

Magnic Wand Kits Assembly Instructions

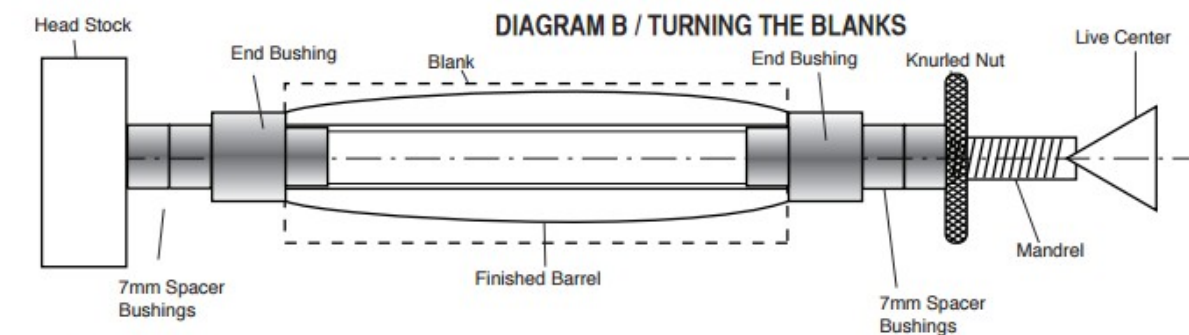
Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 3/8" RZ-DB3/8
- Bushing set(2 pc) RZ-PK689#-BU
- Barrel Trimming set(3/8 shaft RZ-PM013)
- Live Tailstock Center
- 2 Part Epoxy Glue or Cyanoacrylate Glue



•Preparing the Blank:

- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 3/8" hole lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks. Use a 3/8" 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.



Turning the Blank

- Mount the bushings and blanks 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 A



Assembly

Layout parts according to diagram A

- Press the End Cap into one end of the barrel.
- Press Coupler into the opposite end of the tube.
- Place "O" ring on the Threaded Adapter between the two different threads.
- Screw smaller threaded end into the Coupler
- Screw Wand Tip onto the opposite end of Threaded Adapter.
- The wand is now ready for use