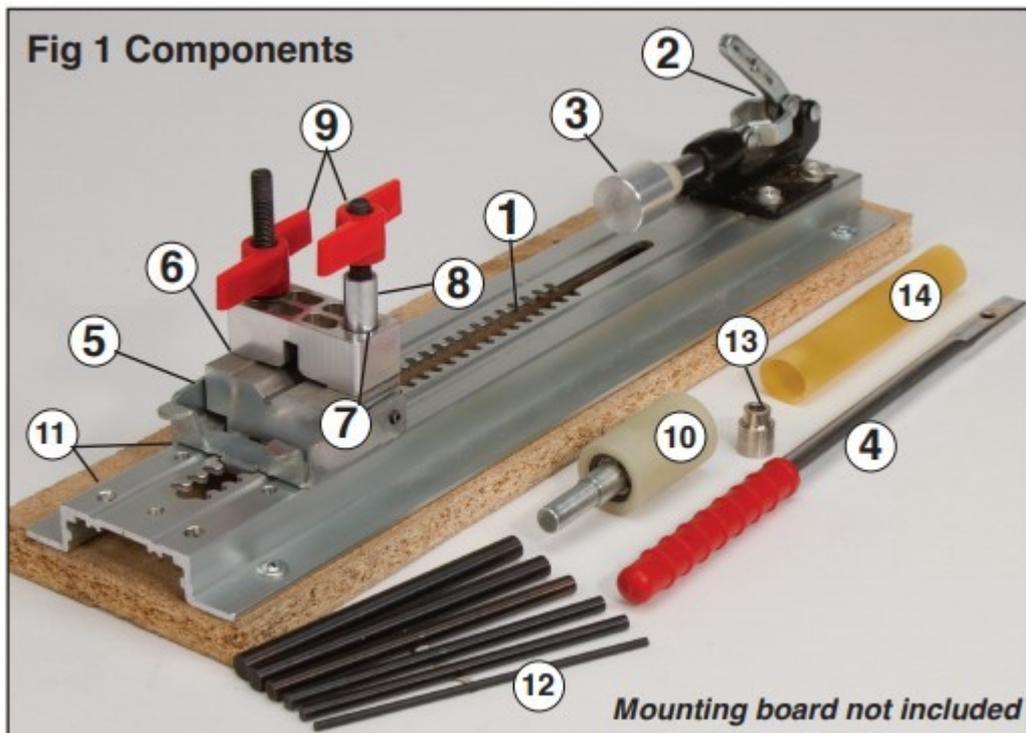
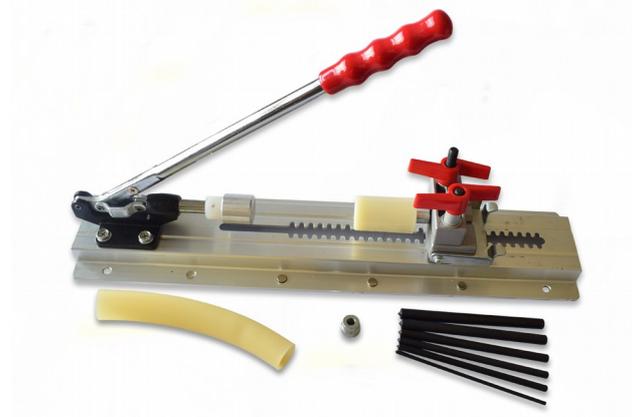


# Xiamen Rizheng Industry Co.,Ltd

## Pen Turners Press Assembly And Disassembly Instructions

### Components Included: Fig 1

1. Slotted platform
2. Pressing Assembly Clamp
3. Pressing Ram
4. Handle
5. Sliding Sled with Sled Lever
6. Sled Clamp
7. Washer
8. Upper Knob spacer
9. Clamping Knob (2)
10. Spring-loaded Plastic Stopper
11. Magnets (4) Mounted in base
12. (6) disassembly rods: 3.0mm, 5.5mm, 6.0mm, 7.0mm, 8.5mm, 9.0mm
13. (1) 7mm mechanism Disassembly Bushing
14. 6" of Soft-grip Tube for parts protection



It is recommended that the press be mounted or clamped to a work space to prevent slipping and aid in leverage. Slide a 2"x18" piece of thin wood or cardboard under the platform to capture parts that fall into the slot.

