

ULTRA-SHEAR™

WOODTURNING TOOLS
by Woodpeckers®

TRITON ROLLERBALL PEN KIT

Instructions for Pen Kit Model Numbers
220046, 220047, 220048



All Pen Kits have different parts. The Pen Kit and the finished pen shown are for reference of the part names and may not fully resemble the Pen Kit you have purchased.

SUPPLIES NEEDED:

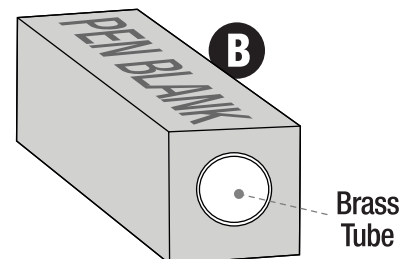
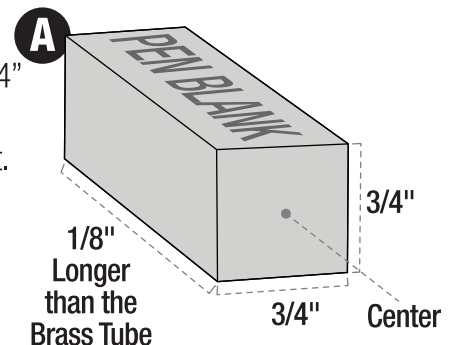
- 12.5mm Drill Bit (Part # ND-21941)
- 10.5mm Drill Bit (Part # ND-21901)
- 3/4" x 3/4" Pen Blank
- Triton/Atrax Pen Kit Bushings (Part # 220234 or 25010)
- Replacement Tubes (Part # 220189)
- Ultra-Shear Pen Mandrel (Part # USPMD)
- Ultra-Shear Pen Mill-Ci (Part # PMCIDLX)

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You can also call us at 800-752-0725 from 9:00 a.m. to 5:00 p.m. EST Monday - Friday.

PREPARING THE PEN BLANK/BRASS TUBE ASSEMBLY

1. This is a two blank kit. The larger diameter tube is the cap. Cut the material blank 1/4" longer than the brass tube. Excess will be cleaned up in a later process.
2. Drill the cap blank with a 12.5mm drill bit. Drill the body blank with a 10.5mm drill bit. Typical speed will be between 900 to 1,200 RPM. **FIG A.**
3. Scuff the brass tube to eliminate any debris and this will rough up the tube for better adhesion.
4. Apply epoxy or CA glue to the brass tube and twist as it is inserted to insure proper coverage. Make sure you have the brass tube fully inserted and not sticking out the other end of the material blank. **FIG B.**



5. Square the ends of the blanks to the brass tube. This process utilizes the Ultra-Shear Pen Mill. Place the material blank in a drill press vise and after selecting the proper reamer clean out the inside of the tub at the same time as you square the ends. **FIG C & D.**

!! COMMON ISSUES !!

- **Proper material blank length. Your pens operation depends is dependent on having the proper length tubes.**
- **Not cleaning out all the glue from the tube causes pen failure.**

TURNING THE MATERIAL BLANK

1. Assemble the blank on the Ultra-Shear Pen Mandrel using the proper bushings. The larger bushings (both are the same size) are for the cap end bushing the next to largest is for one end of the body and the smallest bushing goes on the Nib end. No need to over tighten. **FIG E.**
2. Turn the blank to the desired contour, making sure the area next to the bushing is turning to the diameter of the bushing.
3. After turning the material blank, sand the surface in progressive steps. Depending on the material blank, wood, acrylic, hybrid you use a variety of sandpaper.
4. Apply the finish of your choice and polish.

