

Xiamen Rizheng Industry Co.,Ltd

Dawn Click Pen Kits Assembly Instructions

Required Accessories

- 7mm Long Mandrel.
- 2 Piece Bushing Set RZ-BPCL770#-BU
- 8mm Drill Bit RZ-DB008
- Barrel Trimmer
- Epoxy Glue or Insta-Cure (cyanoacrylate).



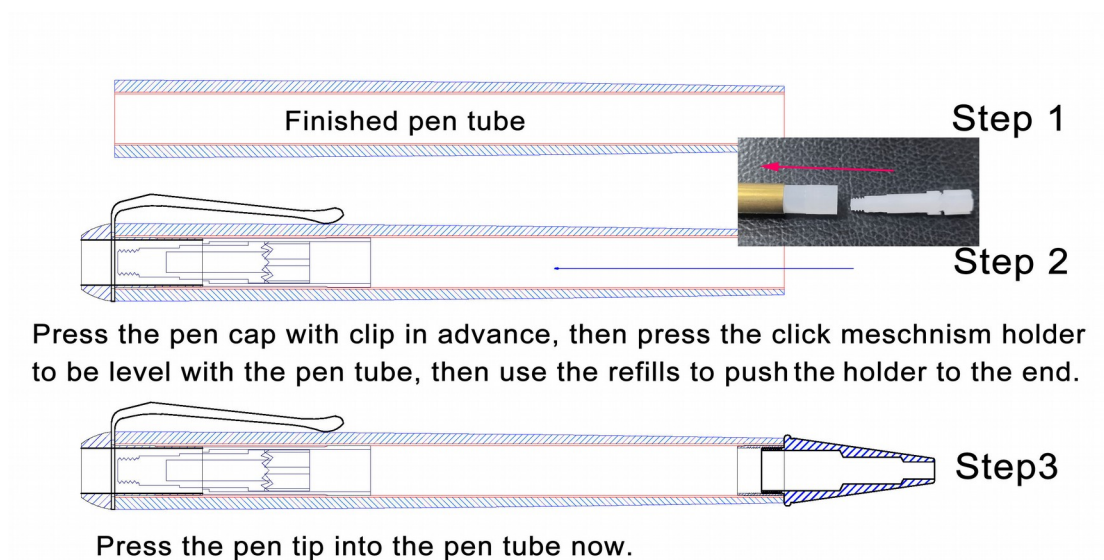
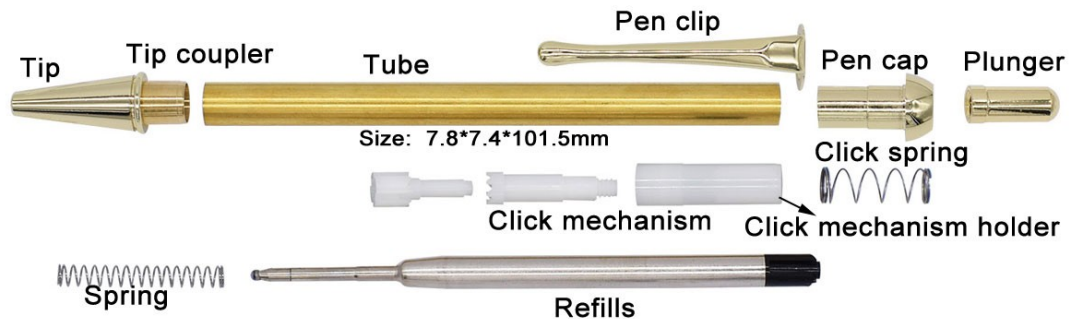
Preparing the Blank

- Cut the pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 8mm 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, square the end of each blank. Use a Barrel trimmer with 7mmmm shaft or a universal pen blank squaring jig with a power disc sander.

Take the wood down to the brass tube. Do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly. Use the barrel trimmer shaft to clean the inside of the tube.

Turning the Blanks

- Mount the bushings and blanks on the mandrel according to the 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 in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
- 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 the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.



Assembly

Layout parts according to diagram above.

- Press the pen cap into the clip then onto the end of tube.
- Press the click mechanism holder into the opposite end of the tube in advance, it will be level with the end of tube.
- Insert two small click mechanism parts to the click mechanism holder, then use the refill to push the holder into the end of the pen cap. (It is very important for this step.)
- Press the pen tip with the tip coupler into the end of the tube.
- Unscrew the pen tip, insert the refill with the spring into the open end of the coupler.

Note: Make sure the Refill go through the tube end to show the Click mechanism.

- Insert the click spring, then thread the plunger onto the end of the Click assembly. Note: Do not over tighten the assembly onto the Click Mechanism.
- To advance the refill press the end of the click mechanism, to retract the refill press the end of the click mechanism again.