

Xiamen Rizheng Industry Co.,Ltd

Pocket ball Pen Kits Assembly Instructions

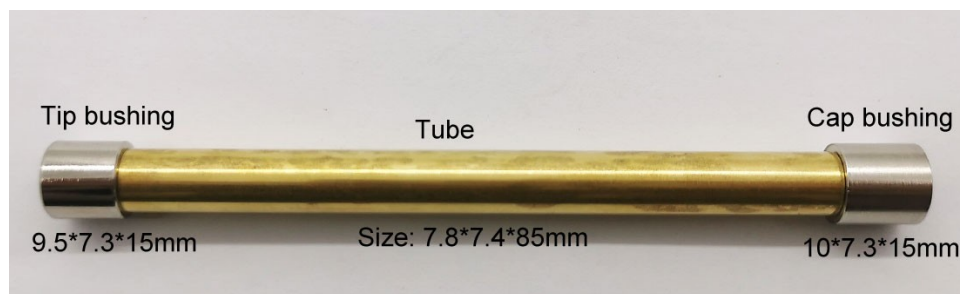
Required Accessories:

- 7mm pen mandrel
- 2piece Bushing Set RZ-BP456#-BU
- 8mm Drill Bit RZ-DB008
- Barrel Trimmer
- Live Tailstock Center
- Glue (Thick CA or Epoxy)



Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 8mm 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 8mm 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.

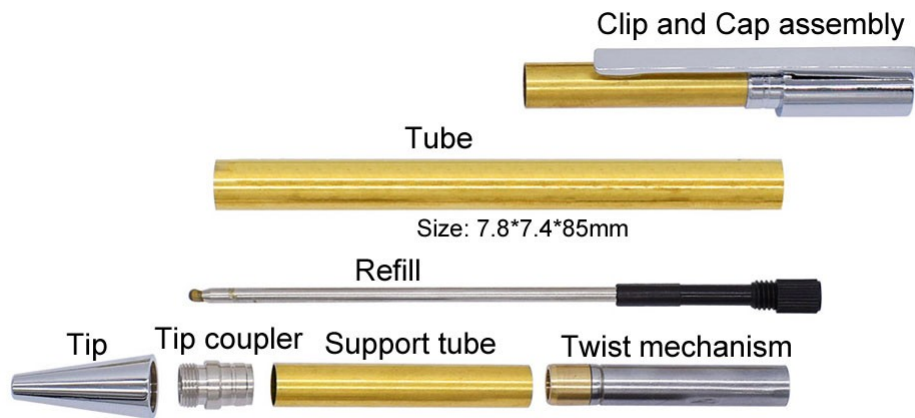


Turning the Blanks:

- Mount the bushings and blanks on the mandrel .
- 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. - refer to polish instructions.



Assembly

- Layout parts according to diagram above.
- Press the cap/clip assembly into either end of the tube.
- Press the support tube into the coupler of tip.
- Scribe a line/ mark on the twist mechanism 25mm line from the chrome end. Press with the brass end of the mechanism first into the opposite end of the support tube to the line scribed. Leaving about 25mm exposed.
- Twist the mechanism and pen barrel to check the retracting and extension of the refill. Press the mechanism further in if necessary.
- Insert refill into twist mechanism and screw to the end.
- Engage and push the tube with cap/clip assembly together.
- Pen operates by twisting the barrels to extend or retract writing tip.