

Xiamen Rizheng Industry Co.,Ltd

Woodworker Jr.Gentlemens Pen Kits Assembly Instructions

Required Accessories:

- 7mm pen mandrel
- 4-piece bushing set RZ- BP54#-BU
- 15/32" Drill Bit RZ-DB15/32
- 25/64"Drill Bit RZ-DB25/64
- 2*2*13cm pen blank
- Universal barrel trimmer
- 2-part epoxy glue or insta-cure glue (cyanoacrylate).

Preparing the Blank:

- Prepare a master blank of at least 3/4" square.Cut two sections to the length of each tube. (Add 1/16" for trimming)

Mark the center of each blank.

- Drill a centered hole lengthwise through each blank.

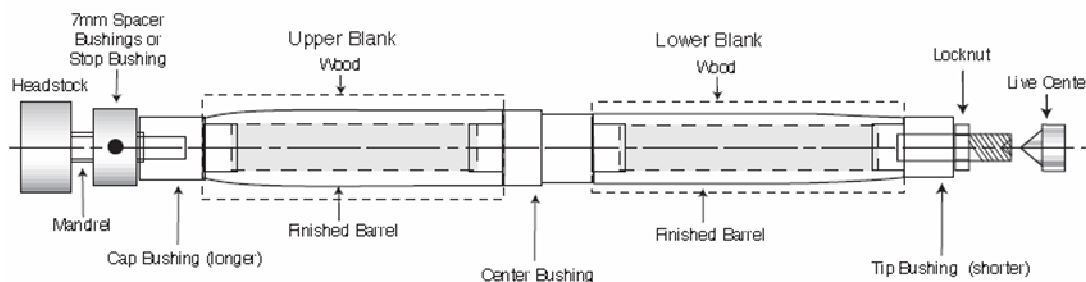
Upper blank (shorter tube)—drill a 15/32"hole through.

Lower blank (longer tube)—drill a 25/64" hole through.

- Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside.Center each tube lengthwise inside the blank.

- When glue dries, square the ends of each blank.Using a 7mm barrel trimmer with adapter sleeves, mount the proper sleeve (large diameter for the short tube, smaller diameter for the longer tube) over the shank with the brass tube.

Turning the Blanks



Turning the Blank

- Mount 7mm spacer bushings on the mandrel followed by the tip bushing (shorter diameter) wide end first.
- Slide the lower blank (long) on next. Follow with the center bushing, narrow diameter first, Slide on the upper blank (short) and follow with the cap bushing, narrow end first. Add additional spacer bushings as necessary to overlap the mandrel. Thread on the lock nut

hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel).

- Turn the blanks down close to the bushings. Follow with abrasives until the tube diameters are flush with the bushings
- Finish with your choice of polish.

DIAGRAM A -- Assembly



Assembly

NOTE: Line up the components according to DIAGRAM A.

- Press the center band into the upper barrel (shorter tube).
- Place the clip to the cap assembly and then press into the opposite end of the upper barrel.
- Press the twist mechanism into the brass cap assembly through the upper barrel.
- Press the lower tube to the center band.
- Place the refill with spring inside barrel.
- Finally press the tip into the lower barrel to complete the pen