

Xiamen Rizheng Industry Co.,Ltd

MK52# Magnifier Kits Assembly Instructions

Required Accessories

- 7mm Pen Mandrel
- 7mm drill bit RZ-DB007
- 2 pc bushings set RZ-MK52#-BU
- barrel trimmer
- epoxy glue or insta-cure (cyanoacrylate) glue



Preparing the Blank

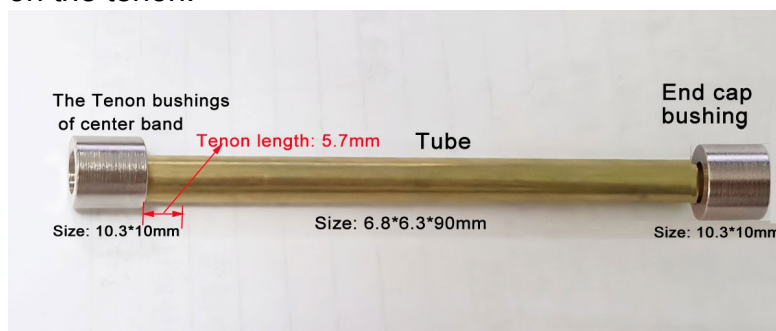
- Cut a blank of 5/8" square to the length of the brass tube. Add 1/16" for squaring off.
- Drill a 7mm hole through the blank.
- Spread glue over the tube, insert into the blank with a twisting motion to spread the glue evenly inside.
- When the glue dries, use barrel trimmer to square the ends of the blank. Take the wood flush with the brass tube.

Turning the Blank

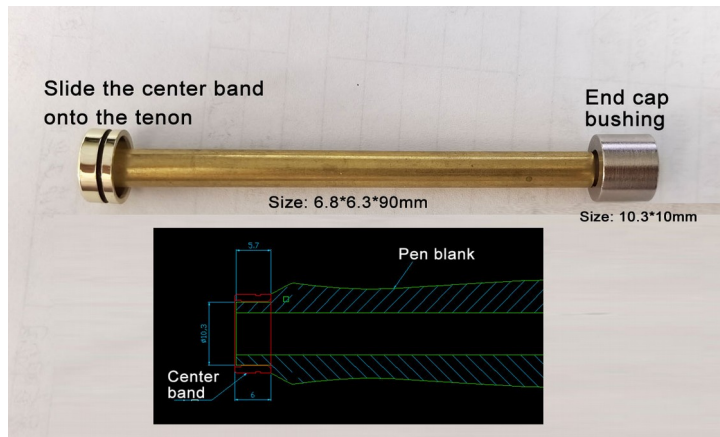
- Place the tenon bushings of center band on the mandrel. Place the glued wood blank and the other end cap bushing onto the mandrel. Place locknut on, hand tighten. Bring up the tail stock snug with the live center. Tighten live center to mandrel. Tighten stop bushing and lock nut. Do not overtighten the knurled nut, it may damage the mandrel.

Cutting the Tenon in advance:

Per the following diagram shown, make a pencil mark 5.7mm from end. Use a parting tool to cut a 5.7mm tenon down to the diameter of the bushing(Diameter: 10.3mm). Make sure you keep a sharp outside 90° corner on the tenon.

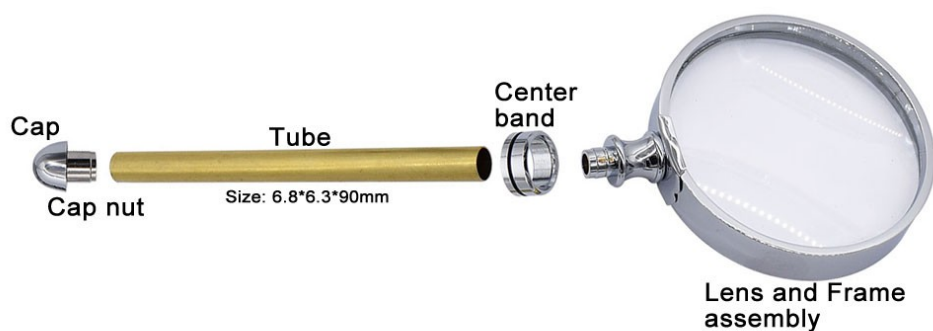


Turning the Blank:



- Slide center band (square end first) over the tenon.
- Mount end cap bushings and blank according the diagram above on the mandrel.
- 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.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)(Note: Avoid scratching the center ring, please be more careful when you turn the wood down to the center band)
- Sand the blank down to be flush with the bushings or center band gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.

Assembly



Layout the parts as shown. Use a vise or clamp with wood or plastic jaws to prevent damaging parts during assembly.

1. Press the nut and cap into one end of the brass tube.
2. Use a drop of glue around the tenon, slide center band (square end first) over the tenon. Push in, let dry.
3. Press the coupler of lens and frame assembly into the end of the brass tube, then finished.