

SEAM ROLLER KIT

Kit Features

- Easy to Turn with Straight Tube
- Minimal Parts--easy to assemble
- Overall Length: 4-23/32"

Required Accessories

- 7mm Pen Mandrel
- Drill Bit: #PK-7MM for Wood, #PK-7MMMSG for plastic
- Bushing Set(2pc): #PKSROLLBU
- Barrel Trimming: #PKTRIM734 or Barrel Trimming Jig on a Disc Sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 7/8" x 7/8" x 3-5/16"L

Preparing the Blank:

- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill a 7mm hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 7mm Barrel Trimer with a 3/4" cutting head (#PKTRIM734) or a pen blank squaring jig on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with assembly. Use a barrel trimmer to clean the inside of the tube.



DIAGRAM B / TURNING THE BLANK



Turning the Blank:

- Mount the bushings and blanks according to diagram B.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To use Knurled Nut Setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- Thread on the Knurled Nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple.
- Lock Tailstock and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel straight or to a profile of your choice. Note that the Roller Bracket is flat and rectangular (bushing matches the shorter width), a rounded end will blend better than a flat one.
- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish manufacturer's instructions.

Knurled Nut Setup

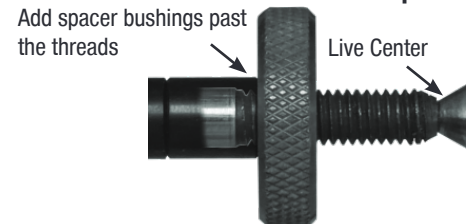


Diagram C / Bushing #PKSROLLBU

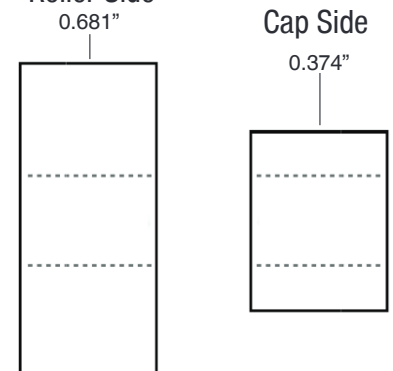
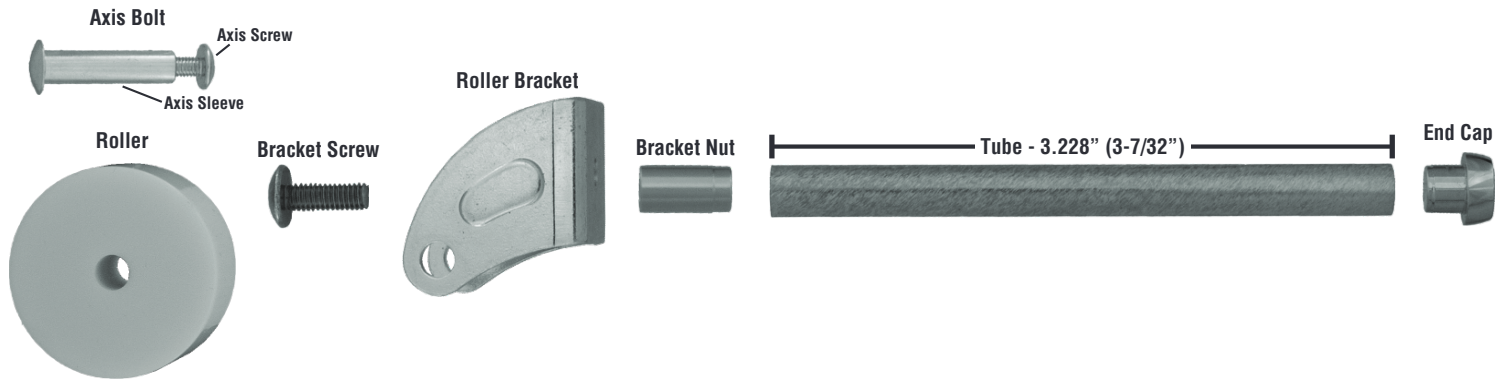


Diagram D / Parts Layout

**Assembly:**

- Press Bracket Nut, reduced diameter first, into larger diameter end of Barrel.
- Press End Cap into opposite, open end of Barrel.
- With the Roller off, thread Bracket Screw through the Bracket and into the Bracket Nut; tighten with screwdriver.
- Slide the Roller into the Bracket, lining up the hole in the Bracket with the hole in the Roller.
- Slide the Axis Sleeve through the Bracket and Roller and thread the Axis Screw into the Sleeve on the other side of the Bracket; tighten with screwdriver.