

# Xiamen Rizheng Industry Co.,Ltd

## REQUIRED ACCESSORIES

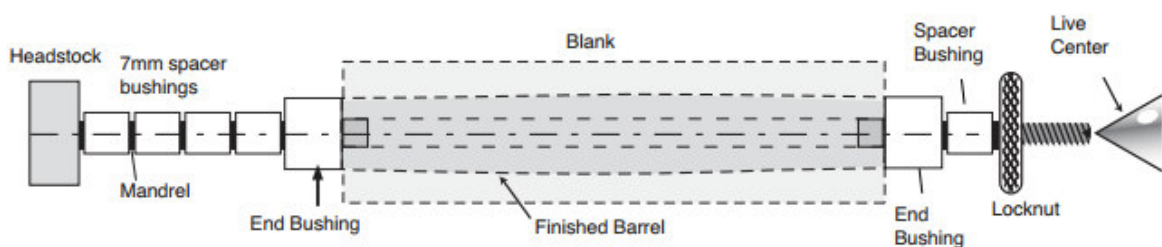
- 7mm Pen Mandrel
- 2 piece Bushing Set RZ-PCL134#-BU
- 3/8" Drill Bit RZ-DB3/8
- Barrel Trimming set (with 3/8" shaft RZ-PM013)
- 2 part epoxy glue or insta-cure (cyanoacrylate) glue

## REPARING THE BLANKS

- Cut 3/4" to 5/8" square blank to the length of the brass tube (add 1/16" for squaring off).
- Drill a 3/8" center hole lengthwise through the blank.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When the glue dries, square the ends of the blank. Use a 3/8" barrel trimmer to square the ends. Take the wood down flush to the brass tube

## TURNING THE BLANKS

- Place three or four standard 7mm bushings onto the mandrel, followed by an end bushing—wide end first—then the wood blank followed by the other bushing, insert with narrow end in first. Use additional spacer bushings to fill the space on the shaft up to the threads.
- Thread on the lock nut and hand tighten to hold all items in place.
- Slide the tailstock to the mandrel shaft (do not overtighten, it could damage the mandrel). Lock in place.
- Turn the wood down, flush with the bushings using lathe tools, gradually increasing the grades of sandpaper.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.



## PEN ASSEMBLY

- Press the coupler, recessed end in first into either end of the barrel.
- Screw the click mechanism into the clip assembly .
- Press the clip assembly into the opposite end of the barrel.
- Affix the spring over the tip of the refill.
- Drop the refill into the opening at the front assembly.
- Screw the tip over the refill, into the front assembly.
- Put the click spring into the clip assembly, Thread the plunger over the shaft of the clicker mechanism at the opposite end.

- The pen works by clicking on the plunger to advance or retract the refill tip.

