Security Key Ring Kit

Product : #171993, #171994

4/8/2020

Gluing Blanks to Tubes:

Rough the entire surface of the tube using 180-grit paper. Next, using either a thick CA or 5 Minute Epoxy, apply adhesive to both the tube and the inside of the blank. To secure the brass tube be sure to rotate the tube as you insert it into the blank. This will help ensure even coverage of the adhesive and a much more secure bond.
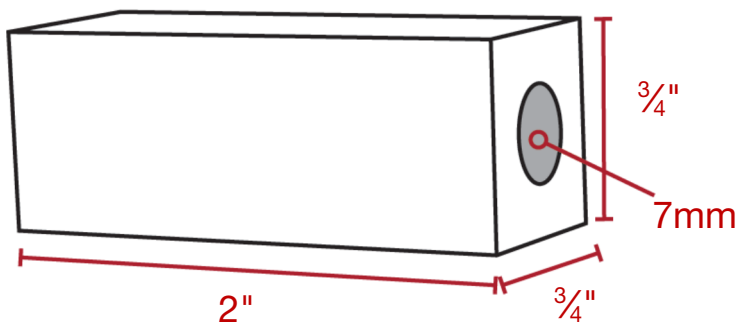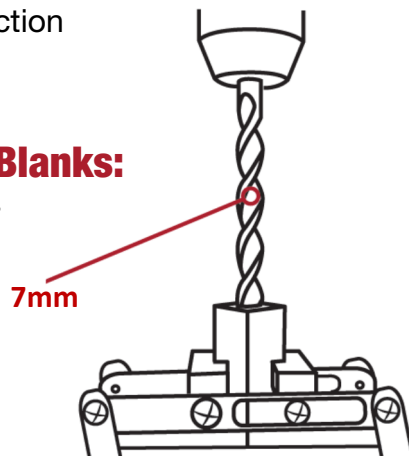
From Setup To Sanding:

These are the supplies we suggest you have on hand to complete this pen kit:

- ❑ 7mm Pen Maker's Bit
- ❑ ¾" x ¾" x 2" Pen Blank
- ❑ Pen Mandrel
- ❑ Security Key Ring Kit Bushings (173409)
- ❑ Thick CA or 5 Minute Epoxy
- ❑ Drill or Drill Press
- ❑ Sandpaper/Micro-Mesh
- ❑ Pen Mill Pilot Shaft 7mm
- ❑ Pen Press
- ❑ Eye & Ear Protection
- ❑ Dust Mask

Squaring the Blank to Length:

When squaring the blanks work only to the brass. Removing brass will affect the overall length of the blank which is critical to the proper operation.

Sand

Drill

Cutting & Drilling Blanks:

