

Xiamen Rizheng Industry Co.,Ltd

Melody Pencil Kits Assembly Instructions

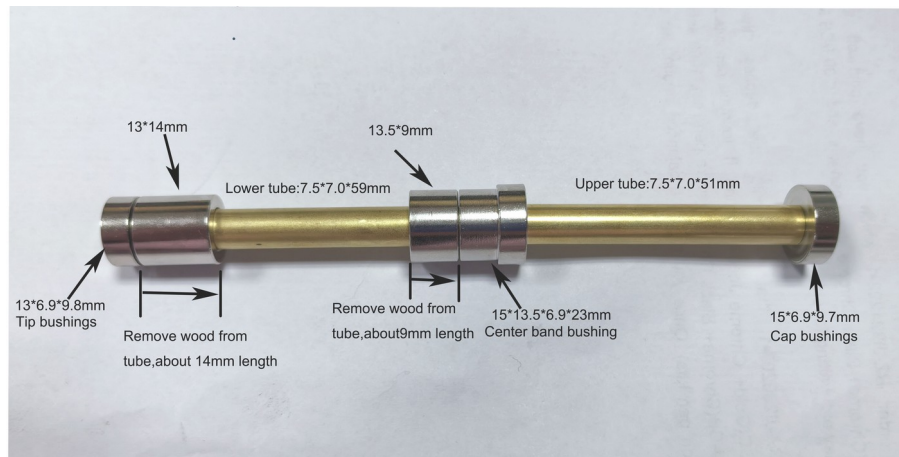
Required Accessories

- 7mm pen mandrel
- 5 piece Bushing Set RZ-PCL242#-BU
- Drill Bit 7.7mm
- Barrel Trimmer use 7.7mm Shaft
- Live Tailstock Center
- Glue (Thick CA or Epoxy)
- Pen Blank: Minimum Size- 3/4" x 4-1/2"

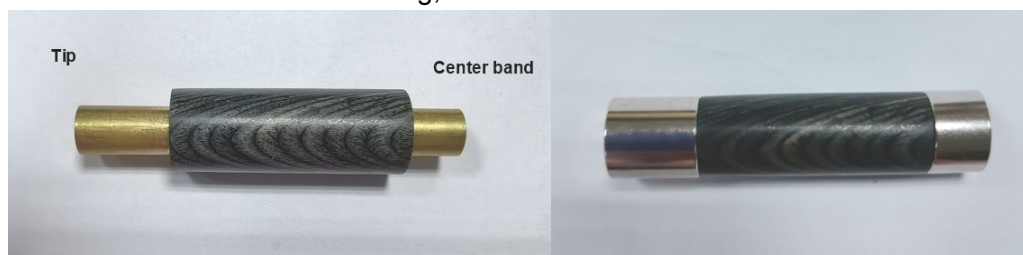


Preparing the Blank

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 7.7mm 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 7.7mm 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.

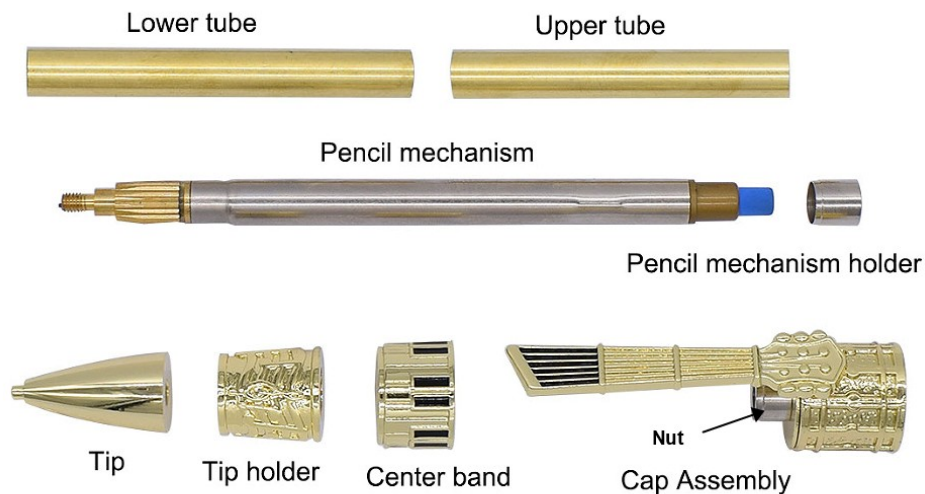


Finished lower tube is as following,



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.



Assembly

Layout parts according to diagram above

- Unscrew the nut off the cap assembly and press the nut into either end of the upper tube.
 - Affix the clip into the threaded stem of the cap, thread this assembly into the cap nut tightly.
 - Press the pencil mechanism holder into the end of lower tube which end is for the tip.
- Push the pencil mechanism into the cap slightly. When cap catches the pencil mechanism is ok, not to the end.
- Put the center band and tip holder to the two ends of lower tube. Then let the pencil mechanism across the lower tube and holder.
 - Push both ends of the pen together to close the gap in the center.
 - Screw the tip to the pencil mechanism.