

Xiamen Rizheng Industry Co.,Ltd

Mini Key Chain Pen Kits Assembly Instructions

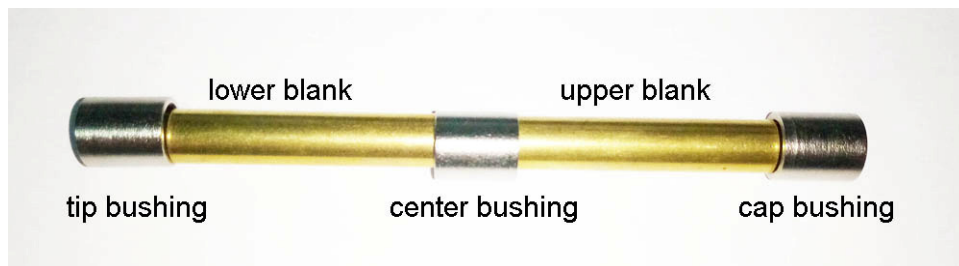
Required Accessories

- 7mm Long Mandrel.
- 7mm Drill Bit. RZ-DB007
- 3 Piece Bushing Set RZ-BP3#-BU
- 7mm Barrel Trimmer RZ-PM011
- Glue (Thick CA or Epoxy)



Preparing the Blank

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 7mm holes lengthwise through the blanks.
- Spread glue over the tube(s), insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 7mm 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). Use a barrel trimmer to clean the inside of the tube.



Turning the Blank

- Mount the bushings and blanks according 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.
- Sand and finish the barrel with your choice of polish and wax.



Assembly

- Layout parts according to diagram above
- Press the tip into the lower tube.
- Press the twist mechanism into opposite end of the same tube. Don't press too far in
- Slide the center band over the exposed mechanism.
- Press cap into the key ring then onto the upper tube.
- Affix key ring into the hole in the ring cap.
- Insert the refill guide into the refill and slide this into the front tube screwing the refill guide into the pen mechanism.
- Push the two halves together aligning grain as desired. Pen is operated by twisting the halves in opposite directions to extend or retract point. Test the extension with the refill inserted.