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EXOTICBLANKS Band-It C Series Standard Banding Tool

Band-It, C Series, Diamond Knurl, Jr. Aaron, Jr. Antony, Jr. Citizen, Jr. Gent II, Jr. Gentleman, Jr. George, Jr. Harold, Jr. Milton, Jr. Morgan, Jr. Statesman II and Jr. Retro, Fountain and Rollerball Pen Kit Assembly Instructions

REQUIRED ACCESSORIES

- 7mm Adjustable or Long Mandrel
- Live 60-degree Tailstock or Mandrel Saver
- Jr. II Series (4 Piece) Bushing Set DKB-JR2
- 12.5mm Drill Bit
- 10.5mm Drill Bit
- Blank Size: Minimum ¾" x ¾" x 5
- Two Part Epoxy Glue or CA (cyanoacrylate) Glue

- 7mm Barrel Trimmer or Disc Sander
- Sandpaper: Standard and Micro Mesh
- Pen Press or Clamp
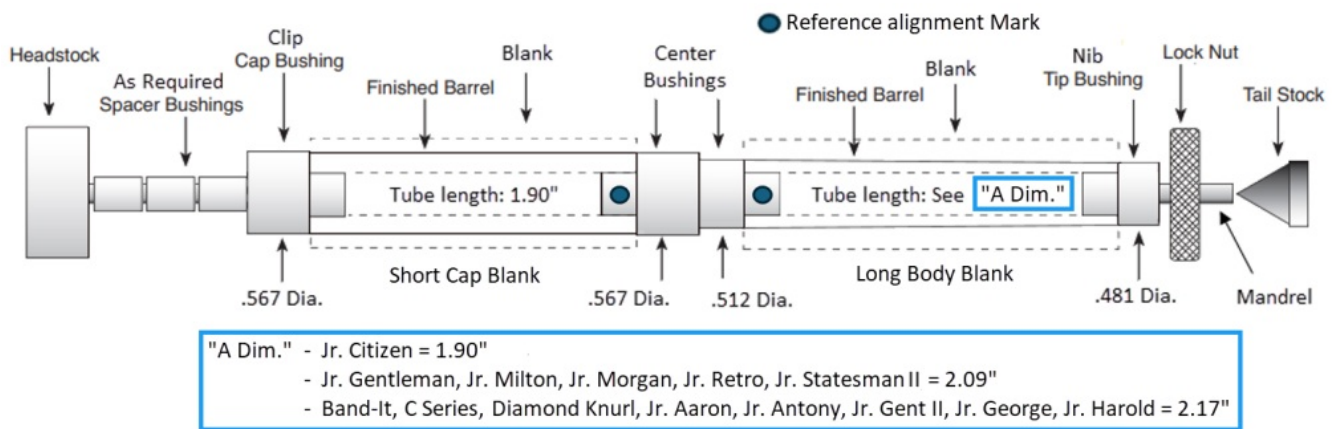- Eye, Ear & Dust Mask Protection

PREPARING THE BLANKS

1. To prepare the Blank for drilling, draw a line lengthwise on the Blank with a permanent marker near the cut line. This provides a visual reference to maintain proper grain or pattern alignment. Cut two sections to the length of each Tube, adding 1/4" for squaring off.
2. Mark the center of each blank's end. This will determine the drilling location.
3. Drill Wood Blanks at 2,000 – 3,000 rpm and Larger bits or Resins at 250 – 500 rpm. Drill the holes through the center of the Blanks stopping an 1/8″ short of the bit exiting each Blank. This will eliminate a Blank blowout.
4. Drill a centered 12.5mm hole lengthwise through the Upper Shorter Tube Blank. Drill a centered 10.5mm hole lengthwise through the Lower Longer Tube Blank. Caution: Excessive pressure will cause the drill bit to wander and/or split the Blank. Slow the feed rate and back the bit out repeatedly for chip removal.
5. Trim away the small amount from the ends of each Blank to expose the hole.
6. Roughen the length of the outside Brass Tubes with 220 grit sandpaper to clean off the oxidation. This provides better glue adhesion. Wipe the brass residue off each Brass Tube. Trail fit each Tube in the Blanks before gluing.
7. To keep the glue from getting into the Tubes, plug both ends of the Tubes with a material of your choice. We recommend base plate wax. Push the Tube ends into a

thin section of the material to seal each end. Wipe the residue left on the Brass Tube with acetone or alcohol on a clean, dry towel.

8. Glue each Tube into the proper Blank. Put a liberal coating of glue on one Brass Tube. Working quickly, insert the Tube halfway into the Blank with a twisting motion to spread the glue evenly inside, then remove itfrom the Blank.

9. Put a little more glue on the Tube and insert it into the opposite end of the Blank. Align each Tube lengthwise just inside the Blanks. Continue with the other Tube.

10. Once the Brass Tubes are glued in place, set the Blanks aside for a day or so to give the glue time to set completely.

11. When the glue is cured, use a hobby knife to remove the plugs and glue from the ends.

12. Use a Barrel Trimmer or a power disc sander to trim the excess material flush with the ends of the Brass Tubes. Trim the ends of the Blanks until you can just see the bright brass ends of the Tubes. The trimmed ends must be 90 degrees flush to the ends of the Brass Tubes. Do not trim past the end of the Tube.