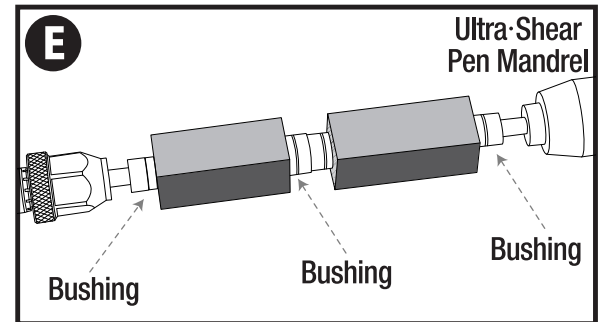
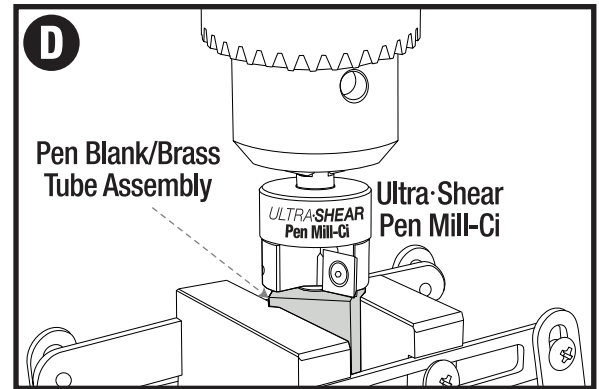
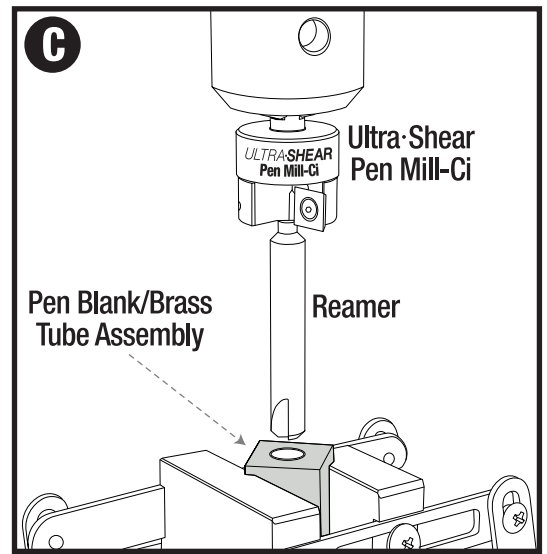
ASSEMBLE THE PEN *Please refer to the Pen Parts Diagram on page 1.*

!! COMMON ISSUES !! *Pen operation is dependent on properly aligned parts. The use of a good pen press or small arbor press is recommended, but it can be accomplished with a good "C" clamp and much care. When pressing in the various parts, by any means, BE SURE that the parts are straight and in line with the blanks. If the part is cocked or otherwise misaligned, at the very least, a poor fitting pen will result. Exercise caution here!*

One other word about pen parts. Occasionally, you will encounter parts that are a little loose fitting. This can be corrected by using a SMALL spot of LOCTITE on these parts before pressing them home. CA and Epoxy can affect the finish.

On this particular pen there is a small difference from others you may have made. The Stop Rings, used on the barrel couplers, are different sizes. The one for the nib end is the larger one. Make sure you get them in the right orientation when you assemble the pen.

1. Place the Center Band over the smaller, threaded end of the black Threaded Insert.
2. Press the Center Band/Threaded Insert Assembly into one end of the Cap blank.
3. Slide the Clip over the Finial and press this into place on the other end of the cap. Be sure to orient the clip to your preference before pressing. Now, lay the cap aside.
4. Assemble the LARGER Stop Ring onto one of the barrel couplers. The smaller end of the Stop Ring goes closest to the threads.
5. Press the Coupler/Stop Ring Assembly into the larger end of the Body blank.
6. Assemble the SMALLER Stop Ring onto the other Coupler. The smaller end of the Stop Ring goes closest to the threads.
7. Press this Assembly into the other end of the Body blank.
8. Screw the End Cap into place.
9. Drop the Spring , large end first into the open end of the body tube. Remove the cap on the Ink Refill and insert into the body tube.



10. Screw the Nib into place.
11. Place the cap on the pen.
12. ***Congratulations, your pen is complete.***

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