

Xiamen Rizheng Industry Co.,Ltd

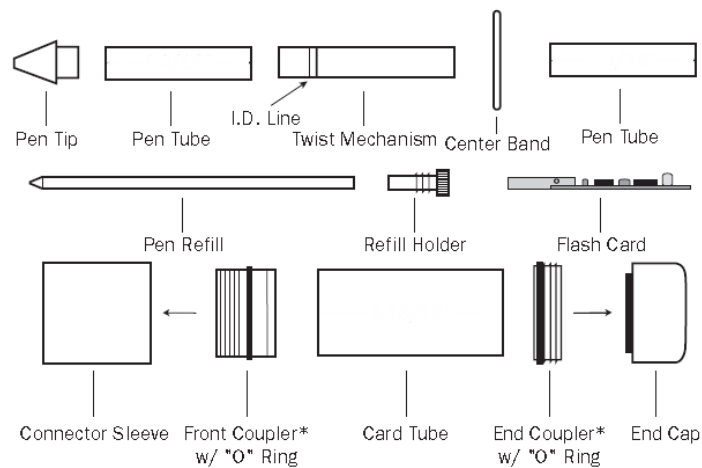
4G USB Drive Pen Kits Assembly Instructions

REQUIRED ACCESSORIES:

- 7mm pen mandrel
- 4pc bushing set
- 7mm drill bit
- 11/16" drill bit
- Universal pen blank squaring jig or a 10mm shaft barrel trimmer with sleeve
- 7mm barrel trimmer
- Tenon cutting tool or parting tool
- 2-part epoxy glue



Diagram A - PARTS LIST



PREPARING THE WOOD BLANKS:

Cut 1" square blanks to the length of each of the 3 brass tubes. Add 1/16" for squaring off.

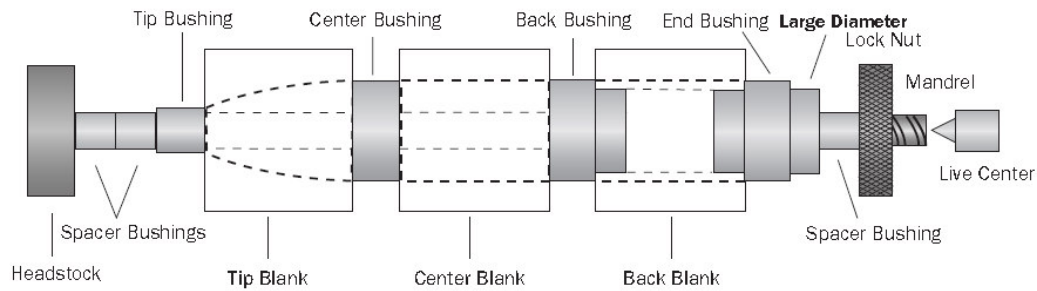
Drill 7mm holes lengthwise through the 2 pen blanks

Drill 11/16" hole lengthwise through the card blank

Apply glue over each of the tubes; insert into the proper blank with a twisting motion to spread the glue evenly inside. Center the tubes lengthwise in the blanks.

When the glue dries, use 7mm barrel trimmer for the pen blanks & a universal barrel trimmer and for the card blank; use a 10mm trimmer shaft with the special trimmer sleeve

