

Xiamen Rizheng Industry Co.,Ltd

Billiard Cue Rollerball Pen Kits Assembly Instructions

Required Accessories:

- 7mm Pen Mandrel
- 4 piece Bushing Set RZ-RP503#-BU
- 8mm Drill Bit (RZ-DB008)
- 10mm Drill Bit (RZ-DB010)
- Universal Barrel Trimmer
- Sandpaper/Finish
- 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)

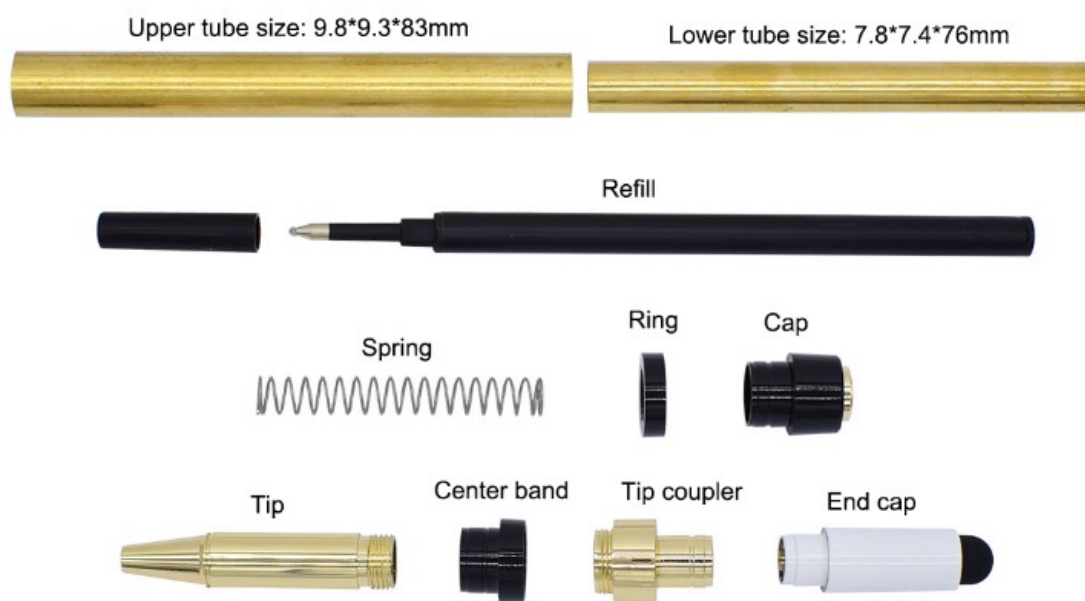
Mark the center of each blank.

- Drill a centered hole lengthwise through each blank.
Upper blank (shorter tube)—drill a 10 mm hole through.
Lower blank (longer tube)—drill a 8 mm 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 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 diagram.

- Press the Cap to one end of the Upper tube (long).
- Press the Center band into the opposite end of the Upper tube(long).
- Press the End cap into one end of the Lower tube(short).
- Cross the ring to the tip coupler and Press the Tip coupler into the opposite end of the Lower tube(short).
- Next slide the Refill with the Spring into the Lower tube. Thread the Tip into the Tip coupler and test action.