

# DETACHABLE KEYCHAIN KIT V2

## Kit Features:

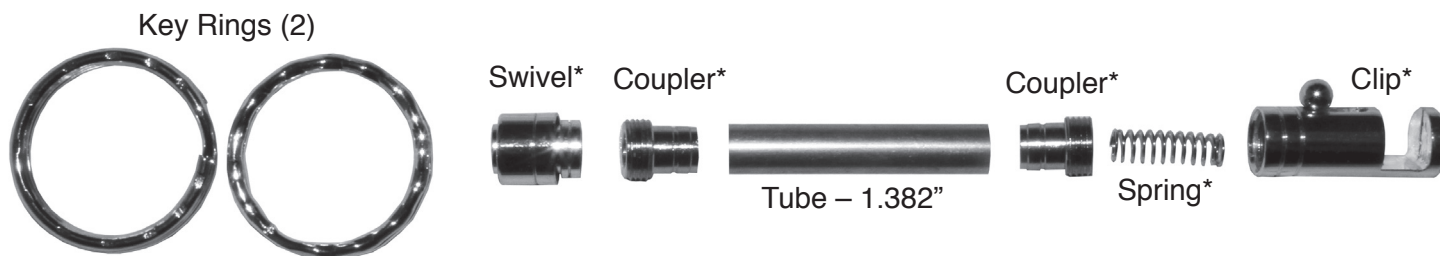
- Reliable, sturdy clip
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 4-13/16"

## Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 7mm #PK-7MM for wood, #PK-7MMSG for plastic
- Bushing Set( 2 pc): #PKDET2BU
- Barrel Trimming set: #PKTRIM7
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 3/4" x 3/4" x 1-7/16"L



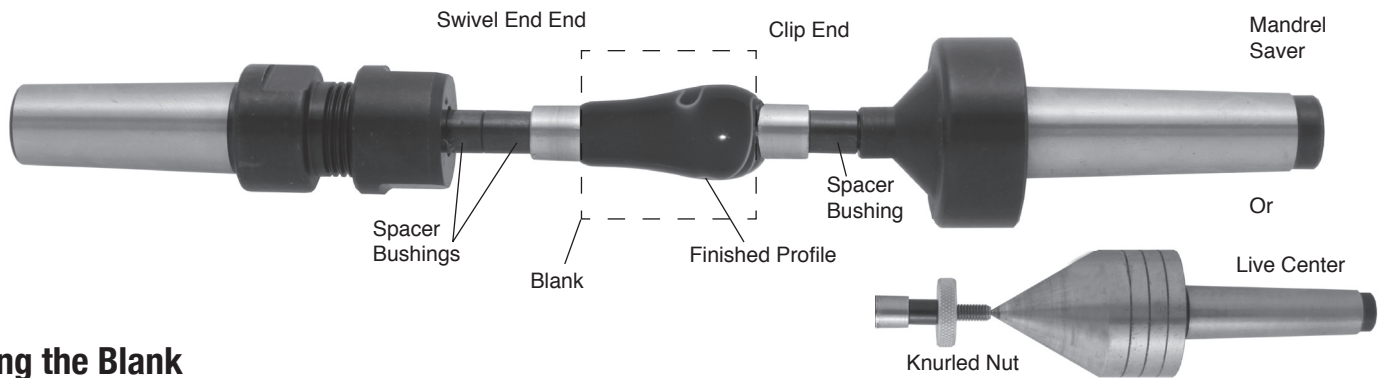
## DIAGRAM A / PARTS LAYOUT



*\*couplers come pre-assembled in swivel end and clip end, spring is pre-installed in clip end*

## Preparing the Blank:

- Cut blank to the to the length of the tube, adding 1/16" for squaring off.
- Drill 7mm hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank with a twisting motion to spread the glue evenly inside.
- Center the tube lengthwise inside the blank.
- When the glue is dry, square the ends of the blanks, making sure the trimmed ends are 90° to the tube. Use a 7mm barrel trimmer, or a pen blank squaring jig on a disc sander. Take the excess material down flush to the ends of the tubes. Do not trim past the end of the tube since this may interfere with the 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 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 Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- 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 sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.

**Assembly**

- Unscrew the coupler from the bottom of both the Clip and Swivel ends. Be sure not to lose the spring.
- Press the couplers into the Barrel, one side at a time.
- Spring can be put into the recess on either coupler before screwing the Clip onto that coupler.
- Screw the Swivel onto the other coupler.
- Note that Clip side of the barrel is slightly larger than the Swivel Side. You can unscrew and switch the ends if you accidentally put one onto the wrong side.
- Attach one Key Ring into the hole in the Swivel.
- The other Key Ring can be inserted into the clip by pushing down on the button and slipping it in while the clip is open.
- Either key ring can be attached to loops, other key rings, or straps. Use the clip to attach and detach as needed.

**Diagram C / Bushings #PKDET2BU**