

Xiamen Rizheng Industry Co.,Ltd

Multicolor Pen Kits Assembly Instructions

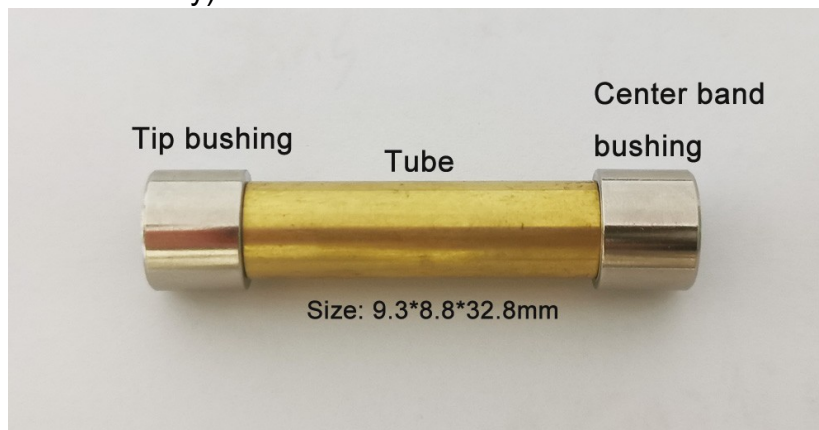
Required Accessories

- 7mm pen mandrel
- 2 piece Bushing Set RZ-BPCL413#-BU
- Drill Bit 3/8" RZ-DB3/8
- Barrel Trimmer
- Glue (Thick CA or Epoxy)



Preparing the Blank

- Cut one blank to the length of the tube(s) and add 1/16" for squaring off.
- Drill 3/8" holes lengthwise through the blanks.
- Spread glue over the tube(s), insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly). Use a barrel trimmer to clean the inside of the tube.



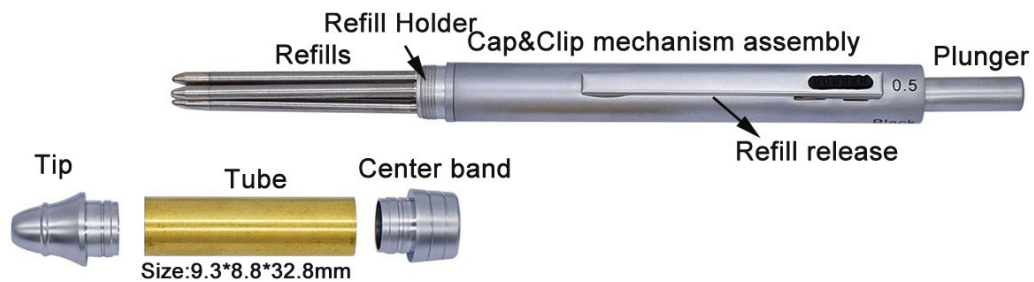
Turning the Blank

- 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.

DIAGRAM B



Pen Assembly:

- Line up finished parts according to the diagram above.
- Press the tip into either end of the tube.
- Press center band into the opposite end of the tube.
- Slide the center band over refills and screw into the Cap & Clip mechanism assembly.
- The pen is now ready to operate. When pen is laying horizontally, rotate to the preferred pencil or ink color. Press plunger and that will activate that refill.

Refill Replacement

- Refills remove from the Refill holder.
- Insert pencil lead at the open end of the pencil mechanism. Reinstall into the refill holder. Use plunger multiple times to push lead to desired length.