Diagram B - TURNING THE BLANKS

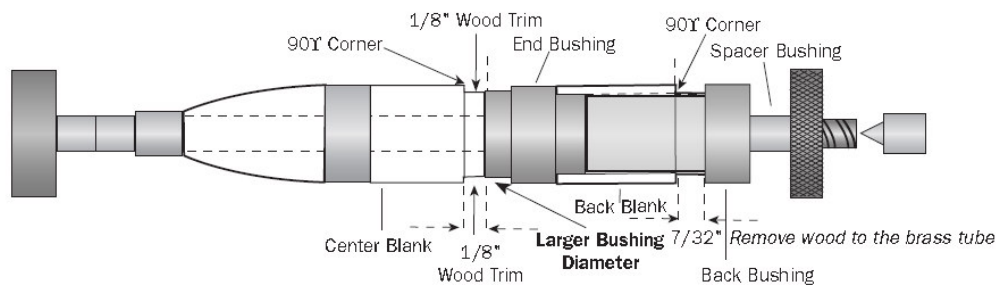


TURNING THE BLANKS

Place spacer bushings on the mandrel if needed. Next, slide on the tip bushing, then the tip blank, follow with the center bushing and then the center blank. Next the back bushing (large diameter on first). Then the back blank, follow with the end bushing (small diameter on first).

Use spacer bushings when necessary to fill the gap on the mandrel shaft between the last bushing and threads. Thread on the lock nut hand tight to hold the assembly in place. Slide the tailstock snug to the mandrel shaft (do not over-tighten, it may damage the mandrel). Lock into place, turn the wood down, flush with the bushings. At the tip end, cut a downward tapered profile. Finish with gradually higher grits of abrasive.

Diagram C - REMOVING WOOD/TENON CUTTING



CUTTING A TENON

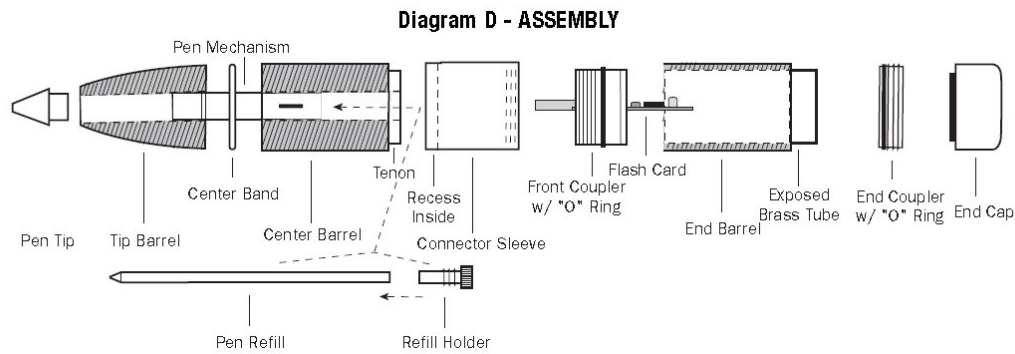
Untighten the lock nut on the mandrel. Pull out the end and the back bushings and change their positions. The larger diameter of the end bushing will go on first against the center blank. (see Diagram C) Lock assembly in place.

Make a pencil mark at 1/8" in from the edge of the center blank. Using a tenon tool, remove wood down to the bushing diameter. Keep a sharp 90° at both corners of the wood.

REMOVING WOOD

On the back blank, place a pencil mark 7/32" from the edge of the blank. Use a tenon tool to remove the wood down to the brass tube. (See Diagram C). Keep a sharp 90° corner on the wood.

Finish the barrels with your choice of polish.



ASSEMBLY

Press the tip into the tapered end of tip barrel.

Press the pen mechanism, brass end in first to the indentation line of the chrome side.

Insert the band over the mechanism shaft.

Press the refill holder over the refill. Turn the pen mechanism counter clockwise until it stops at the top.

Insert the refill assembly and screw in until 1/16" of the holder is showing through. Twist forward for the refill tip to appear.

Squeeze glue into the recess (opposite the threaded end) inside the connector sleeve. Insert the tenon at the center barrel. Clamp in a vise. Let dry.

Press the front coupler, recessed end in first into the front end of the barrel as shown in Diagram D.

Slip on a 'O' ring over the threads and into the groove.

Slide the end coupler, solid end in first over the exposed brass tube to the end. Slip an 'O' ring over the threads into the groove.

Insert & push the flash card, chrome end in first through the opening at the barrel to fit through the bottom slot of the front coupler. Push until the card bottom at the slot.

Thread on the end cap over the opening at the barrel to close the card in.