

Lighter key ring



Needed:

Mandrel A, drill 37/64, bushing 114A

Preparing the blank

1. Cut the blank $\frac{1}{4}$ " longer than the brass tube so you can square it off once the tube has been glued in.
2. Drill the blank through the center, lengthwise, with a 37/64 drill bit.
3. Scuff up the tube with sandpaper to clean off the oxidation and give the glue a better adhesion surface.
4. Plug the tube ends with a material of your choice – we recommend baseplate wax – to keep the glue from getting into the tube. Just push the ends of the tubes into a thin section of the material to form a plug. *This is important: glue inside the tubes is a common cause of kit failure.*
5. Roll the tube in the glue and insert it into the blank with a twisting motion until it is equidistant between both

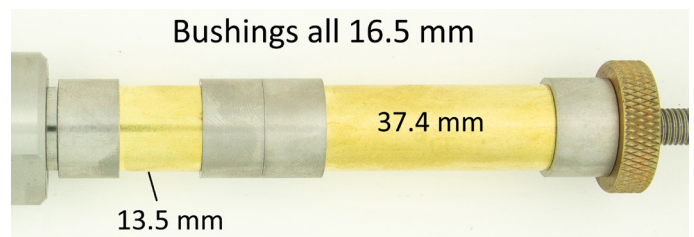
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ends of the blank.

6. Set aside until the glue has had time to reach its maximum strength.
7. When the glue has cured, use a hobby knife to remove the plugs from the ends.
8. Using the proper jigs and a disk sander, square off the ends of the blank until you can see bright brass tube. *Not having the proper tube length is another common cause of pen failure.*

Turning the blank

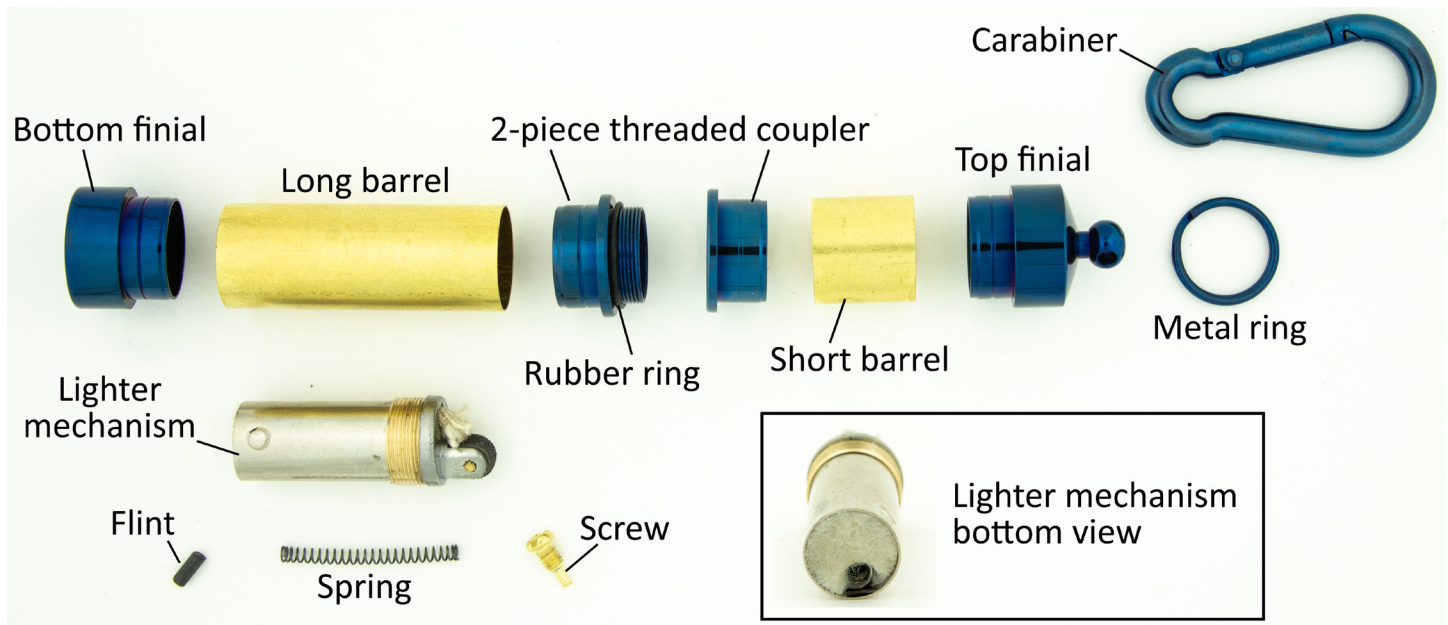


1. Assemble the blank and bushings on the mandrel. The bushings are the same size.
2. Turn the blank to the desired shape, using the bushings as a sizing guide.
3. After turning, sand the surface in progressive steps until you get to 400 or 600 grit. For a high gloss finish, continue sanding using Micro Mesh through 12,000 grit.

4. Apply the finish of your choice and polish.
5. Remove the blank from the mandrel.

Assembling the kit

1. Press the bottom finial into one end of the long barrel.
2. Unthread the 2-piece threaded coupler.
3. Press the coupler into the other end of the long barrel.
4. Press the other coupler into one end of the short barrel.
5. Press the top finial into the other end of the short barrel.
6. Attach the metal ring to the top finial. Attach the carabiner hook to the ring.
7. Install the rubber ring over the threads of the coupler on the long barrel.
8. Drop the flint into the hole on the bottom of the lighter mechanism.
9. Drop in the long spring over the flint.
10. Thread the brass screw into the hole over the spring.
11. Screw the lighter mechanism into the coupler on the long tube.
12. Screw the top over the lighter mechanism.



Fill the lighter mechanism (saturate the batting) from the bottom with lighter fluid.