

Xiamen Rizheng Industry Co.,Ltd

Elegant American Ball Pen Kits Assembly Instruction

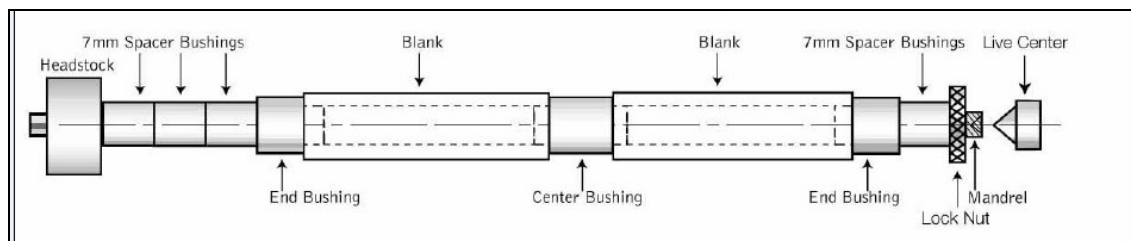
REQUIRED ACCESSORIES

- 7mm, Long Mandrel.
- 3 Pc. Pen Bushing Set RZ-BP72#-BU
- 8mm Drill Bit RZ-DB008
- Barrel Trimmer
- 2 Part Epoxy Glue or Insta-Cure (cyanoacrylate).



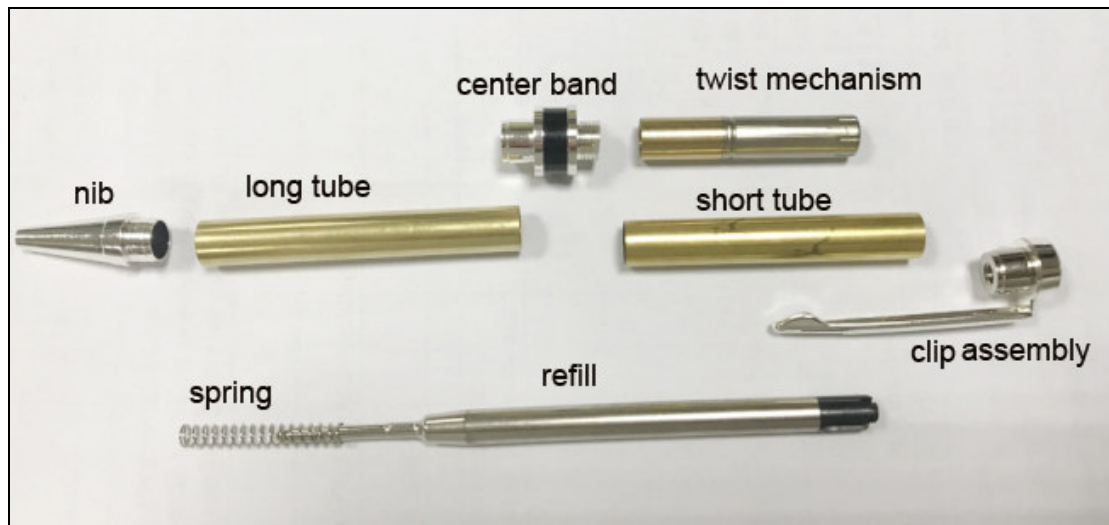
PREPARING THE BLANKS

- Cut 3/4" square blank to the length of the brass tube (add 1/16" for squaring off).
- Drill a 8mm center hole, lengthwise through the blanks.
- 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 inside the blank.
- When the glue dries, square the ends of the blank. Use a barrel trimmer of the proper size or a belt / disc sander to trim the wood down flush to the end of the brass tube.



TURNING THE BLANKS

- Place 3-4 spacer bushings onto the mandrel. Next, place an end bushing, wide-end first onto the mandrel. Then, slide on a blank, insert the center bushing, and follow with the other blank.
- Insert an end bushing, narrow-end first. Use standard 7mm bushings to fill the space to the thread. Thread the lock-nut on and hand tighten.
- Bring the tail stock snug with the mandrel (do not over tighten, it could damage the mandrel). Adjust to remove the spaces, then tighten the lock nut and lock the tail stock in place.
- Turn the wood down, flush with the bushings using a chisel and gradual higher grits of sandpaper. Finish with your choice of polish and wax.



ASSEMBLY

1. Press the nib into the small end of the long tube.
2. Press the center band into the other end of the long tube inserting the UNTHREADED end in the tube first. It is wise to use a block with a hole drilled in it so that the pressing is not done directly on the threads of the center band.
3. Press twist mechanism into the short tube from the top of the blank (small end). The threaded end should come flush with large diameter end of the short tube.
4. Press the clip assembly into the smaller end of the short blank.
5. Place the refill into the long tube with the spring in place and the spring end first.
6. Screw the part on the exposed threads of the center band. Then the pen can work.