

Xiamen Rizheng Industry Co.,Ltd

Carefree Gel Pen Kits Assembly Instructions

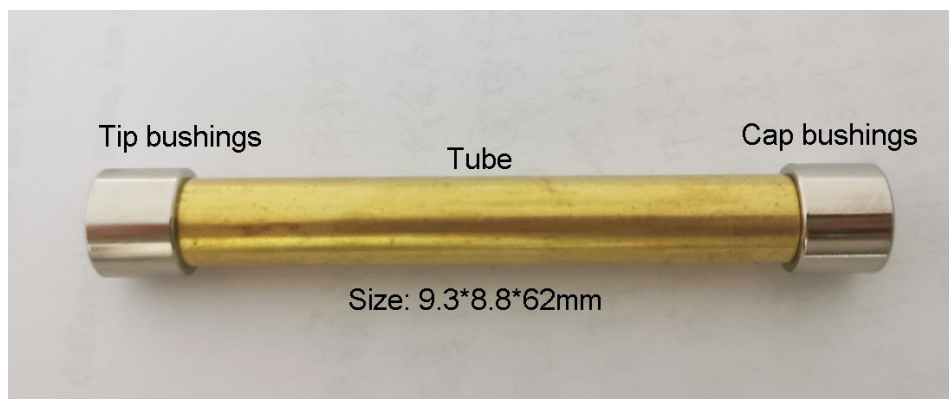
Required Accessories:

- 7mm pen mandrel
- 2piece Bushing Set RZ-BP412#-BU
- 3/8" Drill Bit RZ-DB3/8
- Universal Barrel Trimmer
- Live Tailstock Center
- 2 part epoxy glue or instacure glue
- Minimum Blank size: 3/4" x 3/4" x 2-5/32"



Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 3/8" 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 10mm 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 according to 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.



Pen Assembly

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

- Press the tip coupler assembly into either end of the barrel.
- Press the cap into the opposite end of the barrel.
- Insert refill, back end first into opening in tip coupler..
- Slide spring over tip of refill, then thread tip over spring and refill.
- The spinner cap can now screw on either end.
- The pen is now ready to operate.
- How to play the spinner? Remove spinner cap from pen and pinch it between thumb and index finger and spin with other hand.