

PERMANENT MARKER PEN KIT ASSEMBLY INSTRUCTIONS

Required Accessories:

- 7mm, Pen Mandrel
- 14mm Drill Bit & 15mm Drill Bit
- 4 pcs Bushing Set RZ-BP174#-BU
- Universal Barrel Trimmer
- Sandpaper/Finish
- Glue (Thick CA or Epoxy)

Preparing the Blanks:

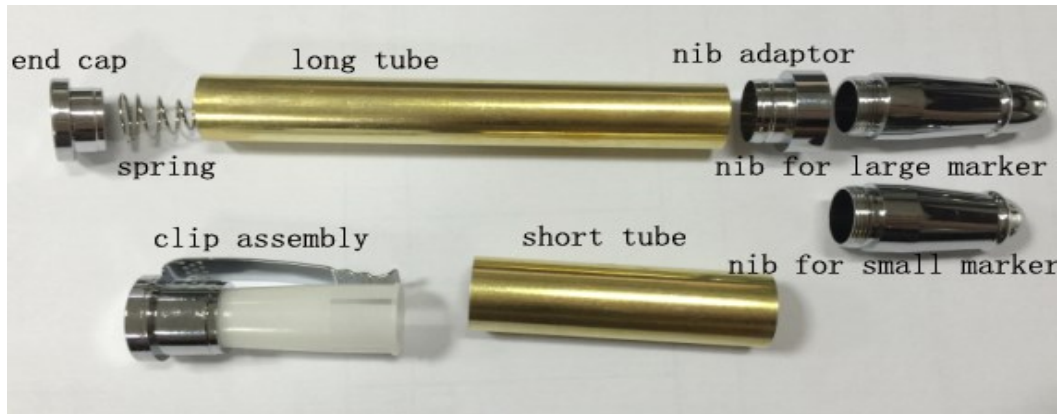
- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a centre hole lengthwise through each blank.
 - Upper blank (short tube) - drill a 15mm hole through.
 - Lower blank (long tube) - drill a 14mm hole through.
- Glue the brass tube in the blank. Spread the glue on the tube. Insert into the blank with a twisting motion to spread the glue evenly inside. Centre the tube lengthwise in the blank. Allow it to dry.
- After the glue dries, use Barrel Trimmer to square the ends of the blank to flush with the ends of the brass tube.



Turning the Blanks

- Assemble the blanks on the mandrel using the matched bushings. Be sure to get the right bushings in the right tubes.
- Tighten the tailstock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks.
- Turn the blanks to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
- After turning the blank, sand the surface in progressive steps until you get to 400 or 500 grit.
- If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
- Apply the finish of your choice and polish.
- Remove the blanks from the mandrel.

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Assembly

NOTE: Line up the components according to the above picture.

1. Press the nib adaptor into one end of the long tube.
2. Press end cap into the other end of the long tube.
3. Drop the spring, large end first, into the long blank.
4. Uncap your marker and drop it into the long blank with the marker nib sticking out.
5. Select the appropriate nib for the size marker you use and screw it into place over the marker.
6. Press the clip assembly into one end of the short tube.
7. The pen is ready to operate.