

Xiamen Rizheng Industry Co.,Ltd

Aureola Twist Pen Kits Assembly Instructions

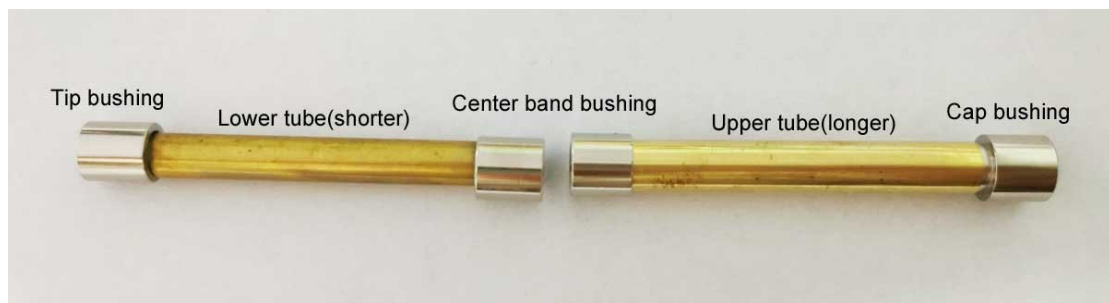
Supplies Needed

- 7mm Pen Mandrel
- Set of Bushings RZ-BP436#-BU
- 7mm & 8mm Drill Bit RZ-DB007 & RZ-DB008
- 7mm & 8mm Barrel Trimmer RZ-PM011& RZ-PM012
- Glue (Thick CA or Epoxy)



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 centered hole lengthwise through each blank.
 - Upper blank (longer tube)—drill a 8mm hole through.
 - Lower blank (shorter tube)—drill a 7mm hole through.
- Spread glue over tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center each tube lengthwise in the blanks.
- When the glue dries, square the ends of the blanks. Use an 7mm & 8mm barrel trimmer or use a belt/disc sander to trim the wood down flush to the end of the brass tubes.



Turning the Blanks:

- Slide 7mm spacer bushings onto the mandrel shaft, followed by the tip bushing. Slide on one blank. Next, add the center bushing. Place the upper blank followed by the cap bushing. Add additional spacer bushings as necessary to reach the mandrel threads.
- Thread on the locknut hand tight. Bring the tailstock in snug to the mandrel, lock in place. Tighten the lock nut for turning.
- DO NOT over tighten the locknut, it could damage the mandrel.
- Turn the barrels close to the bushing diameter with sharp tools; sand the barrels to match the bushing diameter.
- Finish the wood with your choice of polish.

Upper tube size: 7.8*7.4*51mm

Lower tube size: 6.8*6.3*48mm



Refill



Twist mechanism



Center band



Tip



Clip



Cap



Assembly:

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

- Press the tip into the lower tube(shorter).
- Press the twist mechanism, brass end first, into the opposite end to the identification mark. Stop near the mark to check for the desired extension of the refill. Leave the refill screwed in.
- Press the center band into the upper tube(longer).
- Cross the cap into the hole of Clip and Press the cap into the opposite end of the upper tube(longer).
- Push lower tube into the opening of upper tube until gap is closed. Pen is operated by twisting the halves in opposite directions to extend or retract point.