

Xiamen Rizheng Industry Co.,Ltd

Graceful Pluma Pen Kits Assembly Instructions

Required Accessories:

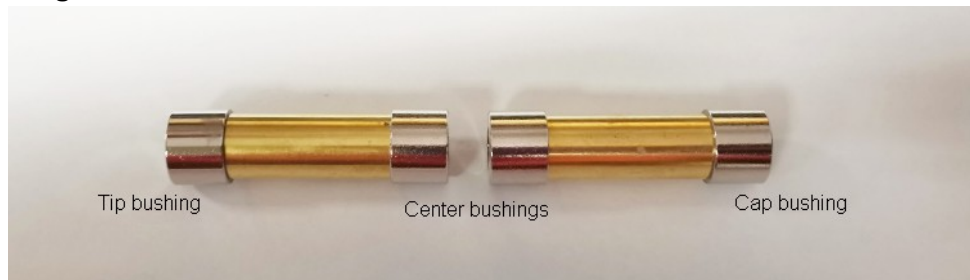
- 7mm, long mandrel
- 27/64" drill bit RZ- DB27/64
- barrel trimmer RZ-PM015
- Bushing set RZ-BP438#-BU
- 2 part epoxy glue or insta-cure (cyanoacrylate)
- Sanding and finishing supplies



Preparing the Blank

- Prepare a master blank of at least 5/8" square. Cut to the length of the two tubes (add 1/16" for trimming).
- Drill a 27/64" center hole through the blank.
- Glue the tube in the blank. Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Center the tube inside the blank.
- Sand or barrel trim to square the ends of the blank

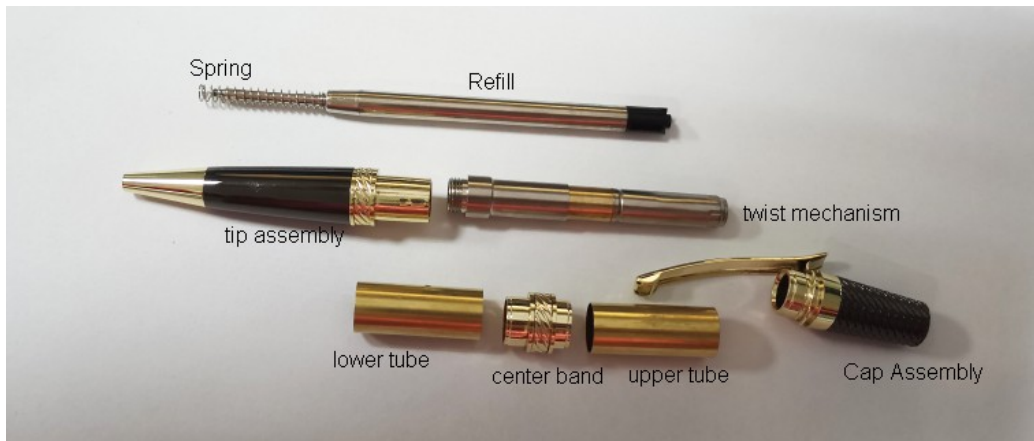
Diagram A



Turning the Blanks (see Diagram A)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with one center bushing; narrow end first. Follow with the other center bushing; wide end first. Insert the other blank. Follow with the cap bushing; narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

Diagram B



Assembly

(Line up finished parts according to Diagram B)

1. Press center band to one end of upper tube and lower tube.
2. Press clip assembly into the other end of upper tube.
3. Slide the spring onto the refill and place inside the tip assembly. Screw the pen mechanism into the tip assembly.
3. Push pen tube with cap assembly onto completed lower assembly.
4. The pen is now ready to operate, twist clockwise to open.