

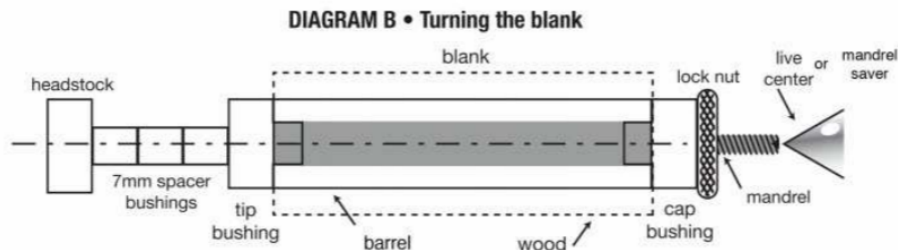
## PEN KITS ASSEMBLY INSTRUCTIONS FOR DAWNGUARD PEN KITS

### Required Accessories

- 7mm Pen Mandrel
- 8mm drill bit RZ-DB008
- 2-pc bushing set RZ-BPCL101#-BU
- Universal barrel trimmer RZ-PM012
- 2 Part epoxy or insta-cure (cyanoacrylate) glue

### Preparing the Blank

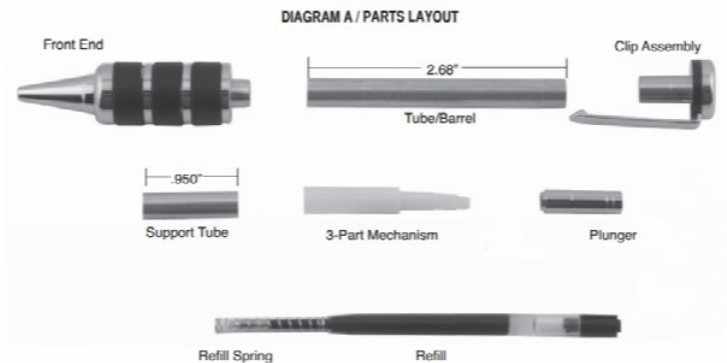
- Cut a blank to the length of the tube and add 1/16" for squaring off.
- Drill a 8mm hole lengthwise through the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blank. Use a 7mm barrel trimmer, 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.



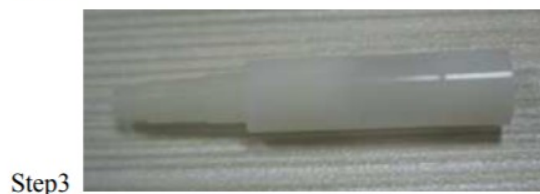
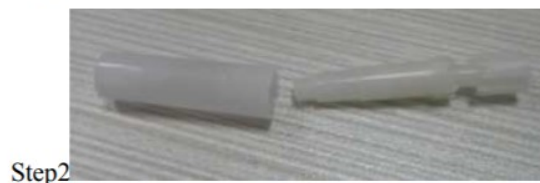
### Turning the Blank

Place 7mm spacer bushings onto the mandrel, followed by tip bushings, wide end in first. Place the barrel over the bushing. Slide on the cap bushing, narrow end first. Add spacer bushings as necessary. Thread on the lock nut; hand tight over the mandrel shaft. Bring the tailstock snug to the mandrel and lock it in place. Tighten the lock nut for turning. Do not over tighten the nut, it could damage the mandrel. Turn the wood down in a straight profile and sand to the bushing diameter. Finish the wood with your choice of polish.

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### Click mechanism assembly



### Assembly

- Layout parts according to diagram A
- Press the clip assembly into the top of the barrel
- Insert the 3 part plastic mechanism, threaded end in first into the bottom of the barrel. Follow with support tube.
- Press the front end into the barrel after the support tube.
- Insert the refill spring, black end in first into the opening. Thread the tip over the refill until it bottoms.
- Insert the plunger, opened end first and thread over the plastic threads until tight.
- Thread the upper nut and tighten.
- Operate the pen by clicking on the plunger.