

Xiamen Rizheng Industry Co.,Ltd

Multifunction Pen Kits Assembly Instructions

Required Accessories

- 7mm pen mandrel
- 2-piece Bushing Set RZ-BP329#-BU
- 7mm drill bit RZ-DB007
- 7mm Barrel Trimmer RZ-PM011
- Live Tailstock Center
- Glue (Thick CA or Epoxy)



Preparing the Blank

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill one 7mm hole lengthwise through the blank.
- 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.

Diagram A

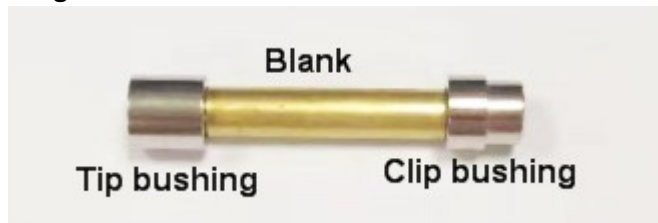
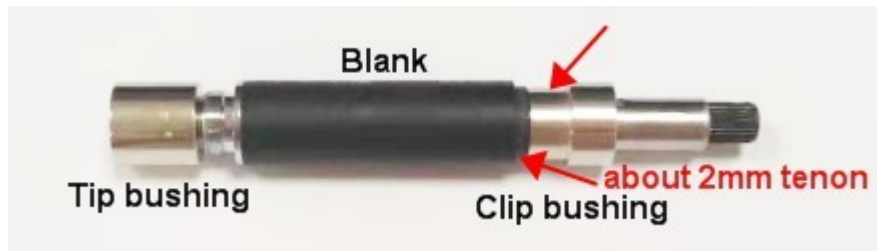


Diagram B (step 1)



Diagram C (step 2)



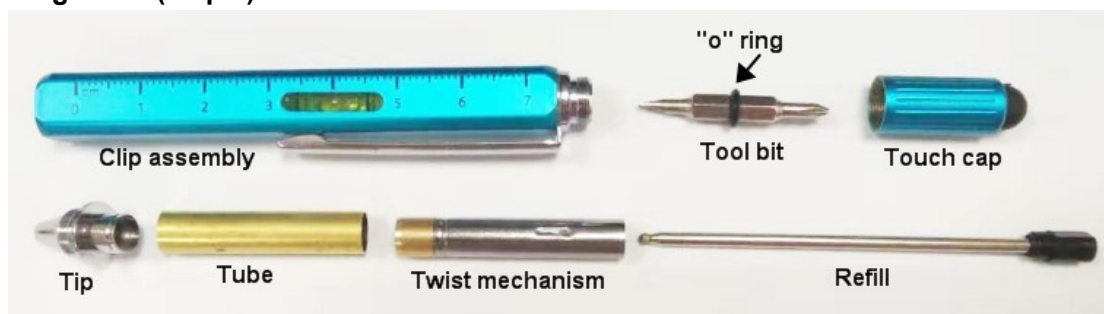
Turning the Blank

- Mount the bushings and blank according to the above diagram A/diagram B(step 1).
- 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)

Note: Place the Clip bushing oppositely according to diagram C (step 2) to make a 2mm tenon after finishing the diagram B. (We need to make 1-2mm tenon with this step bushing when we are turning the final blank, thus it can be inserted to the upper clip assembly straightly).

- 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.

Diagram D (step 3)



Assembly

NOTE: Layout Finished parts according to Diagram D.

- Press the Tip into either end of the Tube.
- Press the Twist mechanism into the other end of tube in place.
- Screw the Refill into the Twist mechanism.
- By hand, push the Tool bit with "O" ring into the Clip assembly.
- Screw the Touch cap into Clip assembly.
- Push the two halves of the pen. The pen operates by twisting the ends to advance or retract the refill for writing.