

Xiamen Rizheng Industry Co.,Ltd

Sword Click Pen Kits Assembly Instructions

Required Accessories:

- 7mm Pen Mandrel
- 4 piece Bushing Set RZ-BPCL343#-BU
- 11/32" Drill Bit (RZ-DB11/32)
- 9mm Drill Bit
- Universal Barrel Trimmer
- Sandpaper/Finish
- 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)

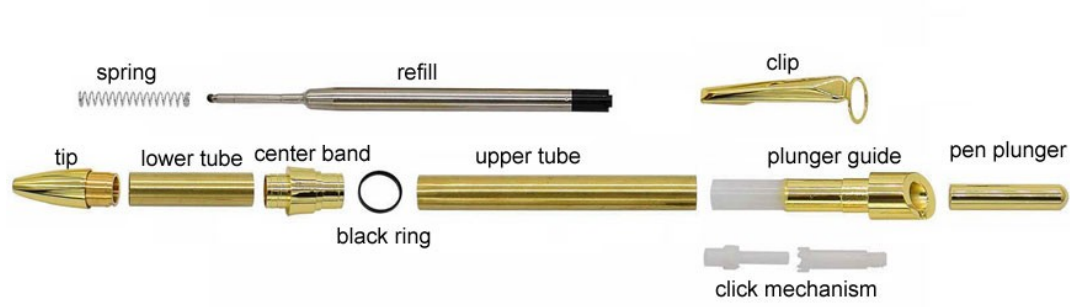
Mark the center of each blank.

- Drill a centered hole lengthwise through each blank.
Upper blank (longer tube)—drill a 9mm hole through.
Lower blank (shorter tube)—drill a 11/32" mm 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 diagram.

- Press the tip assembly to one end of the lower tube (shorter tube).
- Press the center band, wide end first, into the opposite end of the lower tube.
- Press the upper tube into the exposed end of the center band.
- Place the black ring into the center band through the upper tube, slide the plunger guide, narrow end first, into the clip hole. Press this assembly into the opposite end of the tube.
- Screw out the tip and insert the refill through the coupler, and push the mechanism towards the clip end until the threaded end of the back mechanism is held close to the end of the plunger guide, then screw the plunger onto the thread and tighten.
- Slide the refill spring over the threaded the tip of the refill, and screw on the pen tip.
- The pen is now ready to use. Just click the plunger to extend or retract the refill