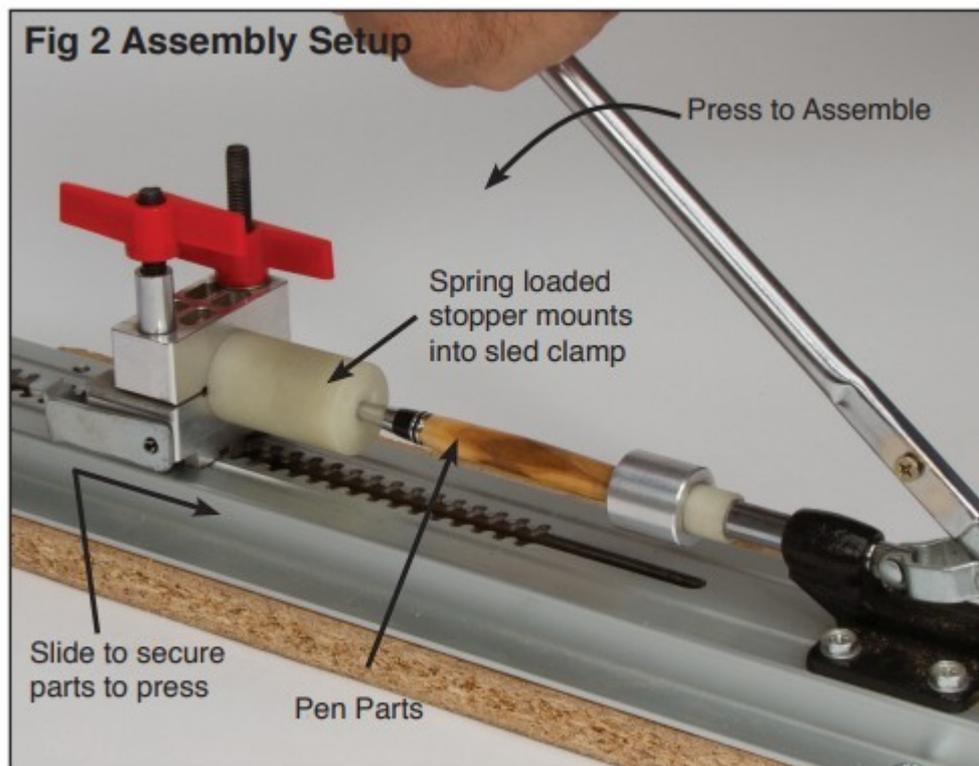
### Press Assembly:

Mount handle onto press assembly - lock in with screw - secure rods &

bushings with magnets.

### Pen Assembly Setup (Fig. 2)

- Insert Stopper into Sled Clamp and tighten Knobs until secure.
- Set the assembly handle in vertical position.
- Lift locking Sled Lever and position Sled so that there is enough distance to allow parts to be inserted. Insert pen parts between the Ram and Stopper, pushing against the spring in the Stopper. Move sled towards the Ram and let the spring pressure of the Stopper hold the parts in place.
- Allow Sled Lever to drop into a locking slot.
- During pressing, be sure pen parts remain aligned.
- NOTE: The spring inside the Stopper will continue to add pressure to the pen parts to support the parts in position.
- Apply steady pressure with the assembly lever until the parts are pressed together. Do not force the lever. If the parts do not press together. Reposition the pen parts and press again.

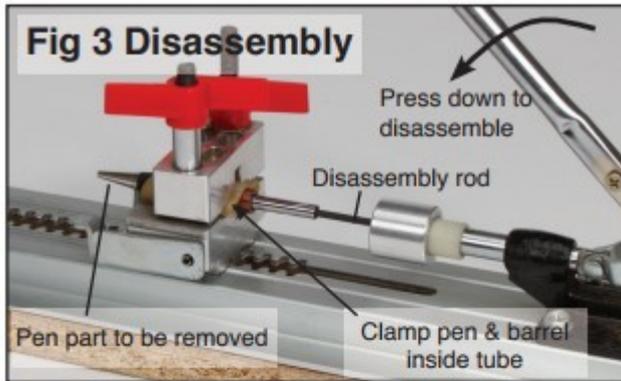


### General Disassembly (Fig 3)

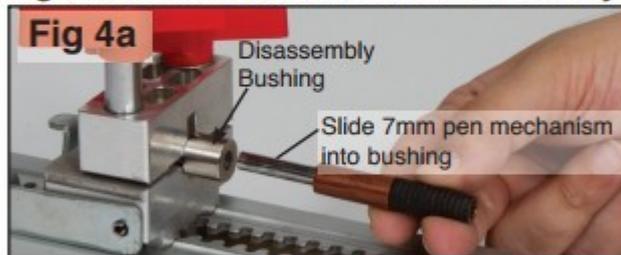
- Cut an approximately 1" to 1.5" section of Soft-grip tubing. Use a sharp knife for this. Tubing will resist being cut with a dull knife. Tubing can be re-used many times. Discard if tears begin to appear.
- Remove any easily removable portion of pen. This may include clips and caps. Retain parts that may aid in disassembly, e.g. tips that can be pressed against to remove couplers they are screwed into
- Loosen knobs sufficiently to allow parts to be inserted. Insert barrel into tube

and then insert into Clamp. Tube should sufficiently cover pen barrel in the clamping area. Make sure the part being removed is free of the clamping area.

