

Xiamen Rizheng Industry Co.,Ltd

Ruyi ballpoint pen kits Assembly Instructions

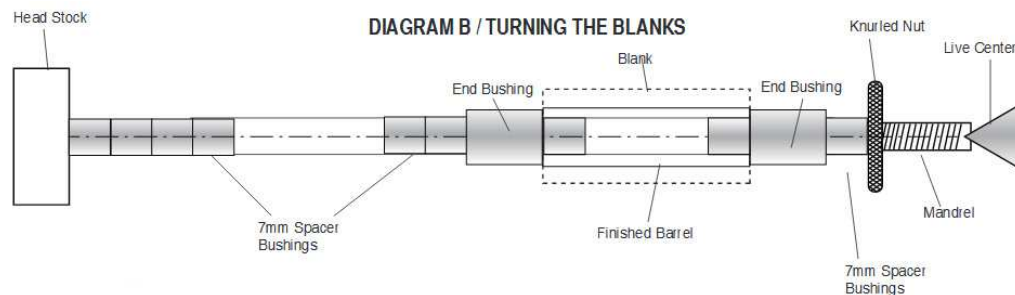
Required Accessories:

- 7mm pen mandrel
- 2 piece Bushing Set RZ-BP220#-BU
- Drill Bit 3/8" RZ-DB3/8
- Barrel Trimmer use 3/8" Shaft
- Live Tailstock Center
- Glue (Thick CA or Epoxy)
- Pen Blank: Minimum Size- 3/4" x 2-1/4"



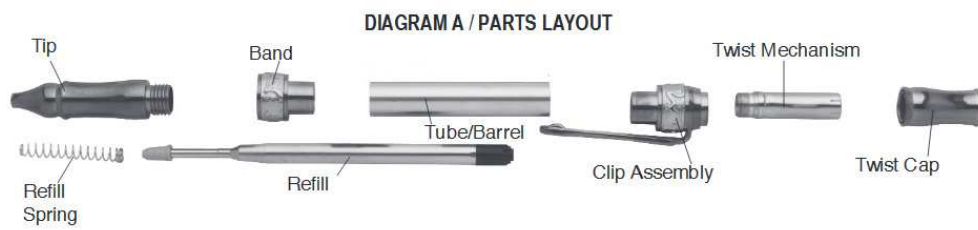
Preparing the Blank:

- Cut one blank to the length of the tube and add 1/16" for squaring off.
- Drill 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. You can use a 3/8" barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly).



Turning the Blank

- Mount the bushings and blanks according to diagram B.
- 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

- Layout parts according to diagram A
- Press the band recessed end in first into either side of the tube/barrel.
- Press the clip assembly into the opposite end of the barrel.
- Screw the tip into the opening at the band.
- Insert the refill with spring into the opening at the clip end.
- Screw the mechanism into the clip assembly, over the refill.
- Insert the twist cap over the mechanism to bottom.
- The pen operates by twisting the twist cap to advance or retract the refill tip. To replace the refill - twist the cap counter clockwise until it releases from the pen and remove/insert the refill then re-assemble.