

Xiamen Rizheng Industry Co.,Ltd

Hurricane Ball Pen Kits Assembly Instructions

Required Accessories:

- 7mm pen mandrel
- 4-piece bushing set RZ-RP341#-BU
- Drill Bit 10 mm RZ-DB010 and 11.7mm RZ-RSDB117
- 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)

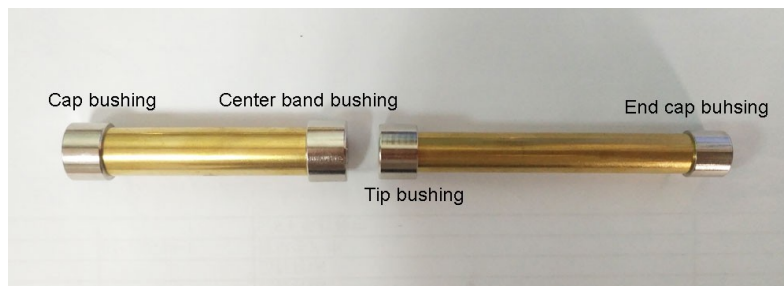
Mark the center of each blank.

- Drill a centered hole lengthwise through each blank.

Upper blank (shorter tube)—drill a 11.7mm hole through.

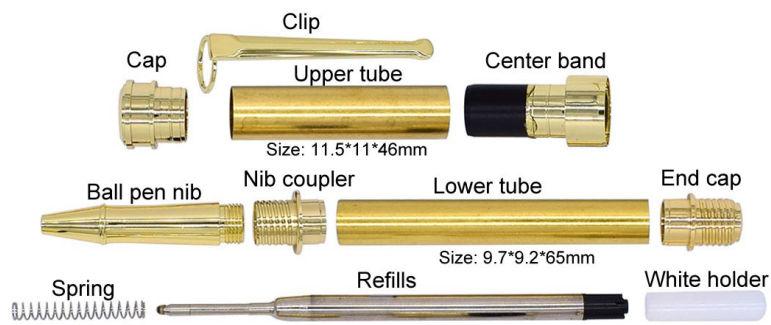
Lower blank (longer tube)—drill a 10mm hole through.

- 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. Using a 7mm barrel trimmer with adapter sleeves, mount the proper sleeve (large diameter for the short tube, smaller diameter for the longer tube) over the shank with the brass tube.



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 the cap and clip into the top of the upper barrel (shorter tube).
- Press the center band into the opposite end of the upper barrel.
- Place the end cap into the end of the long tube
- Press the nib coupler into another end of the long tube.
- Place the spring over the refill tip, then insert the white holder and the refill into the opening at the top of the pen, then screw the ball pen nib into the nib coupler.