- The clamp has a deep slot to accommodate non-removable clips. This prevents damage to clip and maximizes clamping pressure on parts that need to be held in place. If clip is a part of what is being removed make sure that no clamping pressure is directly on the clip.
- Tighten the clamp until pen barrel is firmly held. DO NOT OVERTIGHTEN as it may crush the barrel of the pen.
- Use the largest rod that will fit into the tube and still be able to move freely.
- If the part to be pressed out has a hole larger than the rod, the rod can be angled to the side during pressing to catch the edge of the part. Ends of the rod should be kept sharp to prevent slippage.
- With handle in vertical position, part in clamp and rod inserted, Move Sled until rod is as close as possible to pressing head and still lock into a slot.
- Once set up is complete, apply steady pressure until part comes out of tube. If the part does not come out with moderate pressure-try to “knock it” by rocking the handle so the ram hammers against the rod.
- If the barrel slides through the rubber tube; release handle, carefully increase the clamping pressure, and retry.



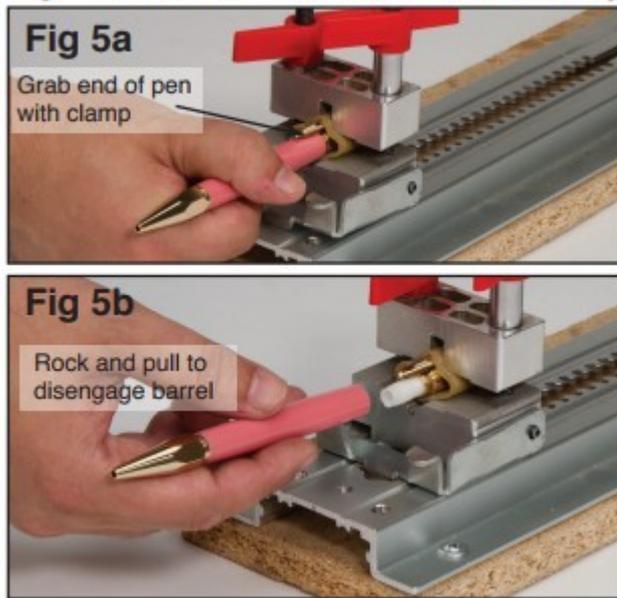
**Fig 4a-4b 7mm Mechanism disassembly**



**7mm Mechanism Disassembly: (Fig 4a, 4b)**

- 7mm mechanism disassembly
- Clamp the lower barrel as described above with the mechanism pointing towards the Pressing Assembly.
- To remove the tip, insert the 3mm rod through the mechanism and against the inside of the tip (see fig 3). Move sled into pressing position and apply pressure until tip comes out.
- To remove the mechanism, (Fig-4a, 4b)remove barrel from clamp. Insert the smaller portion of 7mm Disassembly Bushing into clamp and tighten knobs until it is held firmly.
- Insert exposed portion of mechanism into the Disassembly bushing.
- Insert 6mm rod into opening in opposite end of pen barrel.
- Position sled into locked position with rod against the pressing head.
- Apply pressure until mechanism fully exits the barrel. Mechanism should easily slide through the Bushing.

### Fig 5a-5b Click mechanism disassembly



#### Fig 5. Click Disassembly (Fig 5a, 5b)

This section is for pen sections that cannot be disassembled with the rods (click pens, bolt actions, etc). Click pens, for example have plastic mechanisms that will break if pressure is applied with a rod. For bolt actions, use a #0 Phillips Screwdriver with 4" shaft to remove set screw in bolt action and unscrew bolt.

- Move sled to opposite end of the platform from Pressing assembly.
- Insert part (wrapped inside Soft grip tube) into Clamp. The rest of the pen should be on the outer side of the clamp. Tighten until secure.
- Grab the exposed portion of pen. An extra piece of Soft-grip tube or Soft Jaw Locking pliers around the barrel will aid in this.
- Secure the Sled Lever to prevent movement.
- Gently rock exposed portion of pen while pulling away from clamp until tube separates from part.