

Bottle Opener Keychain Kit

Kit Features:

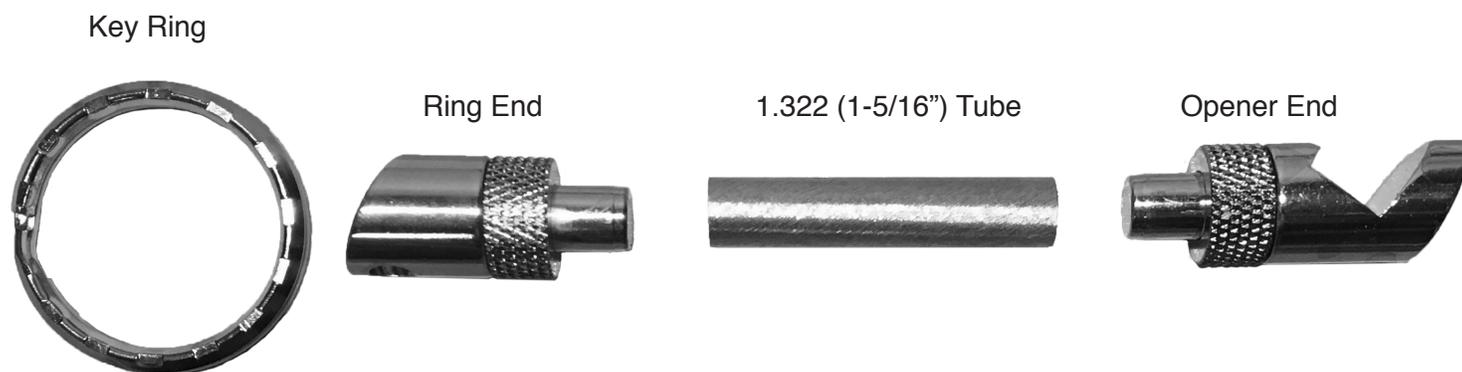
- Slanted, Modern Design
- Knurled for a positive grip
- Easy to Turn with Straight Tubes
- Minimal Parts--easy to assemble
- Available in multiple finishes
- Overall Length: 3-5/16"

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 7mm #PK-7MM for wood, PK-7MMSG for plastic
 - Option drill bit for Pressing Jig: 15/32" #PK-1532
- Bushing Set(2 pc): PKABBU
- Barrel Trimming set: PKTRIM7.
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 1-3/8"L

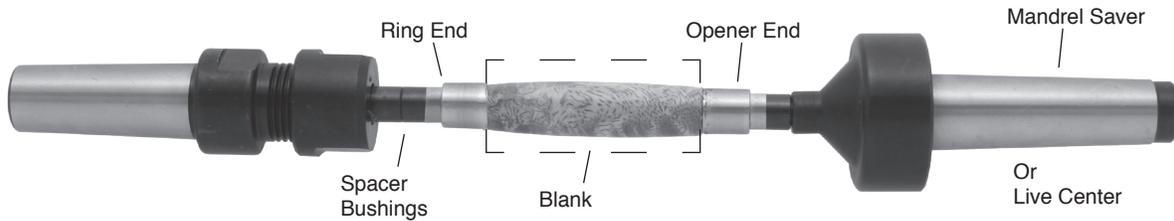


DIAGRAM A / PARTS LAYOUT



Preparing the Blank:

- Cut blank 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 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. Note that the bushings mount with wide end next to blank.
- 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

- To press on the slanted ends, a jig is needed to keep the parts straight.
 - To make the jig, use 2 scrap pieces of wood, at least 3/4" long and drill a 15/32" hole 5/8" deep in each. (See Illustration)
- Slip one jig over the Ring End press it into either end of the Barrel.
- Keep the jig on the Ring End and slip the 2nd jig over the Opener End and Press it into open end of Barrel.
- Attach Key Ring through the hole in the Ring End.

Diagram C / Bushings #PKABBU