

All US Flag Inlay Kits - Assembly Instructions

See Note for Pacifica/Sierra Kit on the last page

Things that you might want to consider before you start assembly process.

1. Take your time and do not rush the process.
2. Do not force anything into place.
3. Do not use glue in the assembly process.
4. Place the brass tube inside the barrel while assembling.
5. Use warm water with a bit of dishwashing liquid with star assembly.
6. This is considered advance pen making and is for experienced pen makers and anyone who would like to try and follow the process step by step.

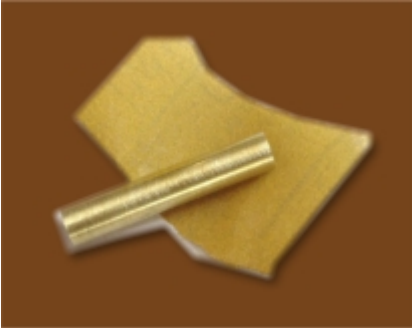
Step 1



Remove all inlay pieces from the container and arrange them in there different groups.

Group all the stars with the **blue upper barrel** and the stripe inlays with the **red lower barrel**.

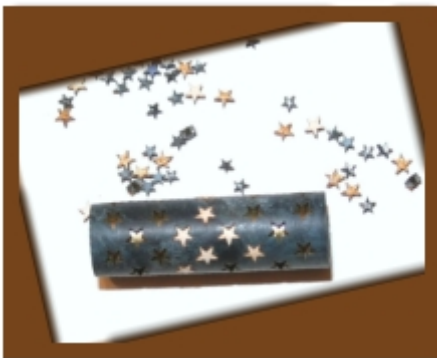
Step 2



Take the brass tube from your pen kit and prepare it as you would do with any other wooden pen blank.

Cut a piece of 3/4 inch blue/ green masking tape (painters tape is also fine) long enough to go around the tube twice.

Step 3



Place the brass tube inside the Blue upper barrel, this will help you with the assembly and also help support the barrel from the inside when you apply pressure to press the stars into place.

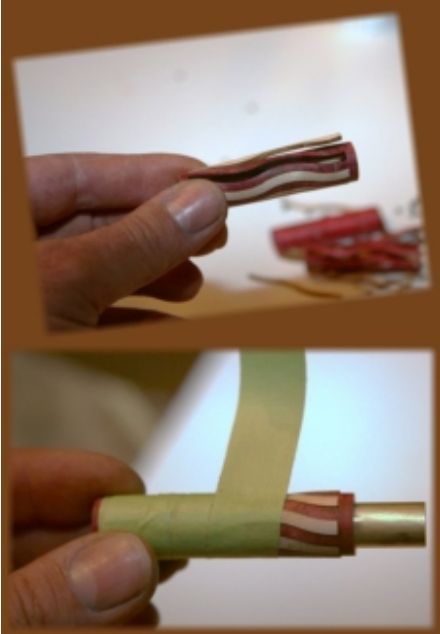
Start placing the star inlays into the star holes. ***Use water with a little bit of dishwashing soap by dipping the stars in the water before placing them in the hole.*** (The stars must go in white side first.)

Continue this until you have fitted all the stars. You have to apply some pressure to push the stars into place. The kit comes with extra stars.

Please DO NOT USE any glue at this stage.

Now wrap the upper barrel with tape and roll it on a flat surface to make sure that all the stars are snug.

Step 4



Place the brass tube inside Red lower barrel. This will help you with the assembly and also help support the tube from the inside when you apply pressure to press the stripes into place. Start placing the stripe inlays into their holes. The stripes have been cut from a pen blank with the same diameter as the Red lower barrel. The fit is tight but not as tight as the stars. Place all the stripes in position and only then you can use a flat block to apply the little pressure to press them into place.

Please DO NOT USE any glue at this stage.

Now wrap the Red lower barrel with tape and roll it on a flat surface to make sure that all the stripes are snug.

Step 5



Remove the scuffed brass tube from the assembled barrels and use any familiar method to glue the brass tube into the assembled blanks. CA glue works great and cures pretty fast. Make sure that you give the glue enough time to cure before you proceed with the next step.

The red lower barrel is longer than what is needed for the pen. The reason for that is to hold the stripes into place until the assembly is glued up. When you glue the red lower barrel make sure that you push the tube deep enough to reach the stripes from both ends on the inside.



Step 6

Remove all the masking tape and prepare the trim the ends of the barrel. After the glue has cured you remove the red ends with a squaring jig or if you have Nova chuck just clamp it in the jaws and remove red ends and square it off.

**Please DO NOT USE a barrel trimmer.
It will tear the pieces off the ends of the assembled blank.**

Step 7

Place the barrel with bushings on the mandrel and place in lathe. You can use a skew for this but make sure it is very sharp to prevent any unnecessary damage. Use progressively finer sandpaper until you are satisfied with the finish.

Step 8

The barrel can now be finished with a finish of your choice. CA glue works great and would provide a great long lasting finish.

Step 9

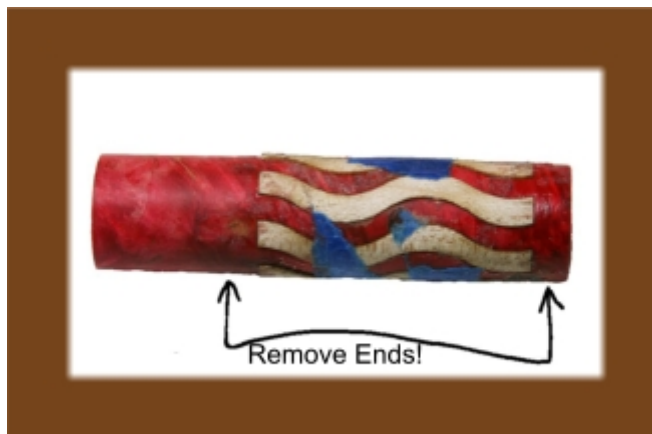
Follow your pen kit instructions to assemble your new pen.

SEE THE FOLLOWING PAGE FOR SIERRA KIT INSTRUCTIONS

Sierra Kit

Follow the same process for both the blue and the red barrel to just before you glue the tube into place.

1. Make sure you remove the ends of the red barrel up to the maple inlays. Use any method that you are familiar with, but make sure the ends are square.



2. Now you can use the length of the red barrel to determine the size of the blue barrel. Follow the same process as for the red barrel to square the ends.
(Do not cut it too small)
3. The two pieces (barrels) can now be glued together. Use any method that you are familiar with. Make sure the stars are pointing up when gluing pieces together.

If you have any problems, feel free to contact me at your convenience.