

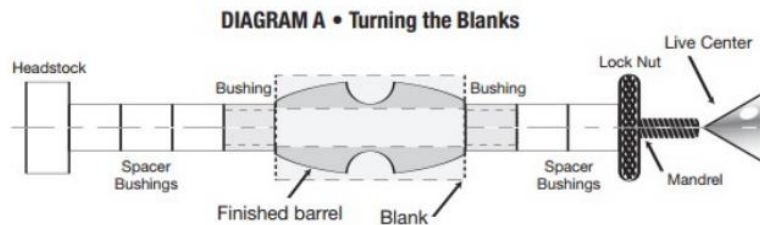
Fire Starter Keychain Kits Assembly Instructions

REQUIRED ACCESSORIES:

- 5mm Pen Mandrel
- 5.7mm drill bit
- 2-piece Bushing Set
- Barrel trimmer
- Glue (Thick CA or Epoxy)

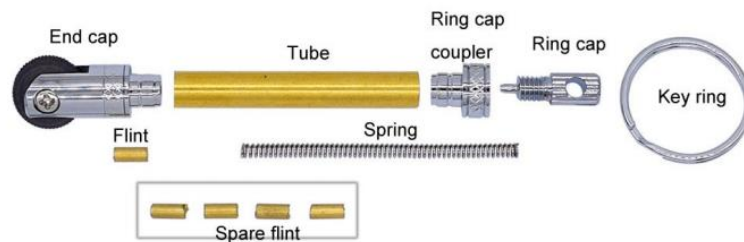
PREPARING THE BLANK

- Use a 5/8" square stock. Cut blanks to the length of the tube, adding 1/16" for trim.
- Drill a centred hole with 5.70mm Drill lengthwise through each blank.
- Use epoxy or a gap filling cyanoacrylate (super glue), to glue the tube into the blank. Coat the outside of the tube with epoxy and insert the tube into the blank with a twisting motion to spread the glue until flush. Allow it to dry.
- With a barrel trimmer, square the ends of the blanks to the tubes.



TURNING THE BLANK

1. Assemble the blanks and bushings on the mandrel.
2. Lightly tighten the mandrel and secure. Do not over-tighten as this can cause the mandrel to bend, causing your pen to come out oval. A spacer may be installed to give you more room between the thumbnut and the last bushing.
3. Turn the pen blanks to the desired shape using the bushings as a sizing guide.
4. Sand the surface in progressive steps until you get to 400 or 600 grit.
5. For a smooth finish, sand with Micro Mesh to 12,000 grit and apply finish of your choice.
6. Remove the blanks from the mandrel.



ASSEMBLY

- Line-up the parts according to the above picture.
- Press the end cap into the tube.
- Press the ring cap coupler into the opposite end into the barrel.
- Insert the spring into the screw of ring cap.
- Put the one flint into the tube smoothly, then screw the ring cap into the ring cap coupler.
- Attach the key ring to complete your fire starter.