

Xiamen Rizheng Industry Co.,Ltd

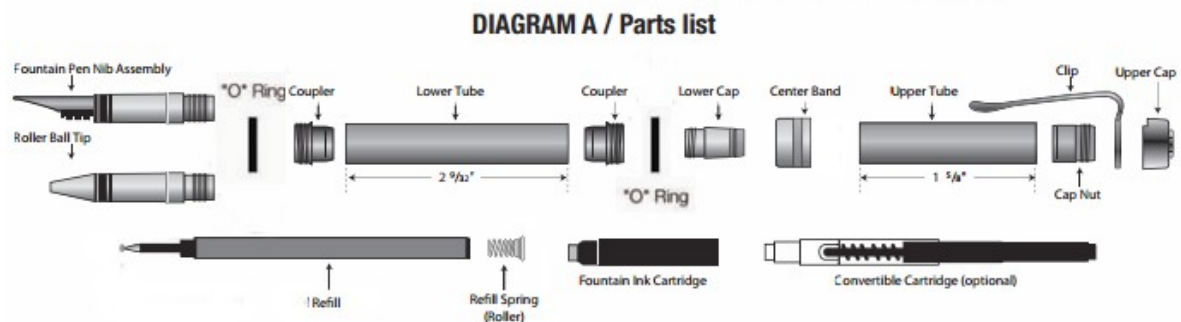
Classic Elite Fountain Pen And Rollerball Pen Kits

REQUIRED ACCESSORIES:

- 7mm, long pen mandrel
- 3 pc bushing set RZ-FP18#-BU
- 10mm drill bit RZ-DB010
- 10mm barrel trimmer RZ-PM014
- 2 part epoxy glue or insta-cure (cyanoacrylate) glue

PREPARING THE BLANK

- Cut 3/4" to 5/8" square blanks to the length of the brass tubes (add 1/16" for squaring off).
- Drill a 10mm center hole lengthwise through each blank.
- Spread glue over tube. Insert into blank with twisting motion to spread the glue evenly inside. Center tube lengthwise in the blanks.
- When the glue dries, square the ends of the blanks. Use a 10mm barrel trimmer or belt/disc sander to trim the wood down flush to the end of the brass tubes



Turning the Blanks

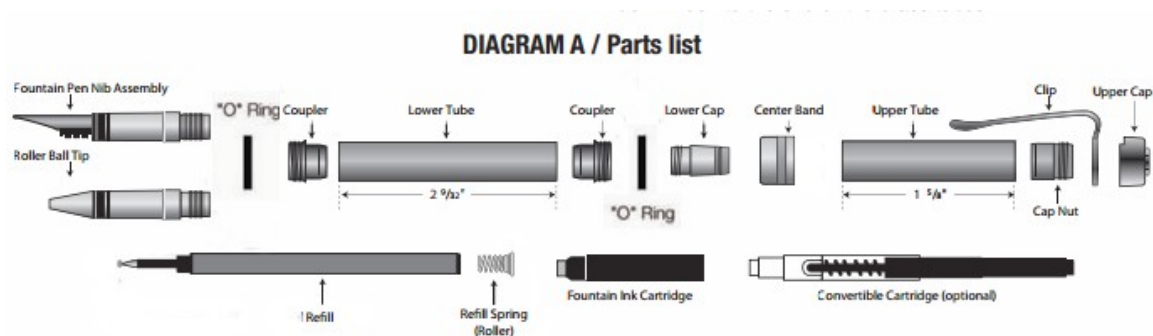
- place the stop bushing on the mandrel hand tight.
- place the cap bushing (longer one) wide end first.
- slide on the either blank. Place the center bushing (wide end first) on the mandrel.
- Slide on the other blank and follow with shorter tip bushing, narrow diameter first.
- Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel).
- Slide the stop bushing toward the blank adjusting to remove spaces. Then tighten the set screw and tighten the lock nut.
- Turn wood down flush with the bushings using lathe chisels and various grits of sandpaper.

Removing Wood For Center Band:

- Use a permanent marker to make marks inside the Brass Tubes that line up with the grain-alignment lines you drew on the outside of the blanks. This will help you maintain grain continuity after the blanks have been turned. Like following picture,



- Turn the blanks to round. Mark the Upper (shorter) Blank 3.5mm from the Center Bushing and extend the mark all the way around the blank.
- Use a parting tool to turn the section of the Upper Blank between the center bushing and the mark you just made to match the diameter of the center bushing. Switch tools and turn the rest of the Upper Blank to the desired shape, making sure that it transitions to the straight section near the center bushing and that it matches the diameter of the outer bushing at the other end.
- Using the parting tool again, carefully turn the 3.5mm section all the way to the brass tube, taking care to stop once you contact the tube.



ASSEMBLY TIPS

- Line up finished parts according to Diagram A.
- To press parts in, use a pen vise or a vice with covered jaws.

- Press parts slowly to avoid scratching and damaging the gold plated parts.
- Slip the “O” ring over the thread of the coupler, into the groove

ASSEMBLY OF BODY BARREL:

- Press a coupler into each end of the Lower barrel.
- Screw in the lower cap into either end of the barrel.
- Choose appropriate pen style for final assembly;

ASSEMBLY OF CAP BARREL:

- Press the center band, narrow diameter in first into the opening at either end of the barrel.
- Insert and press the cap nut, recessed end in first into the opposite end of the barrel. Stop at the shoulder.
- Place the clip over the threads, mount and screw in the upper cap, while aligning the clip rim into the slot in the cap. Tighten cap.

FOUNTAIN PEN ASSEMBLY:

- Push the ink cartridge (narrow end first) into the open end of the nib assembly to the end to cut an opening and allow the ink to flow. Screw this assembly into the barrel.

Tip: Stroke the pen nib from the small hole to the tip with a damp paper to help start the ink flow.

- OR – when using the refillable convertible cartridge, push the clear end of the cartridge into the opening of the nib assembly until it clicks. Screw the inner shaft counter clockwise all the way down inside the cartridge. Now, dip the nib into an ink bottle and slowly turn the shaft upwards (clockwise) to draw ink in, until the reservoir is filled. Screw the nib assembly back into the barrel.

ROLLERBALL PEN ASSEMBLY:

- Drop the refill spring into the opening of the lower barrel wide end first. Insert the refill into the barrel rear end.
- Screw the roller ball tip over the refill. Rollerball is ready to operate.

OPERATING THE PEN:

- A quick 1/4 turn will screw the ends together. When using the pen, screw the cap over the body end. Always keep the nib covered when not in use to avoid ink from drying up