

# Xiamen Rizheng Industry Co.,Ltd

## Jr. Gentleman II Fountain Pen Kits Assembly Instructions

### Required Accessories:

- 7mm, Pen Mandrel
- 4 piece Bushing Set RZ-RP210#-BU
- 12.3mm Drill Bit RZ-DB123
- 10.6mm Drill Bit RZ-DB106
- 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.

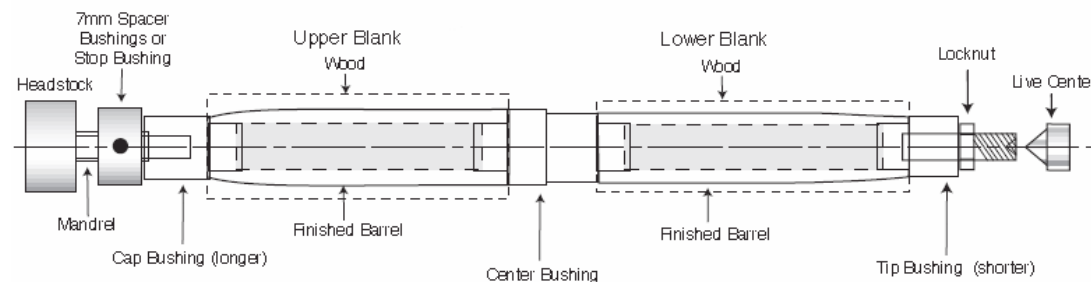
Upper blank (shorter tube)—drill a 12.3mm hole through.

Lower blank (longer tube)—drill a 10.6mm 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 Blanks



### Turning the Blank

- Mount 7mm spacer bushings on the mandrel followed by the tip bushing (shorter diameter) wide end first.
- Slide the lower blank (long) on next. Follow with the 2 center bushings, narrow diameter first, Slide on the upper blank (short) and follow with the cap bushing, narrow end first. Add additional spacer bushings as necessary to overlap the mandrel. Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel).
- Turn the blanks down close to the bushings. Follow with abrasives until the tube diameters are flush with the bushings
- Finish with your choice of polish.



## Assembly

NOTE: Line up the components according to the above diagram.

- Press the clip assembly to one end of the upper tube (shorter tube).
- Press the center band coupler, black end first, into the opposite end of the upper tube.
- Place the cap into the end of the lower tube.
- Press the coupler into the opposite end of the lower tube.
- Insert the spring then the ink refill into the lower tube. Thread the the nib into the nib coupler.