

## Xiamen Rizheng Industry Co.,Ltd

### 5" Crank top salt & pepper mill kits Assembly Instructions

#### Required Accessories

- Drill Bit(s):  
26.2mm (For thru holes)  
37.2mm (For top recess)  
37.2mm (For bottom recess)
- Sandpaper/Finish
- Drill or Drill Press
- 4 jaw chuck
- Eye and Ear Protection
- Wood Blank Required:  
Minimum Size- 2-1/2" x 2-1/2" x 4-3/4"



#### Selecting the Blank

- Select a 2-1/2" x 2-1/2" x 4-3/4" blank with the grain running lengthwise.

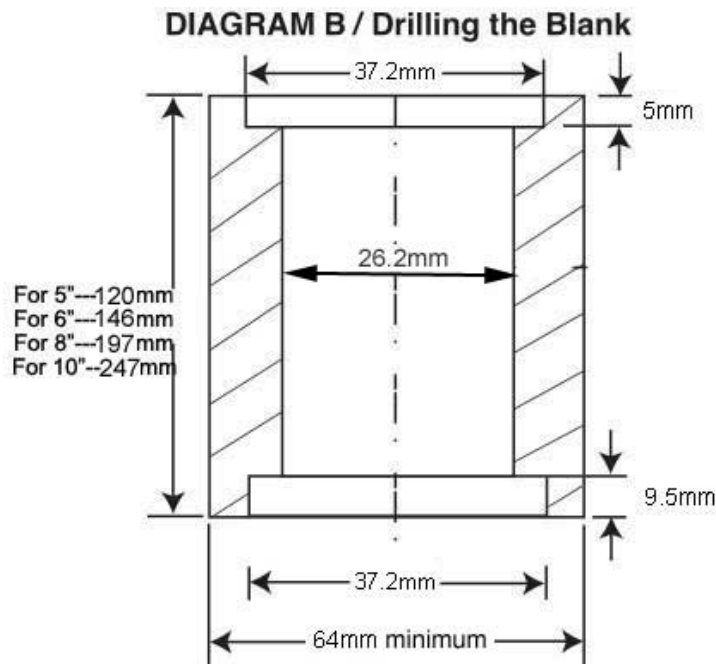
#### Mounting the Blank

- Mount the blank between centers and rough turn the blank to round.
- True the ends of the blank making the overall length 5" long (127mm). Cut a 1/4" long dovetail tenon on each end for mounting in a 4 jaw chuck. (Diagram A)



#### Drilling the Blank (Diagram B)

- Mount the Mill Body in a chuck gripping the dovetail tenon.
- Drill a 37.2mm dia. hole 9.5mm deep.
- Now drill a 26.2mm hole half way through the blank.
- Reverse the blank in the chuck and check it to make sure it runs true and tighten it.
- Drill a 37.2mm hole 5mm deep.
- Drill a 26.2mm hole through the blank until it meets the existing hole leaving a 26.2mm hole through the entire blank.



**Precaution:**

- The hole depths must be accurately drilled or the mechanism will not work.

**Turning the Mill Body**

- Mount a 50mm to 76mm diameter by 50mm long waste block on the lathe using a chuck or faceplate.
- Turn a 1-1/2" long tenon to fit very snugly into the 1-1/16" dia. hole in the Mill Body. Leave a small shoulder at the base of the tenon. Test the fit of the tenon to the hole until you have the right fit.
- Mount the blank onto the tenon and turn to your desired shape. Support the blank using the tailstock whenever possible.
- Sand and finish the blank.

**Assembly**

- Layout parts according to diagram C
- Glue the upper cup into the recess on the upper blank.
- Insert the grinding assembly, shaft in first through the hole in the bottom. Push on the spring.
- Mount the crank wheel over the extended rod. Screw the adjusting grind knob over the threads.
- Line up the grinder support rim shoulders to match the holes in the grinder base.

Cover with the bottom plate, extended portion toward the bottom.

Screw in through the grinder base and housing securely into the wood.

- When filled with pepper or salt, to adjust the grind just loosen or tighten the

knob.

- To reload the mill, remove the knob and crank wheel and reload through the top.

