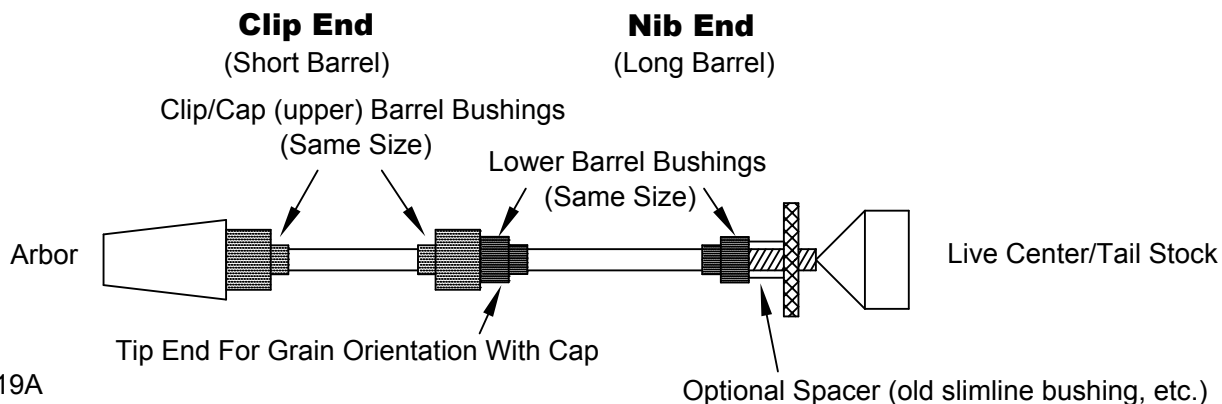


## Instructions for the Sedona Fountain and Rollerball Pens



Bushing: 19A

Blank size: 3/4" x 3/4" x 5" long

Drills needed: 15/32" (upper barrel), 25/64" (lower barrel)

1. Slide a clip/CB bushing, the upper (short) pen blank, the second clip/CB bushing, one 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 overtighten 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. Turn the pen blanks to the desired shape using the bushings as a sizing guide. Sand the blanks and apply your choice of finish.
2. Assembly (helpful hint: Save yourself problems - chamfer the inside edges of each pen tube prior to assembly!):
  - A. Insert the **PEN CLIP ASSEMBLY** into the appropriate end of the short pen blank and press fit. Note: Do NOT disassemble the **CLIP ASSEMBLY**. If this assembly needs to be removed use the Baron Disassembly Kit.
  - B. Slide the black **CENTER BAND COUPLER** (long end first) into the **PLATED CENTER BAND BODY**. Slide the **CENTERBAND** and the **PLATED TRIM RING** on to the **CENTERBAND BODY** and press entire assembly into the other end of the short pen blank. Press fit the **END CAP COUPLER** into the **END CAP**.
  - C. Press a **COUPLER & TRIM RING** into one end of the long pen blank. Press the remaining **COUPLER** and **TRIM RING** into the other end of the long pen blank. Note: the **COUPLERS & TRIM RINGS** 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** into the appropriate end of the long pen blank (as determined by your design and/or grain orientation).
  - E. Rollerball pen: Insert the **REFILL** and screw in the **ROLLERBALL NIB ASSEMBLY** into the **COUPLER**. For the fountain pen: Install the ink cartridge / pump into the back of the **FOUNTAIN PEN NIB ASSEMBLY** and screw the entire assembly into the **COUPLER**.

