

# Xiamen Rizheng Industry Co.,Ltd

## Police Car Pen Kits Assembly Instructions

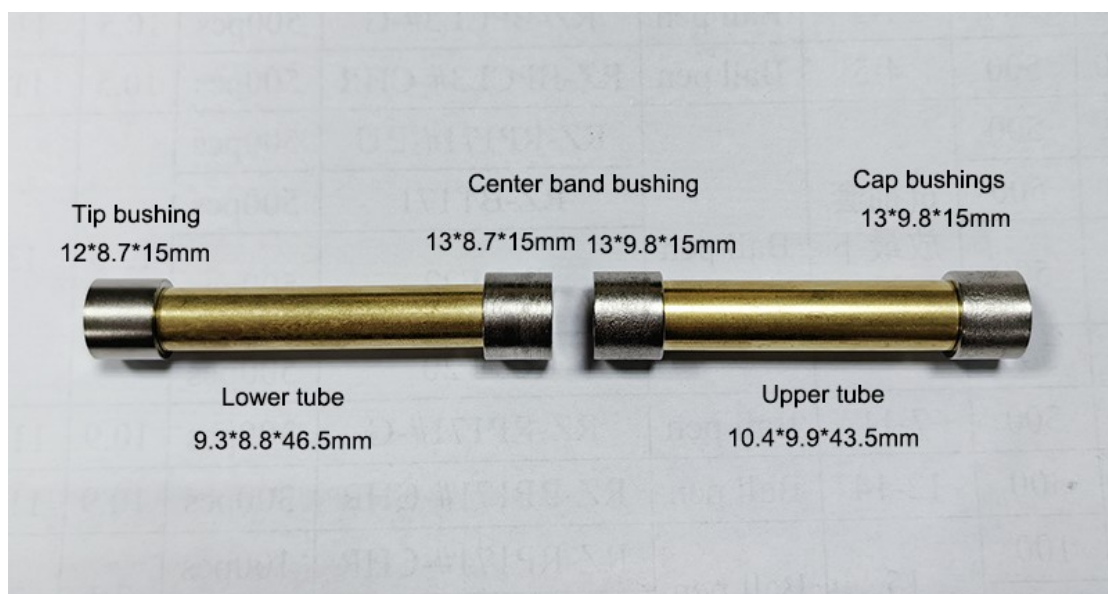
### Required Accessories:

- 7mm Pen Mandrel
- 9.5 mm Drill Bit RZ-DB3/8
- 10.6mm Drill Bit RZ-DB106
- Bushing set(4 pc) RZ-BP785#-BU
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size- 3/4" x 3/4" x 2-5/32"



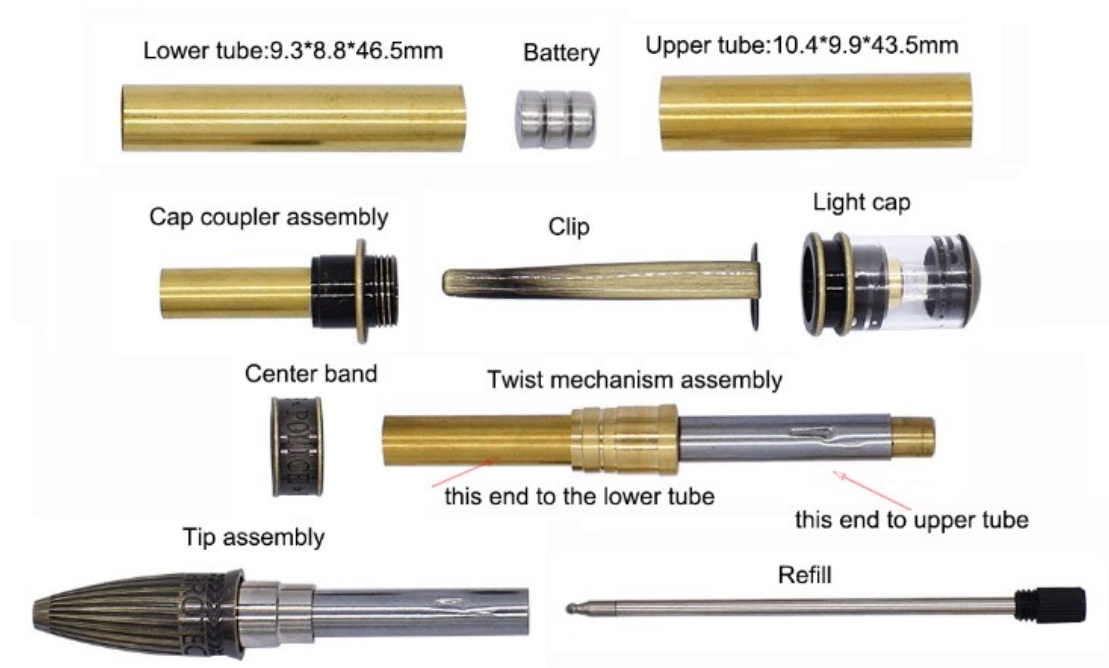
### Preparing the Blank

- Cut 2 blank to the length of the tube and add 1/16" for squaring off.
- Drill a centered hole lengthwise through each blank.
- Upper blank (shorter tube)—drill a 10.6mm hole through.
- Lower blank (longer tube)—drill a 9.5mm hole through
- Spread glue over the tube; insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use a 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 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, refer to polish instructions.



## Pen Assembly

NOTE: Layout Finished parts according to Diagram above.

- Press the cap coupler assembly into either end of upper tube.
- Put the battery into the cap coupler assembly.
- Insert the pen clip on the cap coupler assembly, then screw the light cap to the cap coupler assembly.
- Cross the center band to the twist mechanism assembly (from the tube end)
- Screw the Refill into tip assembly. Push the twist mechanism assembly with center band to the tip assembly.

- Push the other end to the upper tube.
- The pen operates by twisting the tip to advance or retract the refill for writing. Rotating the twist mechanism assembly with lower tube to control the light, you could see the flashing lights.