

PEN KITS ASSEMBLY INSTRUCTIONS FOR ACME PEN KITS

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 8mm RZ-DB008
- Bushing set(4 pc) RZ-BPCL138-BU
- Barrel Trimming set (use 8mm shaft) RZ-PM012
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size - 3/4" X 3-3/4" L
- Plunger: 1/2" sq X 5/8" L

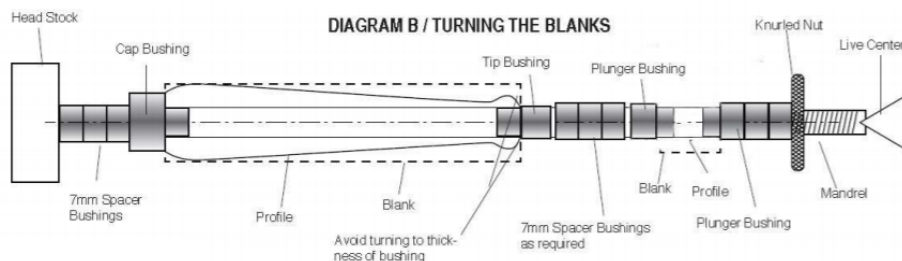


Preparing the Plunger Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill an 8mm hole lengthwise through the blank.
- Spread glue over the tube, insert the tube into 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 8mm barrel trimmer with sleeve. Take the excess material down flush with the ends of the brass tube. NOTE: Plunger bushings are not the same diameter. To insure smooth plunger operation. Do not exceed the wood over the bushings. Follow assembly instructions for positioning

Preparing the Pen Body Blank:

- Cut 1 blank to the length of the tube and add 1/16" for squaring off.
- Drill an 8mm hole lengthwise through the blank.
- Spread glue over the tube, insert the tube into 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. You can use a 8mm barrel trimmer. Take the excess material down flush with the ends of the brass tube. NOTE: The profile of the barrel is tapered. It is thin at the tip end. Do not taper to the tip. Shape the end for a wider diameter. See suggested profile in diagram B.



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Turning the Blank

- You may turn the pen blank and the plunger on the same mandrel together. Pen Blank: Turn the barrel to a pleasing profile. You may design a oversized bead on top and curve the wood at the tip to avoid the thin wall if turned straight to the bushing. Plunger: Turn a straight profile. NOTE: Do not leave wood on the plunger to exceed the bushings otherwise it will effect the plunging and sliding. Sand smooth up to the bushings.

DIAGRAM A



Assembly

- Layout parts according to diagram A

PEN BARREL:

- Insert the mechanism assembly, threaded end in first through the narrow end of the barrel.
- Follow with the support tube into the same opening. Press the assembly tip into the same opening until the base of the tip bottoms onto the barrel.
- Press the cap assembly into the wide turned end of the barrel.
- Unscrew the tip, Insert the refill into the opening at the tip. Affix the refill spring. Screw the tip over. PLUNGER:
- Press the lower end (wider) into the wide end of the plunger.
- Press the plunger cap into the (narrower) opposite opening.
- Drop the click spring into the opening at the cap assembly. Place the plunger, threaded side in first and screw over the spring onto the mechanism to bottom.
- The pen is ready to use by clicking on the plunger to advance or retract the refill. Unscrew the tip to replace refill.