

**Zoltin Pen Kits Assembly Instructions**

**REQUIRED ACCESSORIES**

• 7mm Long Mandrel.

• 2 Piece Bushing Set. BU2002

• Drill Bit. 25/64

• pen mill PM014

PREPARING THE BLANKS

1. This pen needs 1 tube and therefore only 1 blank. Cut the blank slightly longer than the tube.

2. Drill a hole through the center with a 25/64 drill bit, along the length of the blank

3. Lightly sand the tube with sandpaper on the outside. It is preferable to do this by hand. The purpose of roughening the tube is so that the adhesive has better adhesion to the surface.

4. After connecting, clean the tube with acetone or alcohol on a cloth.

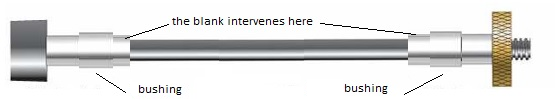
5. Glue the tube into the wood. When the glue is dry, remove all glue residue from the inside of the tube. Failure to remove all glue from the tube is the most common cause of pin failure.

MAKE SURE all dried glue has been removed from the tubes before!

continue.

6. Use a properly sized pen mill to trim the ends of the blank down to the tube. STOP at this point. Correct functioning of the pen depends on the correct length of tubes.

7. Mount the blank to the mandrel using the appropriate bushings.



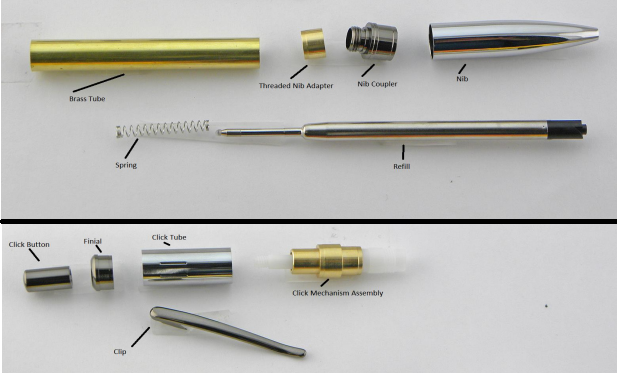
8. Tighten the tailstock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks..

9. Turn the blank to the desired contour, making sure the area next to the

bushing is turned to the size of the adjacent bushing.

10. After you have turned the blank, sand the surface and finish the blank with a finishing product of your choice.

**Assembly**



For assembly please refer to the Parts diagram:

The most common mistake that results in a non-functional or damaged pen is the misalignment of the parts when they are pressed into place. When pressing the various parts, make sure that the parts straight and in line.

If the part is misaligned, and thus becomes misaligned, the result will be at the very least an poor fitting pen. In the worst case, you may have a pen that does not function properly and is not usable. So be careful with this!

One more word about pen parts. Occasionally you will come across parts that have a bit of a loose fit. This can be corrected by using a SMALL drop of glue (usually CA) on parts before pressing them together.

Assemble the Pen Parts Diagram Please refer to the Parts diagrams above.

1. Press the nib coupler into nib. Be careful not to damage threads. Set this aside for now.

2. Press the Threaded Nib Adapter into one end of finished brass tube (indent first).

3. Press Click Mechanism (Large White End) into the other end of finished blank.

**DO NOT PRESS ON THE WHITE CLICK MECHANISM!!!!!!!!!! Use a block of wood with a small hole drilled all the way through it so that you Are pressing on the brass not the white part. Failure to do this will cause the click not to function**.

4. Press the click tube on the other end of the click mechanism until it is flush with the pen blank.

5. Press the finial into click tube.

6. Press clip on to the click tube. This will click into place with thumb pressure.

7. Thread on click button.

8. Slide spring on refill.

9. Insert refill and thread on nib.

10. Check for proper operation of the click assembly and refill. Now your pen is finished!