

Xiamen Rizheng Industry Co.,Ltd

Eagle Click Pen Kits Assembly Instructions

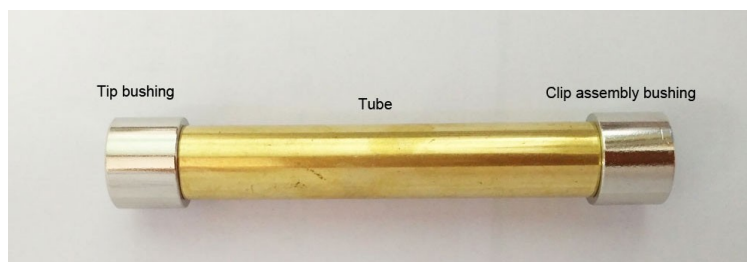
Required Accessories:

- 7mm pen mandrel
- 2 pcs Bushing Set RZ-BPCL371#-BU
- 10.2mm Drill Bit
- Universal Barrel Trimmer 10mm shaft RZ-PM014
- 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 10.2mm 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.

Diagram A



Pen Assembly

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

- Press the clip assembly into either end of the barrel.
- Slide the click mechanism from open end of barrel into the end of clip assembly.
- Press tip assembly into the opposite end of the barrel.
- Insert the Refill with the spring into the open end of tip assembly.

Note: Make sure the refill go through the tube end to touch the click mechanism.
Thread the tip onto the tip assembly.

- Thread the Click spring and the click button onto the open end of the Click assembly.

Note: Do not over tighten the assembly onto the Click Mechanism.

- To advance the refill press the end of the click mechanism, to retract the refill press the end of the click mechanism again.
- The pen is now ready to use. Just click the button to extend or retract the refill