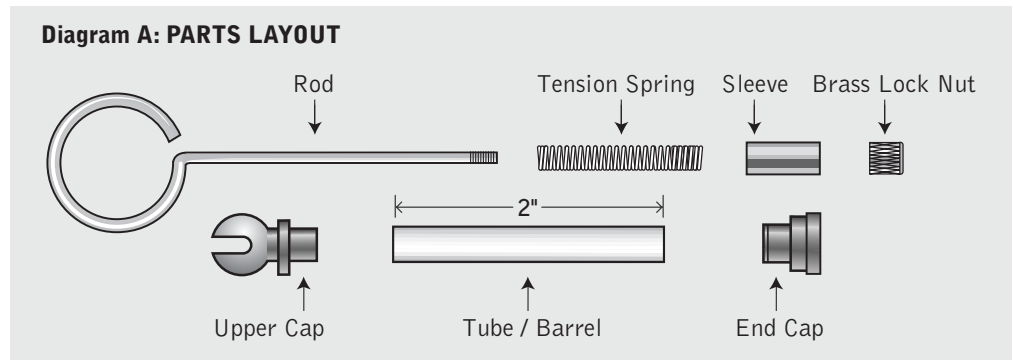


# #PKKEYQR Quick Release Key Ring Kit (Overall size: 4")

## Required Accessories:

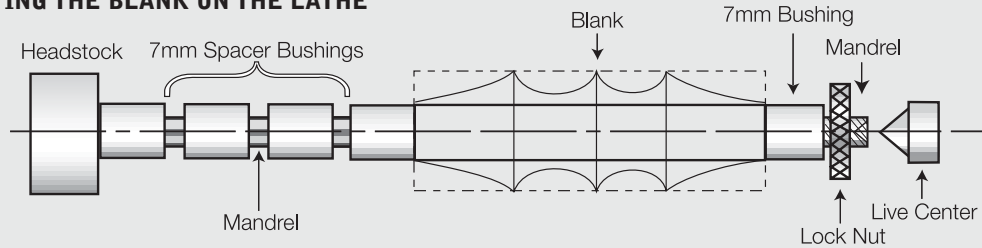
- 7MM mandrel
- 7MM bushings (use PKM-BUSH, PKCFBUSH, or PKLONGBU)
- 7MM drill bit # PK-7MM
- 7MM barrel trimmer # PKTRIM
- 2 part epoxy glue or insta-cure (cyanoacrylate) glue



## PREPARING THE BLANK

- Cut a 5/8" to 1" square blank (depending on the size of your design), to the length of the brass tube plus 1/16" for squaring off).
- Drill a 7MM center hole through the length of the blank.
- Spread glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise in the blank.
- When the glue dries, square the ends of the blank. Use a 7MM barrel trimmer or a disc/ belt sander to trim the wood down, flush to the brass tube.

## Diagram B: MOUNTING THE BLANK ON THE LATHE



## TURNING THE BLANK

- Place 3 or 4 spacer bushings on the mandrel shaft. Slide the blank onto the shaft. Fill in the gap with additional bushings or spacers to reach to the thread. Thread the lock nut onto the end of the mandrel. Bring the tail stock in, lock in place (do not over-tighten the tail stock – it may damage the mandrel) tighten the lock nut.
- Turn the wood down to the design of your choice.
- Sand and finish the wood.

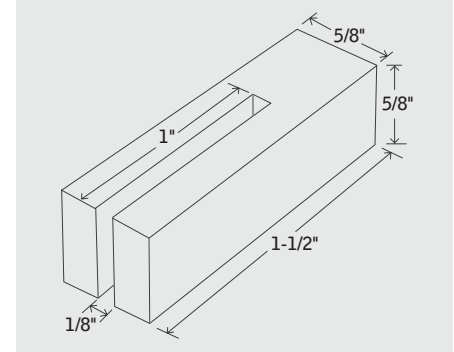
## ASSEMBLY

- Line up parts according to **Diagram A**.
- In order to press the parts properly, you will need to make an assembly device. Using a hardwood pen blank works best. See **Diagram C**.
- Place the upper cap, slotted end first, over the rod.
- Slide the tension spring over the rod, and follow with the sleeve. Then thread the lock nut on the end, and twist it until it is tight.
- Insert the end cap into the bottom end of the barrel, and press in place.
- Slide this barrel assembly over the inner mechanism.
- Place the ring of the rod into the slot of the assembly device. Use a pen press or vice to push the upper cap carefully into the barrel.

**Note:** Use your assembly device to support the key ring when pressing the remaining parts together.

The key chain is now complete. Just pull on the ring, when it clears the slot, turn 90 degrees – the ring is now ready to hold your keys. Turn the ring 90 degrees back to the rest position for use.

## Diagram C: ASSEMBLY DEVICE



## 7MM BUSHINGS

