

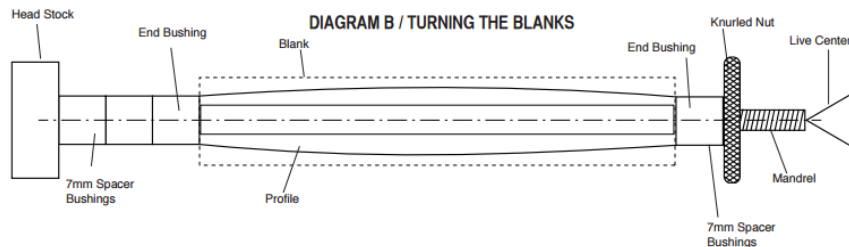
MINI RETRACTABLE PEN KIT ASSEMBLY INSTRUCTIONS

REQUIRED ACCESSORIES:

- 7mm, Pen Mandrel
- bushing set RZ-BPTS186#-BU
- drill bit 7mm RZ-DB007
- Barrel Trimmer 7MM RZ-PM011
- Glue (Thick CA or Epoxy)
- Pen Blank: Minimum Size - 2-1/2" x 5/8"

Preparing the Blank:

- Cut one blank to the length of the tube and add 1/16" for squaring off.
- Drill a 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 blanks. Use a 7mm barrel trimmer to take the excess material down flush with the ends of the brass tube and clean the inside of the tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly).



Turning the Blank

- Mount the bushings and blanks according to diagram B.
- 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.

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Diagram A

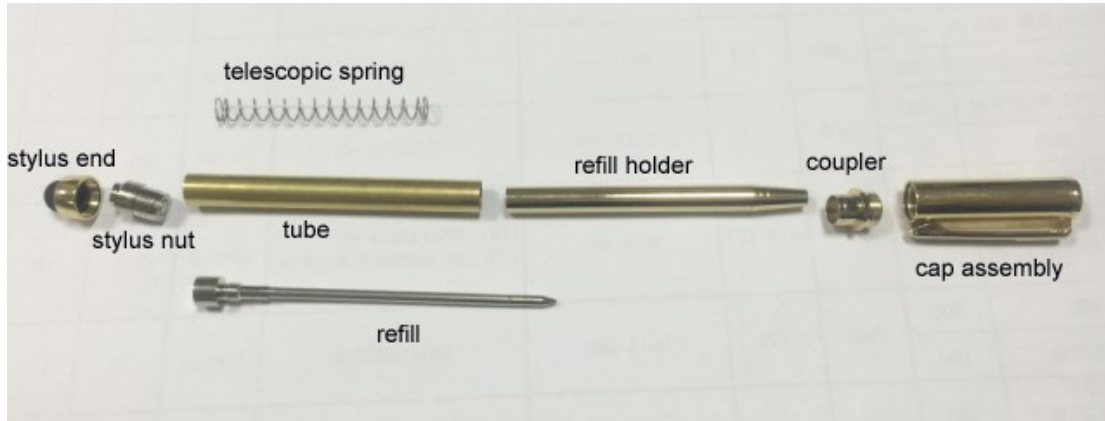
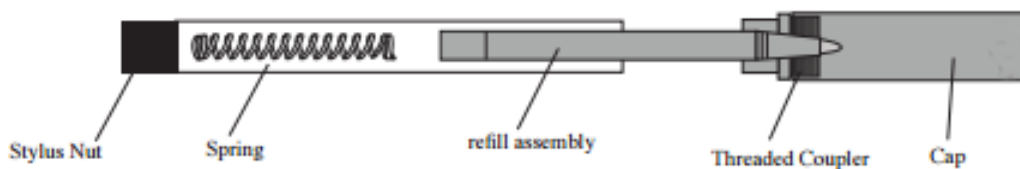


Diagram C



Assembly

- Layout parts according to Diagram A
- Press the stylus nut recessed end first into either end of barrel.
- Insert the spring into the barrel through the opening at the opposite end.
- Screw the threaded coupler into the open end of the cap assembly
- Place refill into the refill holder , insert the refill assembly Tip end first into the cap.
- Slide the refill into the barrel and press the cap and coupler (now together) into the tube (see Diagram. C).
- Screw the stylus end into the stylus nut.
- The pen is ready to use by unscrewing the cap off or on when not in use. The refill will pop-out to the full extension to write.