

Xiamen Rizheng Industry Co.,Ltd

Mini marchesa necklace pen kits Assembly

Instructions

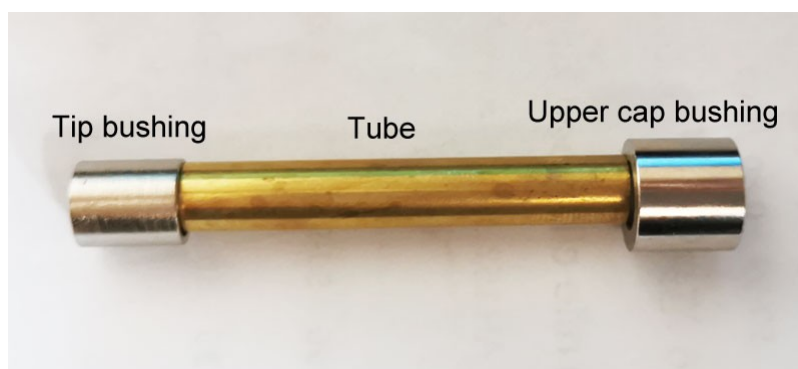
Required Accessories:

- 7mm pen mandrel
- 2piece Bushing Set RZ-BP193#-BU
- 7mm Drill Bit RZ-DB007
- Universal Barrel Trimmer
- Live Tailstock Center
- 2 part epoxy glue or instacure glue
- Overall length 4-1/4"



Preparing the Blanks:

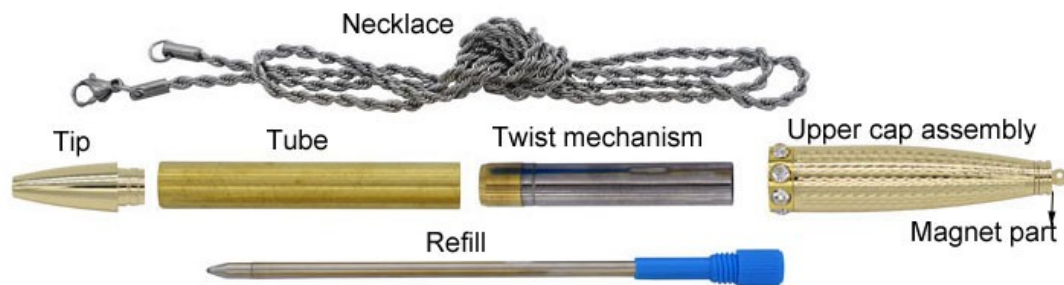
- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 7mm hole lengthwise through the blank.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise in the blank.
- When the glue dries, square the end of each blank. Use a Barrel trimmer with 7mm shaft 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 tube.



Turning the Blanks:

- 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.



Pen Assembly

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

- Press the tip end into the narrow end of the barrel.
- Press the twist mechanism into the opposite end of the barrel. Press until 3/4" of chrome is showing.
- Turn the chrome end of the mechanism counter-clock wise, insert the refill and screw in to bottom.
- Insert the magnetic stem into the opening at the top of the cap. Slip the chain over the neck.
- The pen operates by turning the ends to extract or retract the refill.