Note: Additional length has been added to the overall length of the blank to accommodate for squaring the ends of the blank.
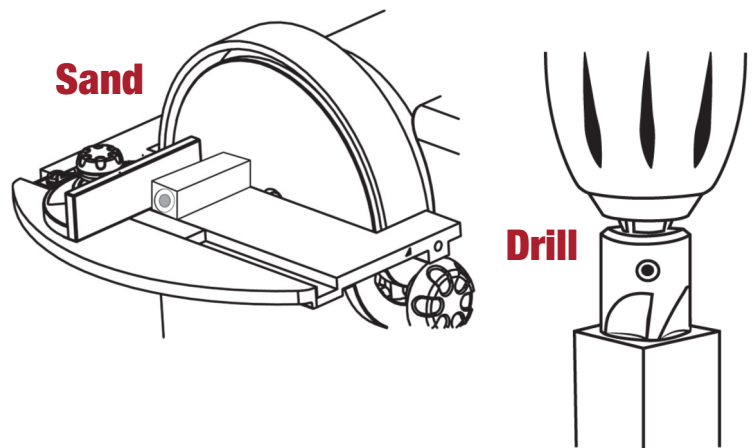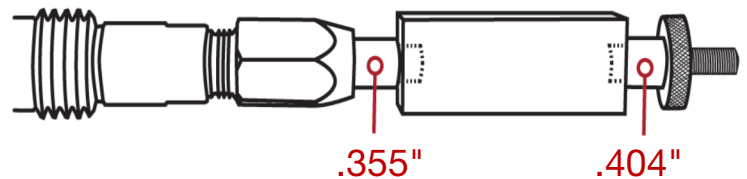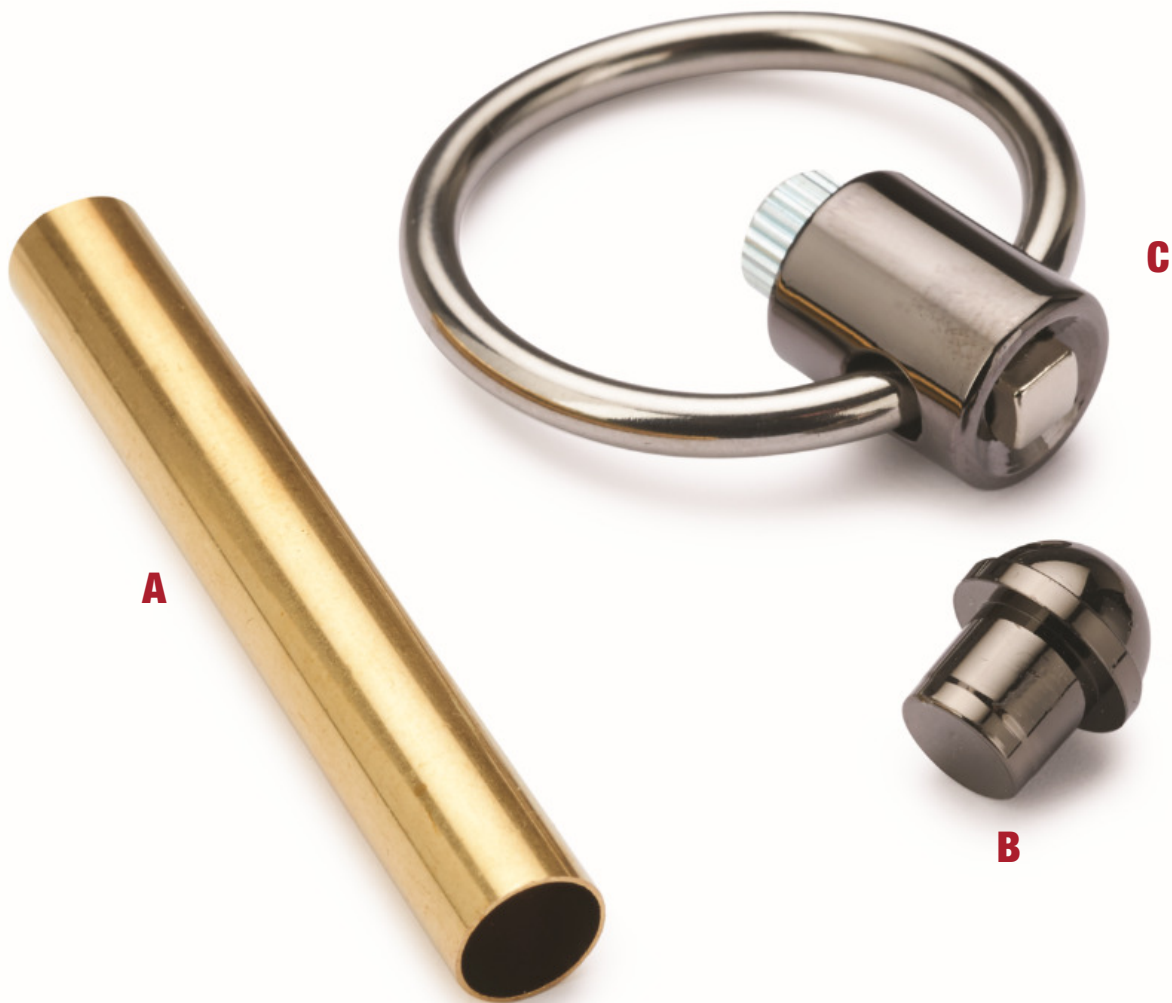
7mm

Mandrel Preparation:

.355"   .404"

Turning & Finishing the Blanks:

Turn the blank to your desired profile, leaving the blank slightly proud of the bushings. With the lathe spinning, begin sanding with 120-grit paper, progress through the finer grits, finishing at 320-grit. Once finished with sanding, apply a finish of your choice.

¾"

7mm

2"   ¾"

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Assembly:

☐ Press End Cap (B) into the .355" diameter end of Finished Barrel (A).

☐ Next press Key Ring (C) into the .404" end of Finished Barrel (A).

To open key ring, depress button and rotate ring. To close key ring, rotate ring back until it snaps back in place.