

Xiamen Rizheng Industry Co.,Ltd

Economical Sierra Pen kits Assembly Instructions

Required Accessories:

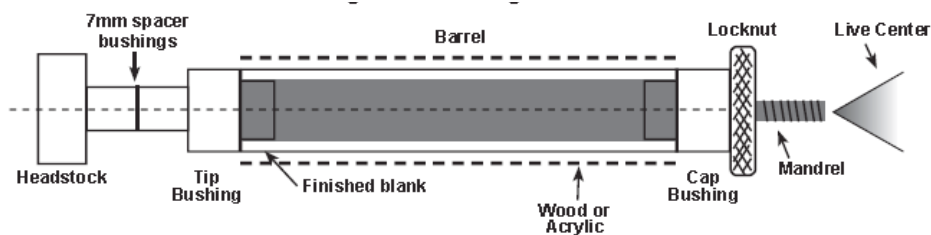
- 7mm, long mandrel
- 27/64" drill bit RZ- DB27/64
- barrel trimmer RZ-PM015
- 2-pc bushing set RZ-BP40#-BU
- 2 part epoxy glue or insta-cure (cyanoacrylate)
- Sanding and finishing supplies



Preparing the Blank

- Prepare a master blank of at least 5/8" square. Cut to the length of the brass tube (add 1/16" for trimming).
- Drill a 27/64" center hole through the blank.
- Glue the tube in the blank. Spread the glue over the tube; insert the tube into the blank with a twisting motion to spread the glue evenly. Center the tube inside the blank.
- Sand or barrel trim to square the ends of the blank

Diagram A



Turning the Blanks (see Diagram A)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing; narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

Diagram B

Brass tube Size:10.45*9.95*56mm



Refill



Twist mechanism



Spring



Nib assembly



Clip assembly



Cap



Assembly

(Line up finished parts according to Diagram B)

- Press the nib assembly into either end of the barrel.
- Insert and press the clip assembly into the opposite end of the barrel.
- Drop the refill with the spring into the opening at the clip end.
- Screw the twist mechanism into the clip assembly threads.
- Mount and push the cap over the mechanism stem to bottom.
- The pen operates by twisting the cap in either direction to advance or retract the refill