

Xiamen Rizheng Industry Co.,Ltd

Loong Fountain/Rollerball Pen Kits Assembly Instructions

Required Accessories

- 7mm pen mandrel
- 4 piece Bushing Set RZ-FP231#-BU
- Drill Bit RZ-DB121, RZ-RSDB25/64
- Live Tailstock Center
- Glue (Thick CA or Epoxy)
- Pen Blank: Minimum Size- 3/4" x 4-3/10"



Preparing the Blank

- Cut 2 blanks to the length of the tube(s) and add 1/16" for squaring off. Mark the center of each blank.
- Drill a centered hole lengthwise through each blank.
Upper blank (shorter tube)—drill a 12.1mm hole through.
Lower blank (longer tube)—drill a 25/64" hole through.
- 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.

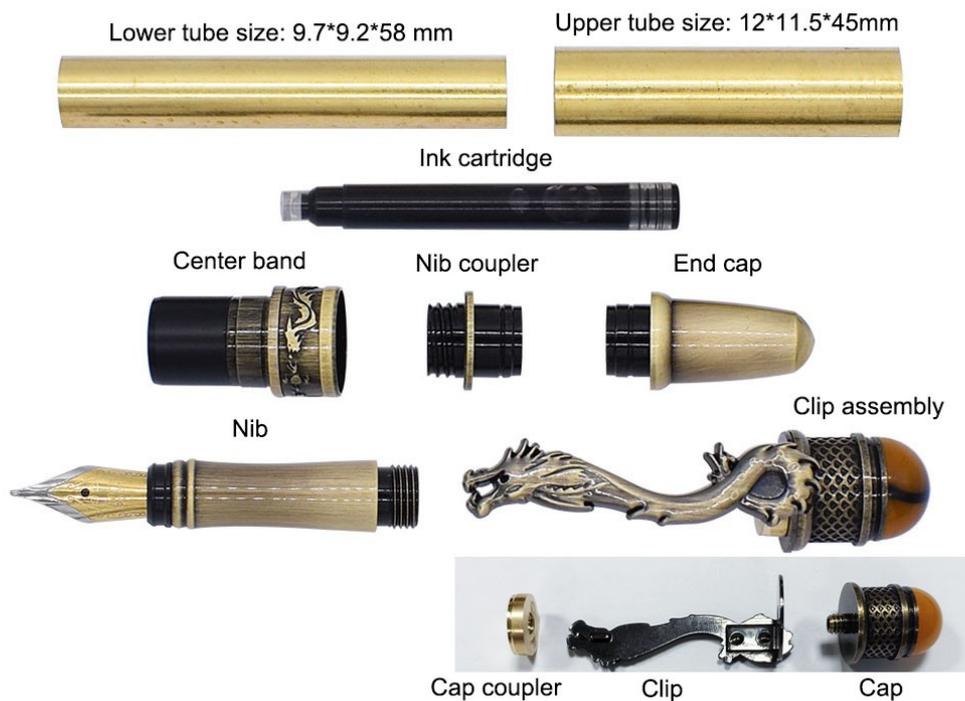


Turning the Blank

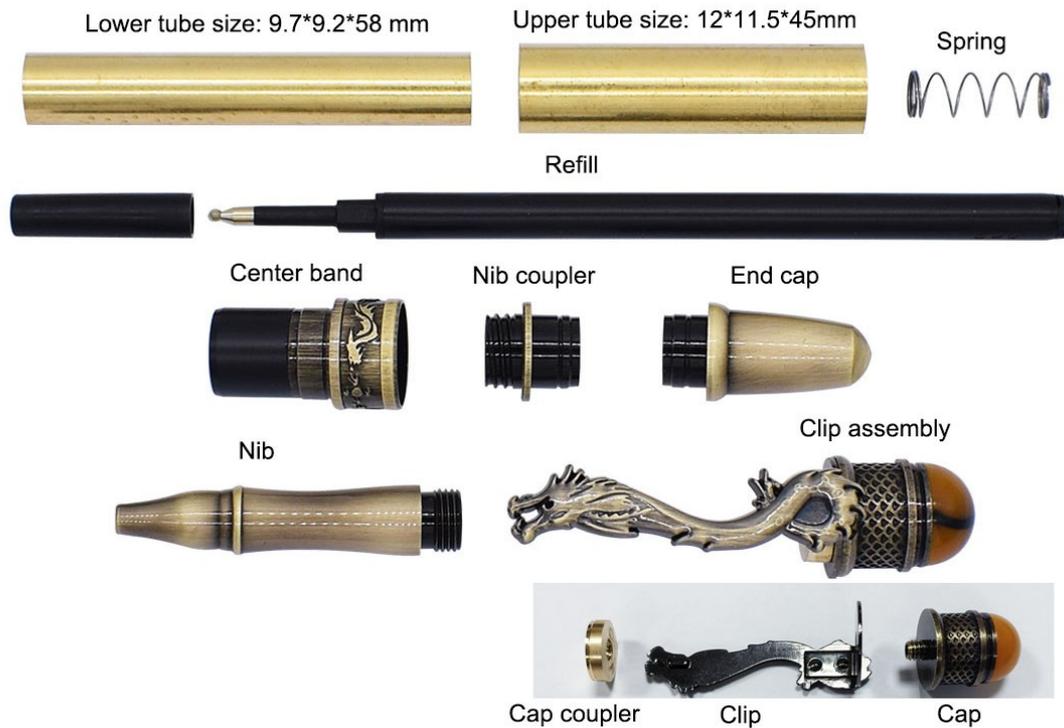
- Mount the bushings and blanks according to the diagram above.
- Thread on the knurled nut and hand tighten to hold all components in place.

- 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.

Fountain pen kits



Rollerball pen kits



Assembly

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

- Screw off the cap coupler and clip from clip assembly.
- Press the cap coupler to one end of the upper tube (shorter tube). Across the clip into the threaded stem. Screw the cap and clip to cap coupler.
- Press the center band, black end first, into the opposite end of the upper tube.
- Press the end cap into the one end of the lower tube.
- Press the nib coupler into the opposite end of the lower tube.

Fountain Pen Kits-----Attach the ink cartridge to the back of the fountain nib, then thread the fountain nib into the nib coupler.

Rollerball Pen Kits-----Insert the spring then the ink refill into the long tube. Thread the rollerball nib into the nib coupler.