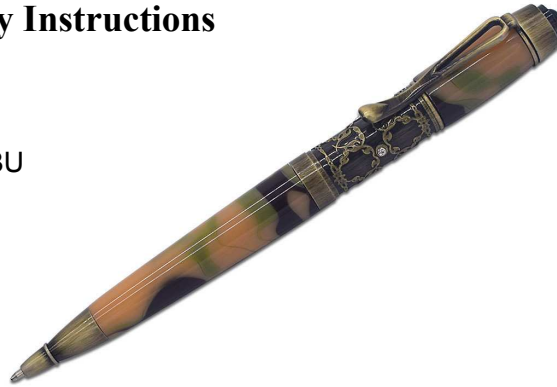


Xiamen Rizheng Industry Co.,Ltd

Ivy Twist Pen Kits Assembly Instructions

Required Accessories:

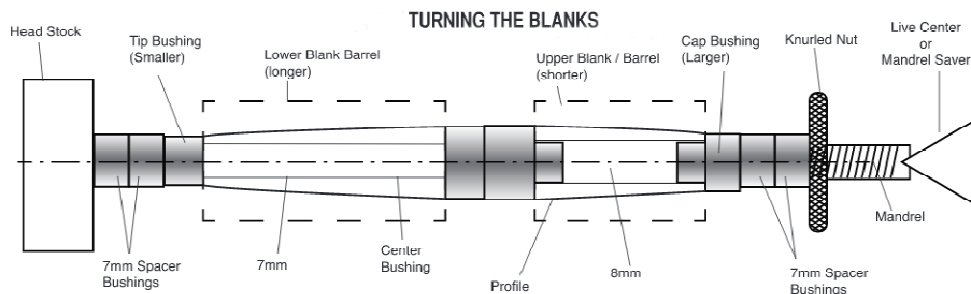
- 7mm pen mandrel
- 3 piece Bushing Set RZ-BP218#-BU
- Drill Bit 7mm&8mm
- Barrel Trimmer 7mm&8mm
- Live Tailstock Center
- Glue (Thick CA or Epoxy)



Preparing the Blanks:

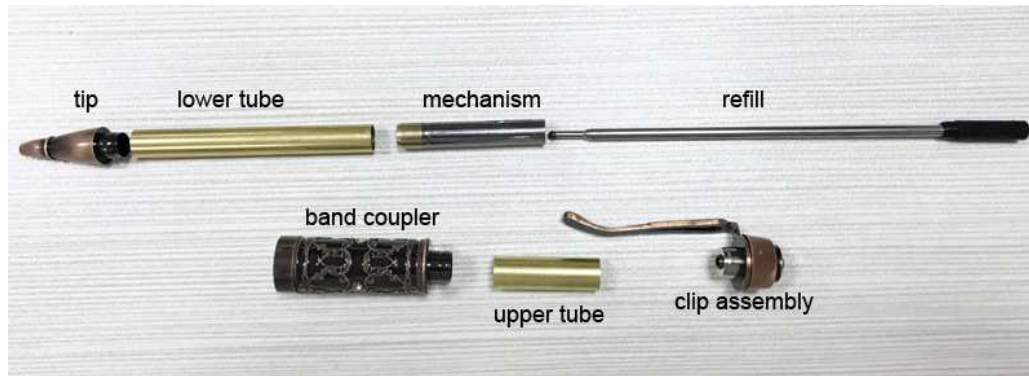
- Cut 2 blanks to the length of the brass tube (add 1/16" for trimming).
- Drill a 7mm hole lengthwise through the lower blank. Drill a 8mm hole lengthwise through the upper blank.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When the glue dries, Square the end of each blank. Use 7mm&8mm Barrel trimmers or a universal pen blank squaring jig with a power disc sander. Take the wood down to the brass tube. Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly.

Use the barrel trimmer shaft to clean the inside of the tubes.



Turning the Blank

- Mount the bushings and blanks on the mandrel according to the diagram above.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.



Assembly

NOTE: Line up the components according to the above picture.

- Press the tip into the narrow end of the lower barrel.
- Press the twist mechanism, brass end first into the opposite end of the barrel, Mark a line, 7/8" from the end and press the mechanism to the line.
- Insert refill into twist mechanism and screw to the end.
- Press the wide end of the upper barrel into the extension of the band coupler.
- Press the clip assembly into the opposite end of the upper barrel.
- Engage two barrels together. The pen is ready to use. Twist the end of the pen to extend or retract the refill.

Note:

In order to assure proper refill tip extension. It is good policy to press the mechanism short of the 7/8" mark. Twist the mechanism and pen barrel to check the retracting and extension of the refill. Press the mechanism further in if necessary.

