

Xiamen Rizheng Industry Co.,Ltd

Mini Bolt Pen Keychain Kits Assembly Instructions

Required Accessories:

- 7mm pen mandrel
- 2piece Bushing Set RZ-BP612#-BU
- 8mm Drill Bit RZ-DB008
- Universal Barrel Trimmer RZ-PM012
- Live Tailstock Center
- 2 part epoxy glue or instacure glue (cyanoacrylate)



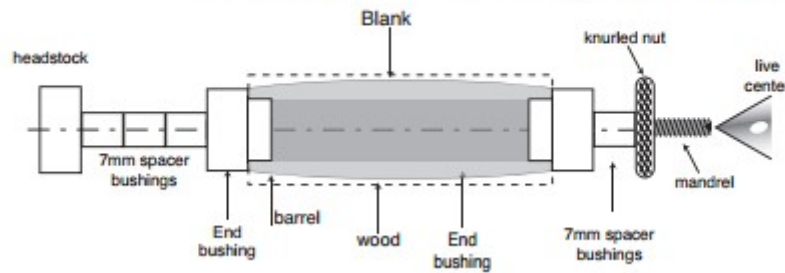
Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
 - Drill a 8mm 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 3/8" 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 Diagram "B"
- 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. - refer to polish instructions.

DIAGRAM B - Turning the Blanks

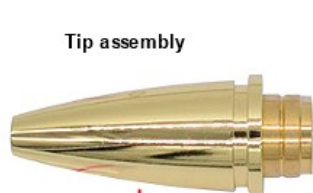
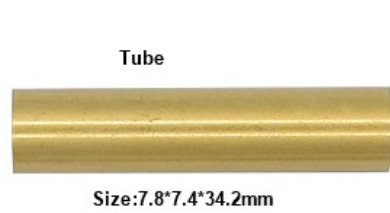


Pen Assembly

NOTE: Layout Finished parts according to Diagram C

- Unscrew the tip assembly to two parts (tip and sleeve)
- Press Sleeve into either end of the Barrel.
- Press the end cap assembly into the other end of the barrel. Be careful. You can place one of the bushings over the ring on the end to protect it.
- Slide spring over the tip of the refill. Tapered side of spring should go onto the refill first. Spring should stop at Refill Holder; it should not slide over it.
- Insert Refill into the opening in the Sleeve.
- Thread Tip, over the Refill and Spring onto the Sleeve.
- Attach Key Ring to the end cap assembly.
- To extend Refill slide the bolt down and over into the locking slot. Retract by moving the bolt out of the locking slot.
- To change refill, carefully unthread tip. Be sure to hold onto tip when removing. Spring can launch the tip and itself away from pen and get lost. Remove Refill Holder from old Refill and transfer it and spring to the new Refill.

Diagram C



Unscrew it to following two parts

