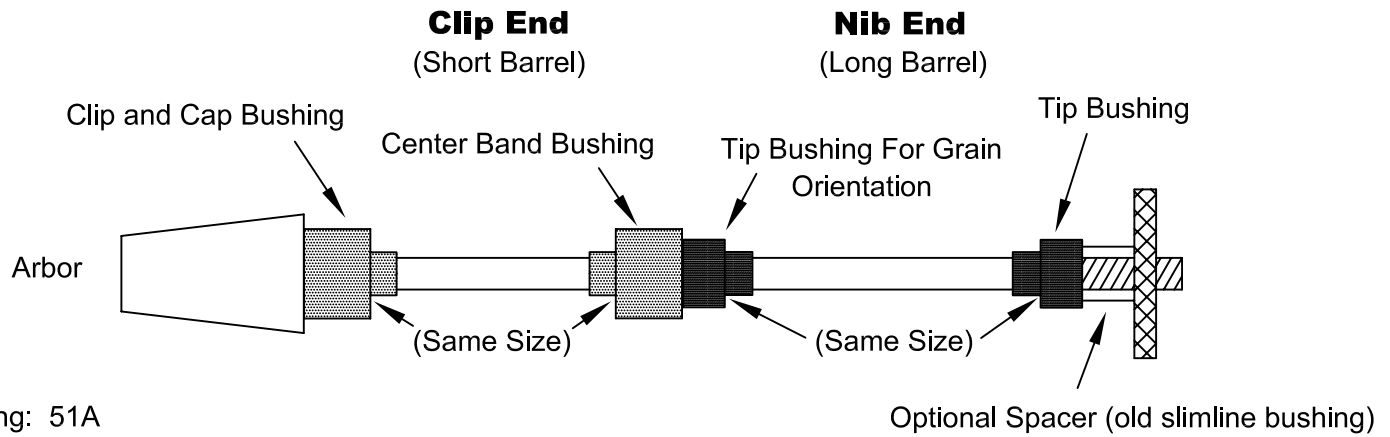


Instructions for the Tropical Baron Fountain and Rollerball Pens



Bushing: 51A

1. Slide the clip & cap bushing, upper (short) pen blank, center band bushing, lower barrel bushing, lower (long) pen blank, the second lower barrel bushing and 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 pen blank to the desired shape using the bushings as a guide. Refer to the separate instruction sheet detailing the procedure for turning the tropical pen blanks.
3. Assembly:
 - A. Slide the CLIP onto the CAP and install into the appropriate end of the short (upper) pen blank.
 - B. Slide the black CENTER BAND COUPLER into the plated CENTER BAND and install the BLACK TRIM RING the PLATED TRIM RING on to the centerband assembly and press into the other end of the short pen blank.
 - C. Press the END CAP COUPLER into the END CAP. Press a COUPLER & TRIM RING into one end of the long pen blank. Note: the couplers are identical.
 - D. Install the SPRING into the END CAP ASSEMBLY (to keep the spring in place apply a drop of silicone seal inside the END CAP). Screw the END CAP ASSEMBLY onto the appropriate end of the long pen blank (as determined by your design).
 - E. Rollerball pen: Insert the REFILL and screw in the ROLLERBALL NIB ASSEMBLY into the COUPLER. Fountain pen: install the ink cartridge / pump into the back of the fountain nib and screw the assembly into the COUPLER. Note: the ink cartridge 'snaps' into place - press firmly into the nib holder..

