

Xiamen Rizheng Industry Co.,Ltd

Rifle Rollerball Pen Kits Assembly Instructions

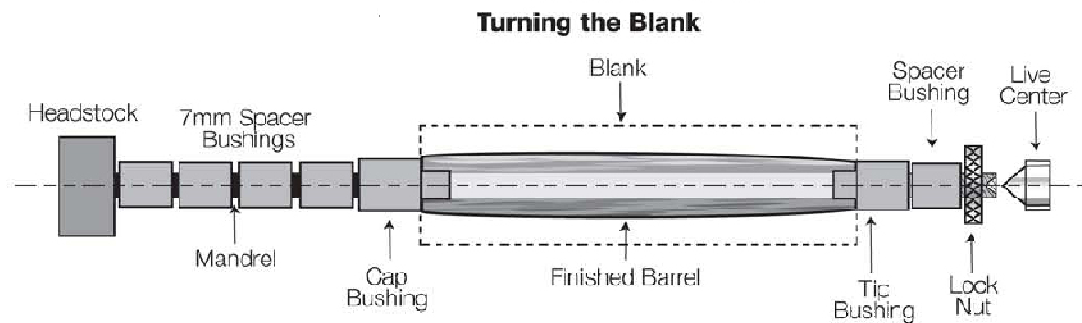
REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- 10 mm Drill Bit
- 2 pc Bushing Set RZ-RP190#-BU
- 10 mm Barrel Trimmer Set
- Glue (Thick CA or Epoxy)



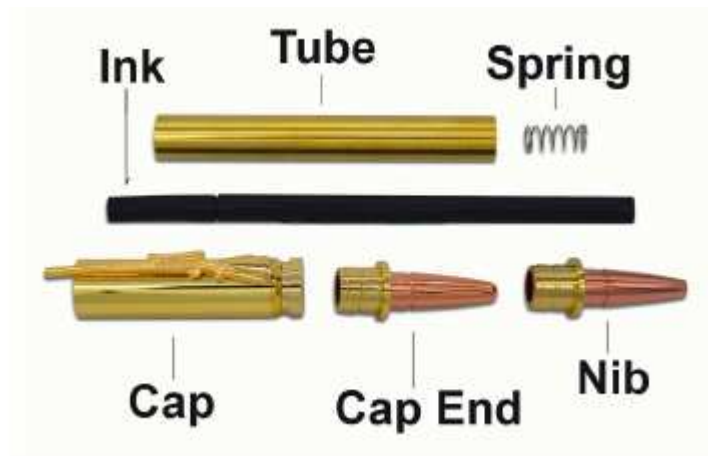
PREPARING THE BLANKS:

1. Cut 3/4" square or larger blanks to the length of the brass tubes (add 1/16" for squaring off).
2. Drill a 10mm-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 10 mm barrel trimmer to take the wood down flush to the brass tubes.



TURNING THE BLANKS:

1. Place spacer bushings onto the mandrel. Place the cap bushing on next, follow with the blank. Next place the tip bushing. Screw on the lock nut hand tight. Bring the tailstock into the mandrel. Lock into place. Tighten the lock nut (do not over-tighten, it may damage the mandrel).
2. Turn the blanks down close to the bushings. Follow with abrasives until the tube diameters are flush with the bushings
3. Finish with your choice of polish.



Assembly

- 1) Begin by pressing the Nib into the proper end of the blank. You can unscrew the copper end from the bass coupler for more control while pressing the pieces together. Once complete screw copper end back onto coupler.
- 2) Next press the Cap End into the other end of the blank. You can unscrew the copper end from the bass coupler for more control while pressing the pieces together.
- 3) Remove (unscrew the copper end) of the endcap and insert the ink. Place the Spring on the flat end of the ink and screw the copper part of the end cap back in place.
- 4) Place the cap on the desired end and you are done.