

# Fire Starter Keychain Kits Assembly Instructions

## REQUIRED ACCESSORIES:

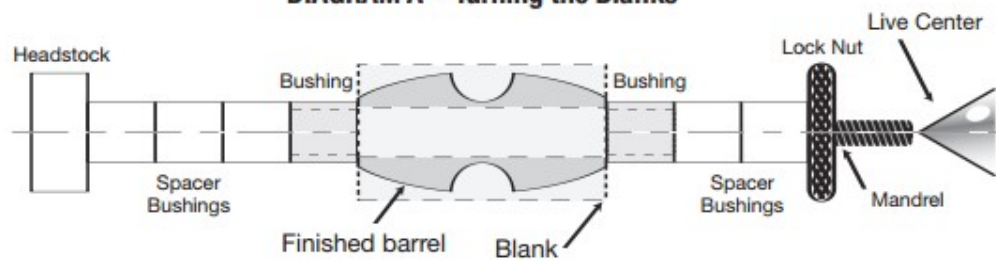
- 5mm Pen Mandrel
- 5.7mm drill bit
- 2-piece BushingSet
- Barrel trimmer
- Glue (Thick CA or Epoxy)



## PREPARING THE BLANK

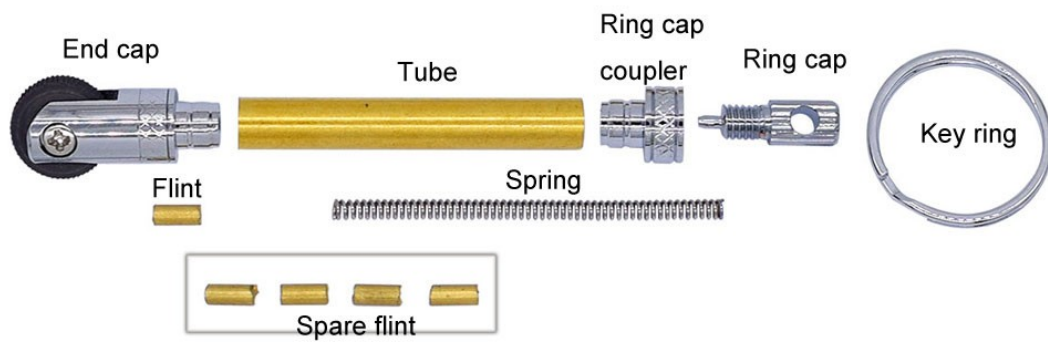
- Use a 5/8" square stock. Cut blanks to the length of the tube, adding 1/16" for trim.
- Drill a centered hole with 5.70mm Drill lengthwise through each blank.
- Use epoxy or a gap filling cyanoacrylate (super glue), to glue the tube into the blank. Coat the outside of the tube with epoxy and insert 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.

**DIAGRAM A • Turning the Blanks**



## 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.