

Xiamen Rizheng Industry Co.,Ltd

Goodwill Pen Kits Assembly Instructions

Required Accessories:

- 7mm pen mandrel
- 2-piece bushing set RZ-RP452#-BU
- Drill Bit 10.5 mm RZ-DB105
- Universal barrel trimmer
- Glue (Thick CA or Epoxy)

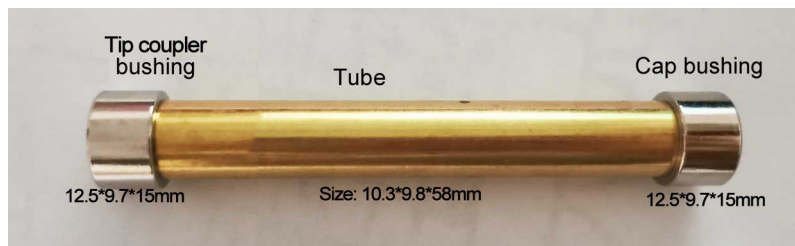


Preparing the Blank:

- Prepare a master blank of at least 3/4" square. Cut two sections to the length of each tube. (Add 1/16" for trimming)

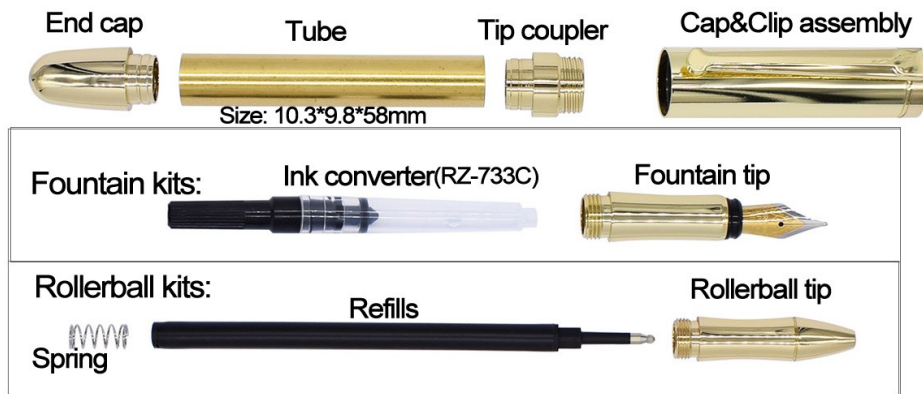
Mark the center of each blank.

- Drill a 10.5mm hole lengthwise through the blank.
- Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center each tube lengthwise inside the blank.
- When glue dries, square the ends of each blank. Using a 7mm barrel trimmer with adapter sleeves, mount the proper sleeve (large diameter for the short tube, smaller diameter for the longer tube) over the shank with the brass tube.



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

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

- Press the end cap into one end of the tube.
- Unscrew the tip coupler from the fountain/rollerball tip assembly, then press the tip coupler into the opposite end of the tube.
- For Rollerball kits----- Insert the Spring and the Refill into the tube. Thread the Rollerball tip into the tip coupler.
- For Fountain kits----- Attach the Ink converter to the back of the Fountain tip, then thread the Fountain tip into the tip coupler.
- Screw the cap& clip assembly into the coupler to complete the pen.