

# Xiamen Rizheng Industry Co.,Ltd

## AMC Classic Twist Pen Kits Assembly Instructions

### REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- 8.8mm Drill Bit
- 3pc Bushing Set RZ-BP115#-BU
- Universal Barrel Trimmer Set
- 2 part epoxy glue or insta-cure (cyanoacrylate)

### PREPARING THE BLANKS:

1. Cut 5/8" square or larger blanks to the length of the brass tubes (add 1/16" for squaring off).
2. Drill a 8.8mm-centered hole lengthwise through each blank.
3. Spread glue over the tubes; insert into the blanks with a twisting motion to spread the glue evenly inside. Center the tubes lengthwise inside the blanks.
4. When the glue dries, square the ends of the blank. Use a 7mm barrel trimmer to take the wood down flush to the brass tubes.

### TURNING THE BLANKS:

1. Place spacer bushings onto the mandrel. Place the tip bushing on next, follow with the lower (longer blank). Then place the center bushing on small diameter on first. Follow with the upper blank (shorter). Place the cap bushing on next. Screw on the lock nut hand tight. Bring the tailstock into the mandrel. Lock into place. Tighten the lock nut (do not overtighten, it may damage the mandrel).
2. Turn the wood down to the diameter of the bushings using chisels and abrasives. Taper the lower blank. Follow diagram 'B' for profile. Form a straight line between the bushings on the upper barrel. Test to be sure the filigree tube fits snug over the barrel. Finish the barrels.

