

Xiamen Rizheng Industry Co.,Ltd

Outdoor Tactical Twist Pen Kits Assembly Instructions

Required Accessories:

- 7mm pen mandrel
- 4-piece bushing set RZ-BP292#-BU
- Drill Bit 13/32" RZ-RSDB13/32 and 13.2mm RZ-RSDB132
- Universal barrel trimmer
- Glue (Thick CA or Epoxy)

Preparing the Blank:

- Prepare a master blank of at least 3/4" square. Cut two sections to the length of each tube. (Add 1/16" for trimming)

Mark the center of each blank.

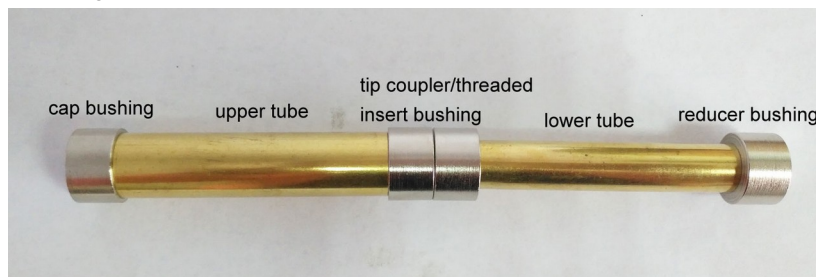
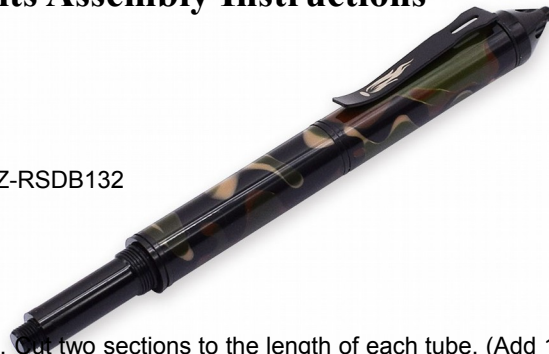
- Drill a centered hole lengthwise through each blank.

Upper blank —drill a 13.2mm hole through.

Lower blank—drill a 13/32" hole through.

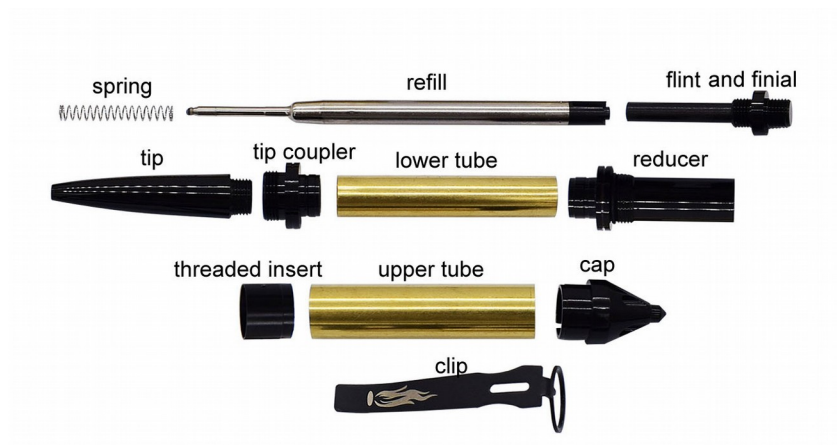
- Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center each tube lengthwise inside the blank.

- When glue dries, square the ends of each blank.



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.
- 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 tip coupler into one end of the lower tube.
- Press the reducer into the other end of the lower.
- Screw in the flint and finial to the reducer (flint side first).
- Insert the spring then the refill into the lower tube. Thread the tip into the tip coupler.
- Press the threaded insert into one end of the upper tube.
- Insert the clip into the cap, then press the clip and cap into the other end of the upper tube
- Thread the cap on the pen. The outdoor tactical pen is ready to operate now.