

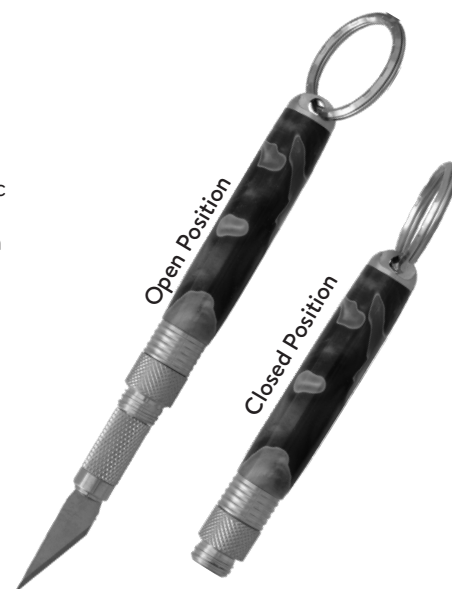
Classic Knife Keychain

Kit Features

- Easy to Turn with Straight Tubes
- Minimal Parts—easy to assemble
- Available in multiple finishes
- Uses Gatsby accessories
- No separate cap required to protect Blade—just flip it inside to close.
- Overall Length: 4-3/16" Closed, 5-1/4" Open

Required Accessories

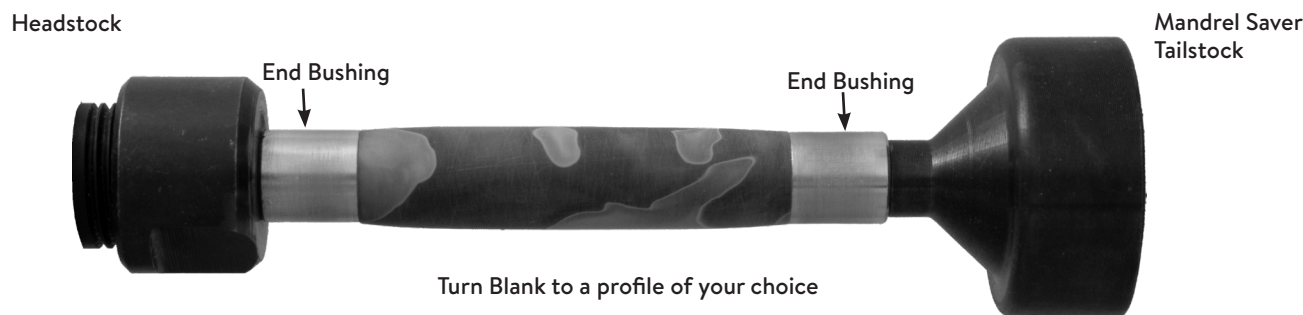
- 7mm Pen Mandrel
- Drill Bit: #PK-2764 for Wood, #PK-2764SG for Plastic
- Bushing Set(2pc): # PKGABU
- Barrel Trimming: PKGABTS with #PKTRIM734 or with squaring jig on disc sander
- Live Tailstock or Mandrel Saver
- 2 part Epoxy or Thick CA (Cyanoacrylate) Glue
- Pen Blank Minimum Size: 5/8" x 5/8" x 2-1/4"L



Preparing the Blank:

- Prior to cutting and gluing, always verify tube length is correct (see parts diagram on back page)
- Cut blank to the length of the tube, adding 1/16" for squaring off.
- Drill 27/64" hole lengthwise through the blank.
- Spread glue over tube, insert the tube into the blank while twisting 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 PKGABTS barrel trimming sleeve with PKTRIM734 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 and the operation of the mechanism. Use a barrel trimmer to clean the inside of the tube.

DIAGRAM B / TURNING THE BLANK



Turning the Blank:

- Mount the bushings and blanks according to diagram B.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide and lock tailstock directly against bushings and tighten quill until blank and bushings are secure.
- To use Knurled Nut Setup (right), add spacer bushings until past the threads on the end of the Mandrel Shaft.
- 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 and hand tighten the quill adjustment with wheel to steady the mandrel. Do not over-tighten, it could damage mandrel shaft.
- 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 manufacturer's instructions.

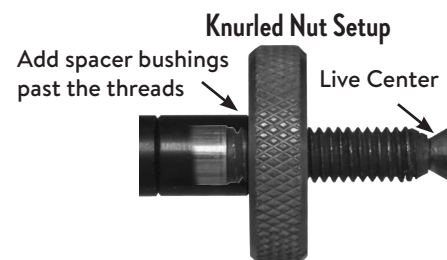


Diagram C / Bushing #PKGABU

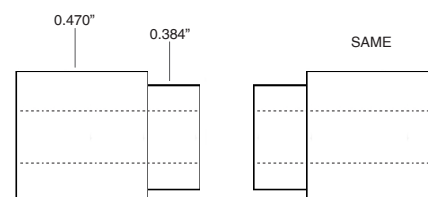
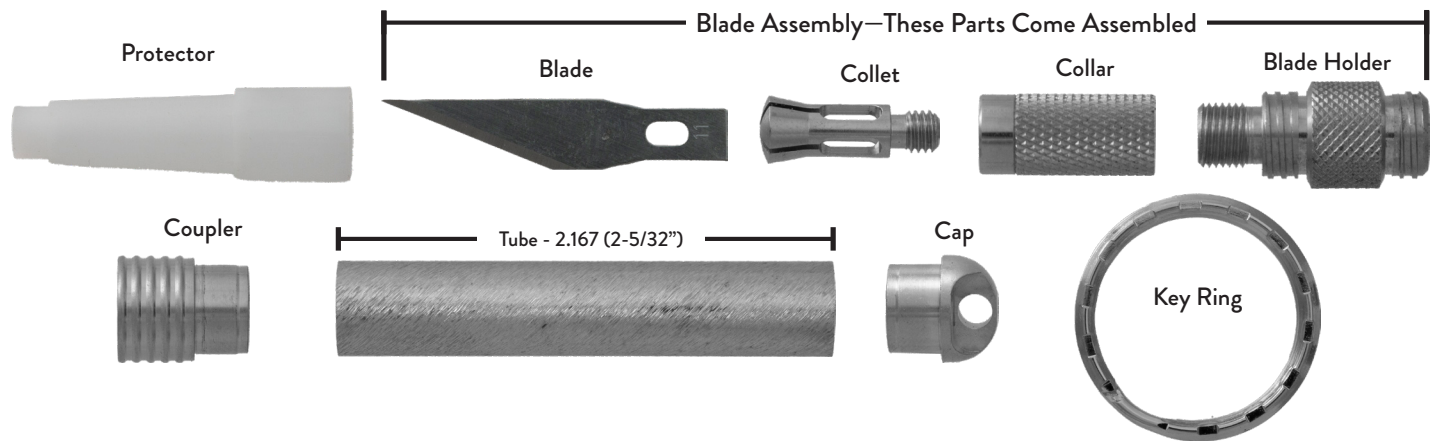


Diagram D / Parts Layout

**Assembly:**

- Press Coupler into either end of Barrel.
- Carefully Press Cap into remaining open end of barrel. There is a small flat spot on the end of the cap to help in pressing straight.
- Attach Key Ring through hole in Cap.
- Remove Protector from Blade Assembly.
- Blade Assembly can be threaded into Coupler either with the Blade side in for storage or with the Blade pointed out for usage.
- To change the Blade twist the Collar so it threads away from the Blade and loosens the collet. Insert a new Blade and re-tighten the Collar.