



## Xiangyun Lever Action Pen Kits Assembly Instruction

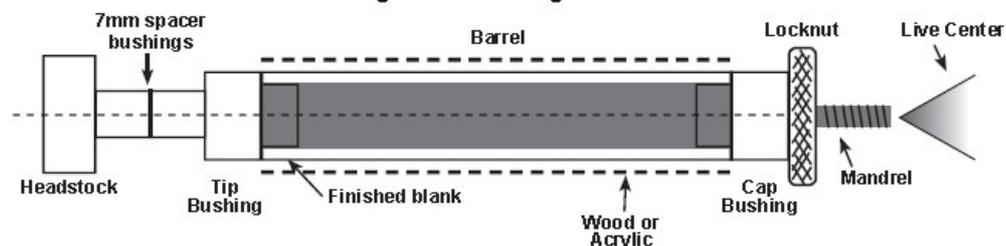
### Required Accessories:

- 7mm, Pen Mandrel
- 10mm Drill Bit RZ-DB010
- 2 piece Bushing Set RZ-BP191#-BU
- Universal Barrel Trimmer
- Sandpaper/Finish
- Glue (Thick CA or Epoxy)

### Preparing the Blanks:

- Cut one pen blank to the length of the brass tube (add 1/16" for trimming).
- Drill a 10mm hole lengthwise through the blank.
- Glue the brass tube in the blank. Spread the glue on the tube. Insert into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank. Allow it to dry.
- After the glue dries, use Barrel Trimmer to square the ends of the blank to flush with the ends of the brass tube.

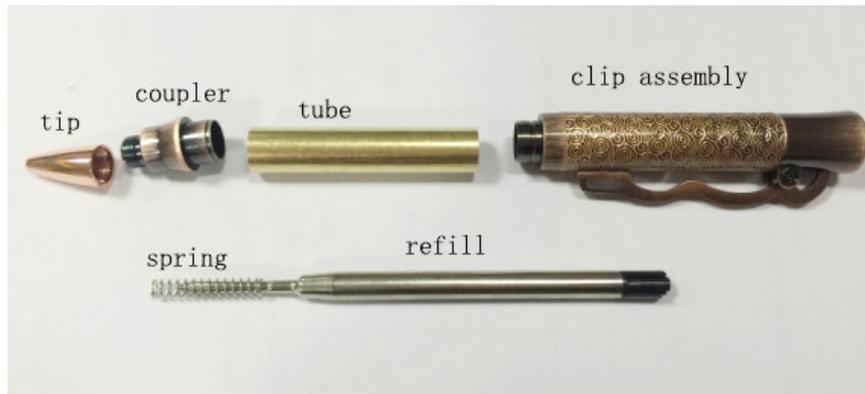
(see Diagram A)



### Turning the Blanks (see Diagram A)

- Mount 7mm spacer bushing on the mandrel, followed by the tip bushing; wide end first. Insert the blank. Follow with the cap bushing; narrow end first. Mount spacer bushing to fill the space to the threads on the mandrel. Screw on the knurled nut hand tight. Bring the tailstock in snug to the mandrel and tighten the knurled nut for turning. Do not overtighten the knurled nut, it may damage the mandrel.
- Turn the blank down close to the bushings. Follow with abrasives until the barrel diameters are flush with the bushings.
- Finish with your choice of polish.

## Diagram B



### Assembly

(Line up finished parts according to Diagram B)

- Press the clip assembly into one end of the tube.
- Press the coupler into the opposite end of the tube
- Insert the refill with spring into the opening end of the pen. Then screw the tip to the coupler.
- The pen is ready to operate. Just twist the cap from one position to another to extend or retract the refill.