13. The faces of the ends must be perpendicular to the Brass Tubes and parallel with each other. It is imperative that the length of the trimmed blanks match the original length of the Brass Tubes and that the insides of the Brass Tubes are clean and free of any glue. Any excess glue left inside will split the Blanks during assembly.

TURNING THE BLANKS

14. Use a permanent marker, place a Reference alignment "MARK" ● inside the Tubes to align the Blanks' grain or pattern at the original cut line.

15. Mount the Bushings and Blanks on the Mandrel, make sure that your reference "MARKS" ●meet at the Center Bushings. This will maintain the proper blank's grain or pattern alignment on the Pen Mandrel as displayed below.

16. Thread the knurled Lock Nut on to Pen Mandrel and hand tighten it to hold all the components in place.

17. Slide the Tail Stock up snugly against the Mandrel Shaft, inserting the Live Tail Stock Center Point into the Mandrel's end Dimple. If using the Mandrel Saver, insert the Mandrel into its hole. Lock the Tail Stock in place. (Do not overtighten, it could damage the Mandrel). Excessive pressure may also crack the Blanks.

18. Using sharp tools, turn the Blanks down to a diameter slightly larger than the Bushings. As you approach the final size, be cautious, as the Blank may be very thin. (Turn them straight or to a profile of your choice.)

Headstock | As Required Spacer Bushings | Clip Cap Bushing | Finished Barrel | Blank | Center Bushings | Reference alignment Mark | Finished Barrel | Blank | Nib Tip Bushing | Lock Nut | Tail Stock

Tube length: 1.90"

Tube length: See "A Dim."

Short Cap Blank

Long Body Blank

.567 Dia.   .567 Dia.   .512 Dia.   .481 Dia.   Mandrel

"A Dim." - Jr. Citizen = 1.90"
- Jr. Gentleman, Jr. Milton, Jr. Morgan, Jr. Retro, Jr. Statesman II = 2.09"
- Band-It, C Series, Diamond Knurl, Jr. Aaron, Jr. Antony, Jr. Gent II, Jr. George, Jr. Harold = 2.17"
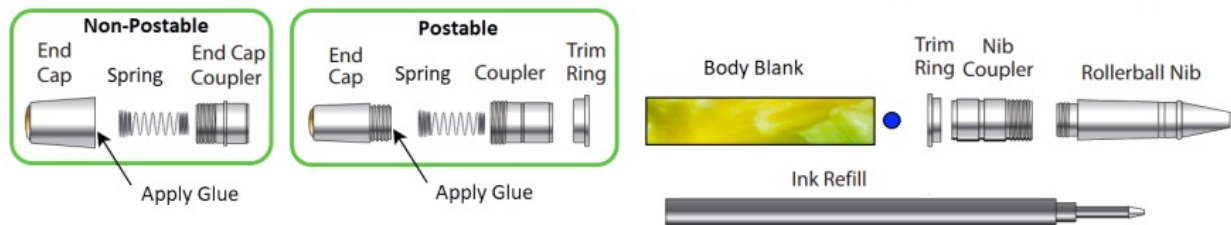
FINISHING THE BLANKS

19. Sand the Blank down flush with the Bushings, gradually increasing the sandpaper grits.

20. Sand wood Blanks from 120 to 600 grit paper. For Resin Blanks continue sanding with Micro Mesh from 1,500 to 12,000 grit. Woods and Resins require different methods to achieve better results.

21. Use a finish of your choice but be careful if using a CA or Polyurethane, etc. The Tubes may stick to the Bushings, and Mandrel. Use Non-stick Finishing Bushings to eliminate the sticking, as finish is applied.

22. Remove both Blanks from the Mandrel, lay them end to end, and align the Blanks as you determined when assembled. If necessary, a light sanding of the ends on a sanding block will square the ends and improve the fit during assembly. Finish the ends of the Blanks with thin CA to seal the blanks.
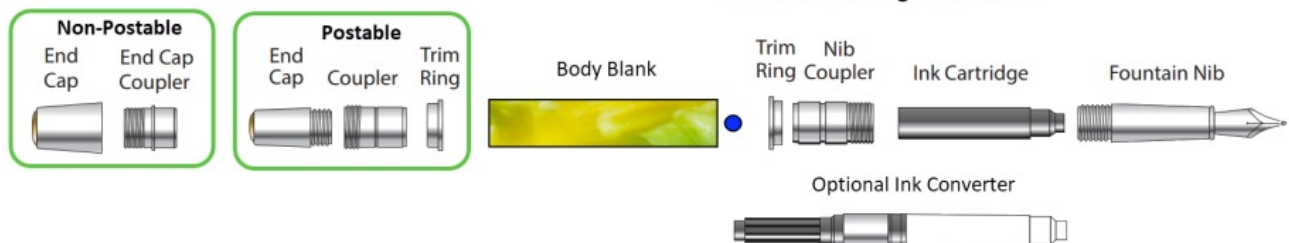
ASSEMBLING THE KIT

