

Xiamen Rizheng Industry Co.,Ltd

Gentry Rollerball & Fountain Pen Kits Assembly Instructions

REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 4-piece bushing set RZ-RP51#-BU
- 12.3mm Drill Bit RZ-DB123
- 10.6mm Drill Bit RZ-DB106
- 2*2*13cm pen blank
- Universal barrel trimmer
- 2-part epoxy glue or insta-cure glue (cyanoacrylate).



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 centered hole lengthwise through each blank.

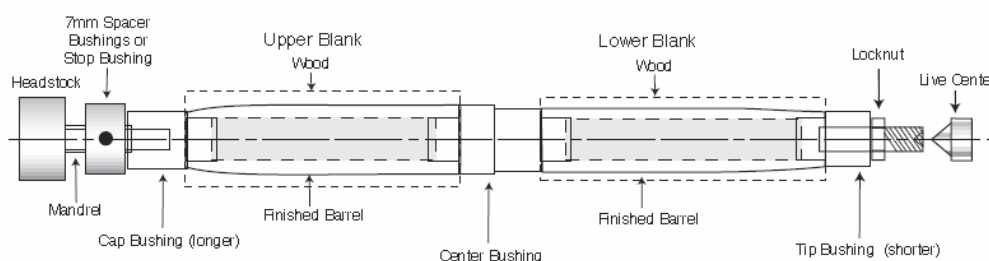
Upper blank (shorter tube)—drill a 12.3mm hole through.

Lower blank (longer tube)—drill a 10.6mm 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. 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 Blanks



Turning the Blank

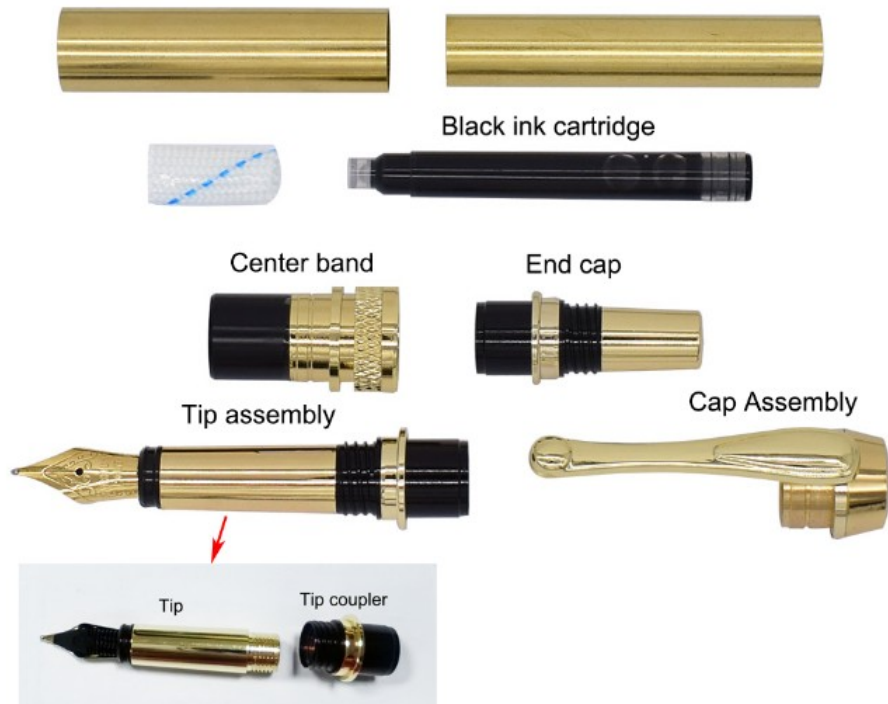
- Mount 7mm spacer bushings on the mandrel followed by the tip bushing (shorter diameter) wide end first.
- Slide the lower blank (long) on next. Follow with the center bushing, narrow diameter first, Slide on the upper blank (short) and follow with the cap bushing, narrow end first. Add additional spacer bushings as necessary to overlap the mandrel. Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel).

- Turn the blanks down close to the bushings. Follow with abrasives until the tube diameters are flush with the bushings
- Finish with your choice of polish.

DIAGRAM A – Assembly

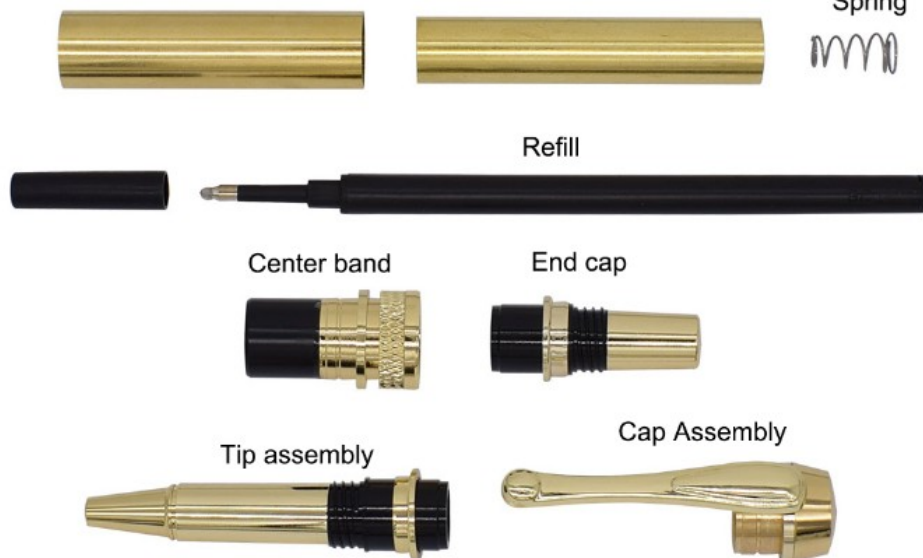
For Fountain pen kits

Upper tube Size:12.1*11.6*46.2mm Lower tube Size:10.4*9.9*53.4mm



For Rollerball pen kits

Upper tube Size:12.1*11.6*46.2mm Lower tube Size:10.4*9.9*53.4mm Spring



Assembly

NOTE: Line up the components according to DIAGRAM A.

- Press the cap assembly to one end of the upper tube (shorter tube).
- Press the center band, black end first, into the opposite end of the upper tube.

For Fountain Pen:

- Place the end cap into one end of the lower tube.
- Unscrew the tip assembly to tip and tip coupler
- Press the tip coupler into the opposite end of the lower tube.
- Attach the ink cartridge to the back of the fountain nib, then thread the fountain tip into the tip coupler.

For Rollerball Pen:

- Place the end cap into one end of the lower tube.
- Unscrew the tip assembly to tip and tip coupler
- Press the tip coupler into the opposite end of the lower tube.
- Insert the spring then the ink refill into the lower tube. Thread the tip into the tip coupler.