

# Xiamen Rizheng Industry Co.,Ltd

## Lighter Ball Pen Kits Assembly Instructions

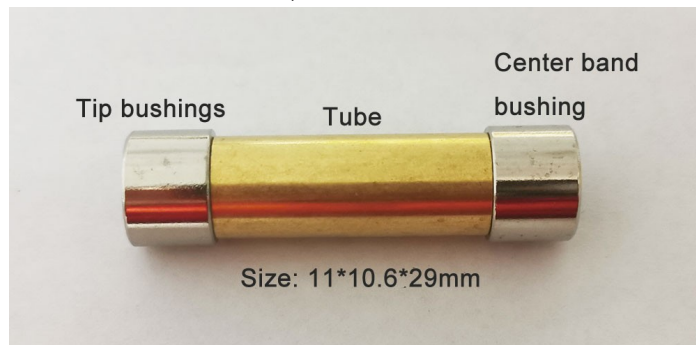
### REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- 11.2mm drill bit
- 2-piece Bushing Set RZ-BP455#-BU
- barrel trimmer
- Glue (Thick CA or Epoxy)



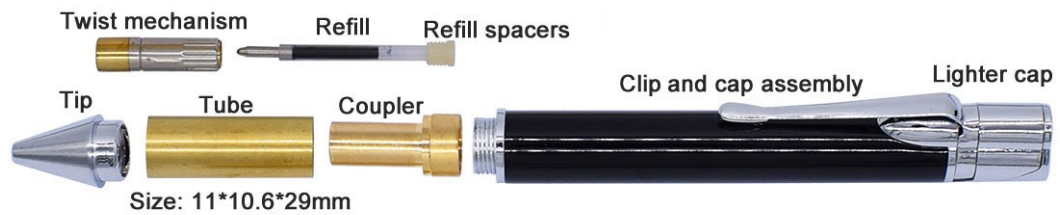
### PREPARING THE BLANK

- Cut a 5/8" to 1" square blank or larger, depending on your design, to the length of the tube (add 1/16" for squaring off).
- Drill a 11.2mm center hole lengthwise through the blank.
- Spread glue over the tube, then insert it into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue dries, use a barrel trimmer, universal squaring jig, or a belt/disc sander to take the wood down, flush to the brass tube.



### TURNING THE BLANK

- Mount the bushings and blanks according to diagram above.
- 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 Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- 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 sandpaper grits. • Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.



### ASSEMBLY

- Line-up the parts according to the above picture.
- Press the coupler into the end of the tube.
- Press the twist mechanism to the tip, insert and screw the refills with the refill spacers into the twist mechanism.
- Press the tip into the opposite end of the tube.
- Screw the coupler into the clip and cap assembly, then the lighter pen is ready,
- The pen operates by twisting the pen body to extend or retract the refill.
- You need to equip a gas filling tool when you want to refill the gas into the end of the pen body.