Layout the parts as shown below. Align the kit Blanks in the same orientation as determined on the Mandrel when the pen Cap and Body will be assembled. The Body of the kit should be assembled first. End Caps have 2 options available.
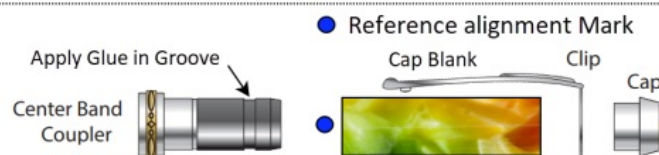
Rollerball Assembly

Non-Postable: End Cap, Spring, End Cap Coupler — Apply Glue

Postable: End Cap, Spring, Coupler, Trim Ring — Apply Glue

● Reference alignment Mark

Body Blank, Trim Ring, Nib Coupler, Rollerball Nib

Ink Refill

Fountain Assembly

Non-Postable: End Cap, End Cap Coupler

Postable: End Cap, Coupler, Trim Ring

● Reference alignment Mark

Body Blank, Trim Ring, Nib Coupler, Ink Cartridge, Fountain Nib

Optional Ink Converter

Cap Assembly

● Reference alignment Mark

Apply Glue in Groove

Center Band Coupler

Cap Blank, Clip, Cap

23. Rollerball Assembly: Place a drop of CA into the End Cap. Drop the Spring, wide end first into the End Cap. Allow it to dry.

24. Press your desired End Coupler and Trim Ring (These may be assembled) or just the End Cap Coupler, into the Smaller turned end of the Long Body Blank, opposite the Reference alignment Mark.

25. Press the Larger Nib Coupler and Trim Ring (These may be assembled), into the Larger turned end of the Long Body Blank, at the Reference alignment Mark ● .

26. Thread the End Cap onto the End Cap Coupler.
    Skip to Step 27) Cap Assembly: Instructions.

27. Fountain Assembly: Press your desired End Coupler and Trim Ring (These may be assembled) or just the End Cap Coupler, into the Smaller turned end of the Long Body Blank, opposite the Reference alignment Mark.

28. Press the Larger Nib Coupler and Trim Rung (These may be assembled), into the Larger turned end of the Long Body Blank, at the Reference alignment Mark .

29. Thread the End Cap onto the End Cap Coupler.

30. Attach either the Ink Cartridge or an Optional Ink Converter to the back of the Fountain Nib.
    Skip to Step 27) Cap Assembly: Instructions.

31. Cap Assembly: Thread the Center Band Coupler onto the Body Nib Coupler, as if you were closing the pen.

32. Slide on, do not press the Cap Blank onto the Center Band Couplers black plastic

piece.

33. Rotate the Cap Blank until the proper grain or pattern alignment matches from the Body Blank to the Cap Blank.

34. Mark this alignment location with tape.

35. Once grain or pattern alignment is satisfactory, unthread the Center Band Coupler from the Body Nib Coupler.

36. Remove the Cap Blank from the Center Band Coupler, retaining the alignment.

37. Place a very small dab of thick CA glue in the Glue Groove of the Center Band Coupler and inside this Tube.

38. Quickly, align the Cap Blank grain or pattern, press this Center Band Coupler, black end first into the Cap Blank, at the Reference alignment Mark ●.

   Skip to Step 35) Final Assembly: Instructions below to complete the pen assembly.

39. Final Rollerball Assembly:

40. Insert the Refill into the Nib Coupler. Thread the Rollerball Nib onto the Nib Coupler.

41. Slide the Clip onto the Cap, then press these into the Short Cap Blank, opposite the Reference alignment Mark.

42. Screw the Cap onto the Body and admire what you have accomplished.

43. Final Fountain Assembly:

44. Thread the Fountain Nib and Ink assembly onto the Nib Coupler.

45. Slide the Clip onto the Cap, then press these into the Short Cap Blank, opposite the Reference alignment Mark.

46. Screw the Cap onto the Body and admire what you have accomplished.

Additional Information

- To change the Refill unthread the Nib, remove the old Refill, replace with a new Refill and thread the Nib back on.
- When writing, the Cap will post onto the End Cap of the Body if the Postable End Cap was chosen.
- When the pen is not being used, screw the Cap over the Nib.

FAQs

Q: What should I do if my blanks crack during turning?

A: If your blanks crack during turning, reduce pressure on the tools and work slowly to avoid damaging them.

Q: Can I use different types of ink cartridges with this pen kit?

A: Yes, you can use different types of ink cartridges or opt for an ink converter for flexibility in ink choices.

Documents / Resources

	[EXOTICBLANKS Band-It C Series Standard Banding Tool](#) [[pdf](#)] User Guide r. Aaron, Jr. Antony, Jr. Citizen, Jr. Gent II, Jr. Gentleman, Jr. George, Jr. Harold, Jr. Milton, Jr. Morgan, Jr. Statesman II, Jr. Retro, Band-It C Series Standard Banding Tool, Band-It C Series, Standard Banding Tool, Banding Tool, Tool

References

- [User Manual](#)

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