

PEN KITS ASSEMBLY INSTRUCTIONS FOR SECRET TOP PEN KITS

Required Accessories

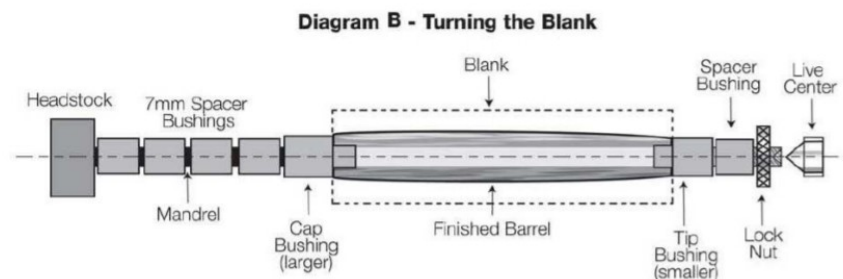
- 7mm Pen Mandrel
- 2 pcs bushing set RZ-BP47#-BU
- 8.5 mm drill bit
- Universal Barrel Trimmer
- 2 part epoxy glue or Insta Cure (cyanoacrylate) glue

Preparing the blanks

- Cut 3/4" to 5/8" square blank to the size of the brass tube (add 1/16" for trimming)
- Drill a 8.5mm center hole lengthwise through the blank.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside . Center the tube lengthwise in the blank
- When the glue dries, use a universal squaring jig or a belt/disc sander to square the ends. Trim the wood down, flush to the brass tube.

Turning the Blanks (see Diagram B)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing; narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.



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Assembly

(Line up finished parts according to Diagram A)

- Screw the tip support into the tip ,then press it to one end of tube.
- Insert the refill to the brass top ,then screw the screw top onto the brass top.
- Insert the top support to the clip, then link to the brass top.
- Insert the mechanism into the refill.
- Push the two pen halves together.
- The pen operates by twisting the cap to extend or retract the refill.