

Rifle Bolt Pencil Kits Assembly Instructions

Required Accessories

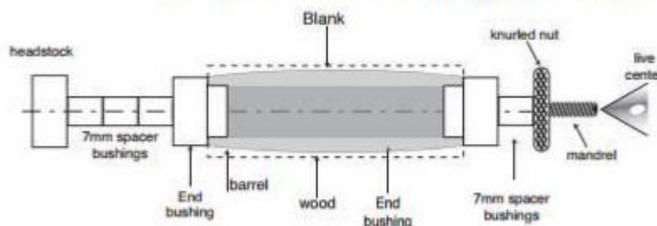
- 7mm pen mandrel
- 2 piece Bushing Set RZ-BP84#-BU
- Drill Bit 3/8" RZ-DB3/8
- Barrel Trimmer use 3/8" Shaft RZ-PM013
- Live Tailstock Center
- Glue (Thick CA or Epoxy)
- Pen Blank: Minimum Size- 5/8" x 2 1/4"



Preparing the Blank

- Cut 1 blanks to the length of the tube(s) and add 1/16" for squaring off.
- Drill 3/8" holes lengthwise through the blanks.
- Spread glue over the tube(s), insert the blank with a twisting motion to spread the glue evenly inside.
- Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks. Use a 3/8" barrel trimmer, or a universal pen blank squaring jig with a power disc sander. Take the excess material down flush with the ends of the brass tube. (do not trim beyond the length of the tube since this may interfere with operation of the mechanism and assembly). Use a barrel trimmer to clean the inside of the tube.

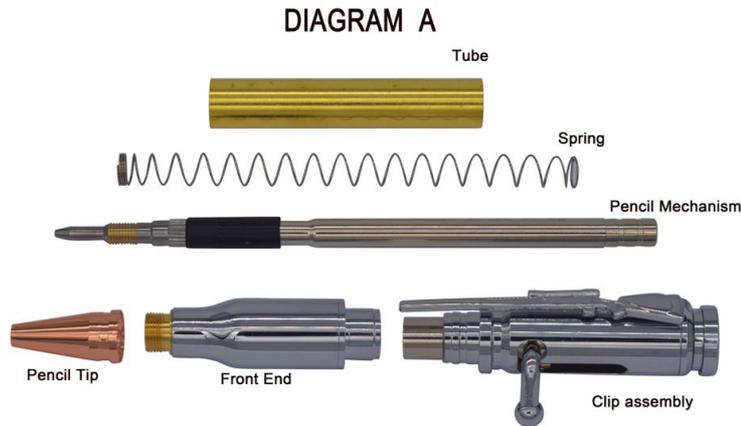
DIAGRAM B - Turning the Blanks



Turning the Blank

- Mount the bushings and blanks according to the diagram B.
- 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 A
- Press the clip assembly into either end of the tube.
- Slide the spring, in first through the opening at the opposite end of the tube.
- Press the front end into the opening at the tube.
- Thread pencil tip onto the front of the pencil mechanism.
- Slide the mechanism(attached to tip) into the front opening; screw the tip onto the front end.
- To advance the lead, just click on the bolt once or twice. The bolt can be left in the small hook in the channel to allow for easy lead advancement while writing.
- To retract the lead, press the bolt down and push the lead back into the tip, then allow the bolt to retract fully.
- To reload with new lead, remove the mechanism and pull the black plug. Load with a maximum of five -7mm lead sticks.
- To use the eraser, unscrew and remove the upper cap to reach the eraser. Replace eraser.