

WoodRiver® Titanium Comfort Ring Kit Instructions

Product: #171925, #171877, #171878, #171879, 2/21/2020
 #171880, #171881, #171882, #171926, #171927,
 #171928, #171883, #171884, #171885, #171886,
 #171887, #171888, #171929, #171930

Supplies Needed to Complete Kit:

- Comfort Ring Core
- Ring Blank Material
- Comfort Ring Core Bushings
- Pen Mandrel
- Double-faced Turning Tape
- Drill Chuck
- Drill Bit
- Revolving Center
- 4-Jaw Chuck
- Scrap Wood Block
- 5-Minute Epoxy or Thick CA Glue
- Sandpaper
- Eye & Ear Protection
- Dust Mask

Sizing the Ring Core:

Mount a 2" x 2" x 3" block of scrap wood in the 4-jaw lathe chuck. Turn to round and true up the face of the block.



Selecting Ring Blank Material:

Recommend using acrylic, stabilized, or a dense exotic hardwood. Blank will need to be $\frac{1}{16}$ " - $\frac{1}{8}$ " wider than the chosen ring core.

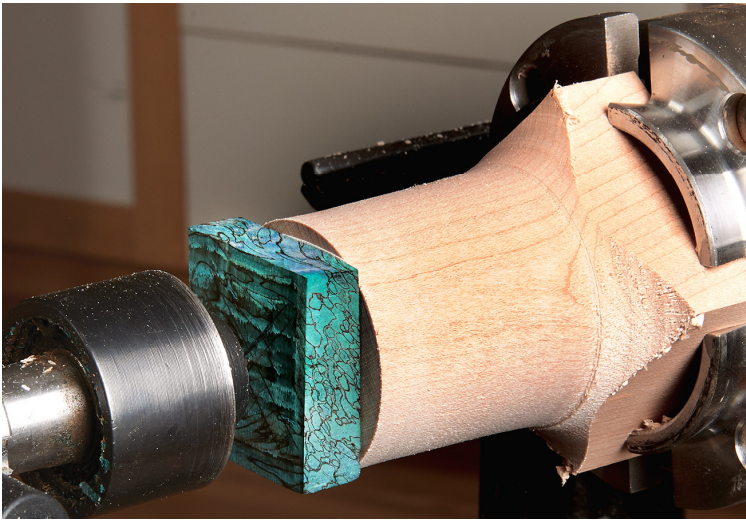
Using a flat surface and 100-grit sandpaper, flatten and clean one side of the ring blank. Apply double-faced turning tape to one side, and mark centers on the opposite side.



Center the blank on the live center, and advance against the face of the scrap block. The pressure of the live center will enhance the bond of the tape during the rough turning process.

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Rough turn the blank to round. Remove the live center.

Using a drill bit slightly under the inside diameter of the chosen ring core, install the bit into a drill chuck and drill through the ring blank.



Use a narrow scraper or square carbide turning tool to open up the drilled hole until the ring core fits into the opening. Frequent test fits will be required to avoid an oversized opening. The ring core should just fit snug.

Note: Recommend having a few different ring core sizes in case you make the hole too large. Moving up one size can help salvage your blank.



When the ring core fits the opening, true the face of the blank to the same width of the ring core, ensuring a good fit.



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Using a thin blade putty knife, slowly pry the blank from the waste block. Spin the hand wheel as you work around the blank to help release the tape. **Take care to not apply excessive pressure or the blank may break.**



Apply a light coat of either thick CA glue or 5-minute epoxy (recommended) to both the ring core and blank. Immediately remove any excess glue.



Turning the Ring Core:

Mount the ring core on the pen mandrel using the ring core bushings as shown in the image below. Small-size ring core bushings fit ring sizes 4–7. Medium-size ring core bushings fit ring sizes 8–12.



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Turn the blank to the desired profile. Sand the blank up to 400 grit or higher.

Apply a finish of your choice. One of the most durable would be a CA finish that will polish to a high gloss while forming a long-lasting hard finish.



Remove the ring from the mandrel. Sit back and enjoy all of the compliments on your beautiful creation.

