

Berea Hardwoods Co., Inc.  
Pen Instructions

## **Rinehart Roller Ball and Fountain Pen. Berea #0405H+(x+x+xx)**



Needed: Mandrel-A  
Bushing-19A  
Drill-15/32" and 25/64"  
Wood Size- 3/4" x 3/4"

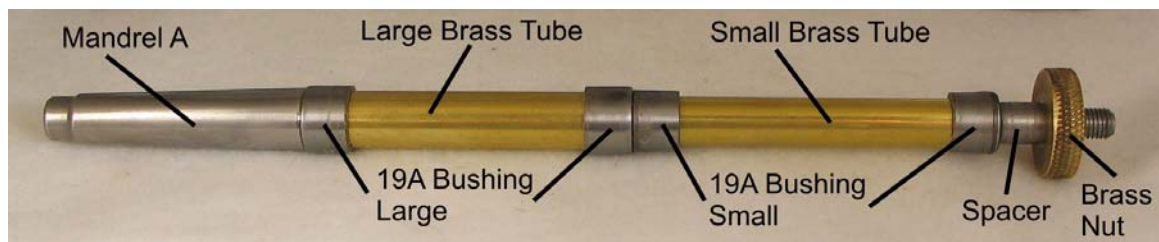
The Rinehart is a beautiful pen and also very easy to make. It is available in both a roller ball, illustrated, and a fountain pen. The construction for both is the same.

### **Preparing the Material Blanks**

1. Cut your material blanks about 1/8" longer than the brass tubes to allow for squaring the tube on the ends.
2. Drill the shorter of the blanks, the cap blank, with the 15/32" bit.
3. Drill the longer blank, the barrel blank, with the 25/64" bit.
4. Polish the brass tubes with sandpaper. This can be done by hand or on a power machine such as a belt sander. The purpose of the sanding is to clean off the oxidation and roughen the tube so that the glue will have a better adhesion surface.
5. Plug the ends of the tubes with the material of your choice. Some use base wax or Play Dough or even a slice of potato. Just push the ends of the tubes into a thin section of the material. This will form a plug to keep the glue from getting into the tube.
6. Clean the tube, after plugging, with acetone or alcohol on a rag.
7. Prepare your glue. We recommend two-part epoxy glue that is available in all hardware stores. Use a fast drying type, one hour or less. Be sure to mix it thoroughly. (A Post-it Note Pad makes an excellent mixing place. When you are

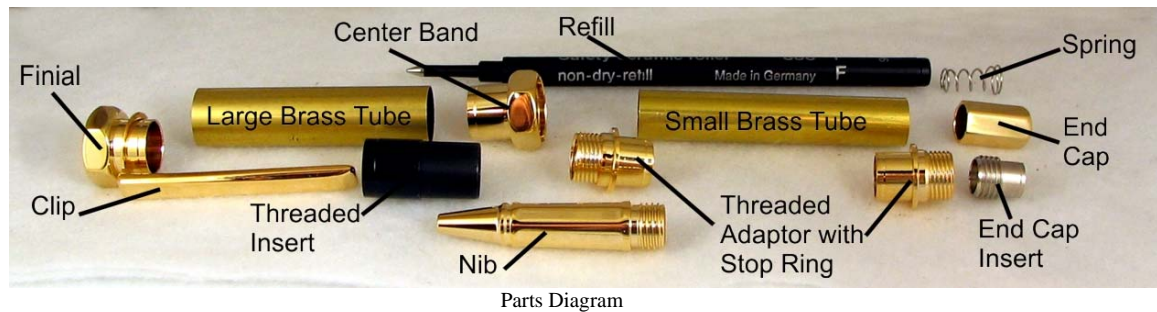
- finished just tear it off and throw it away.) Polyurethanes and thick flexible CA's can be used, but they each have their drawbacks.
8. Place some of the epoxy into the blank using a small piece of dowel or other small stick.
  9. Roll the appropriate tube in the epoxy.
  10. Insert the tube with a twisting motion until it is almost in the material blank. Then use the dowel to push it until the end is flush with the blank. Use the stick to rake off the excess glue even with the blank and the tube.
  11. Push the brass tube through the blank until the other end is flush with the blank. Then rake the glue flush with that end. Now push the tube back into the blank until the tube is equidistant between both ends of the blank.
  12. Move it aside for 60 minutes until the epoxy has had time to reach its maximum strength.
  13. If you are using CA glue, the wait is much shorter. When using polyurethane the wait will be about 24 hours.
  14. When the glue has cured, use a hobby knife to remove the plugs from the ends. It is also a good idea to clean the tubes with a brass gun cleaning brush or a rolled up piece of sandpaper to remove any glue that may have gotten into the tubes.
  15. Not cleaning out all glue from the tubes is the most common cause of pen failure. BE CERTAIN that all dried glue is removed from inside the tubes before proceeding.
  16. Using a barrel trimmer of the proper size, face off the ends of the blanks until you can just see bright brass. STOP facing at this point. Your pen's proper operation is dependent on having the proper length tubes. This facing operation can also be done with the proper jig and a disk or belt sander.
  17. Not having the proper tube length is the #2 cause of pen failure. Sanding, on a disk sander, using a jig to hold the tube square with the disk, is a more sure way of getting the proper length. It should be tried if you have any doubt as to your abilities to square the material with the barrel trimmer.
  18. Another good method of squaring the ends of the blank is to turn the blank until it is just round. Using a miter gauge to maintain the blank perpendicular to the sanding disk, just touch the ends to the disk. Once the blanks are square and you can see the ends of the tubes brighten, then return the blanks to the mandrel and finish the turning until the desired contour is accomplished.

### Turning the Blanks



1. Assemble the blanks on the mandrel with the right bushings in the right place. The right bushing can be found by comparing the diameter of the bushing to the piece of hardware that will be placed in that place. For instance, the bushing that is the same size as the clip will fit on the end of the blank that will eventually become the top of the cap.

2. Tighten the tailstock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks.
3. Turn the blanks to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
4. After turning the blank, sand the surface in progressive steps until you get to 400 or 500 grit.
5. If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
6. Remove the blanks from the mandrel.



### Assembling the Pen

Please refer to the Pen Parts Diagram

1. Press one of the threaded adaptors with the stop ring attached, they are both identical, into each end of the longer, barrel, blank.
2. Next press the end cap insert into the end cap.
3. Screw this assembly into the blind end of the barrel.
4. If making a roller ball pen drop the spring into the barrel from the open end. If making a fountain pen, then attach the cartridge to the nib.
5. If making a roller ball pen insert the refill and screw on the nib. If making a fountain pen simply screw the nib and cartridge assembly into the open end of the barrel blank.
6. Lay this assembly aside.
7. Push or press the threaded insert into the center band from the rear of the center band. Be sure the threaded portion is facing toward the front of the center band.
8. Now, press this assembly into the appropriate end of the barrel blank.
9. Slide the pocket clip onto the finial.
10. Align the clip where you want it positioned and press the finial into the other end of the cap blank.
11. Screw the cap on the barrel and admire your work.