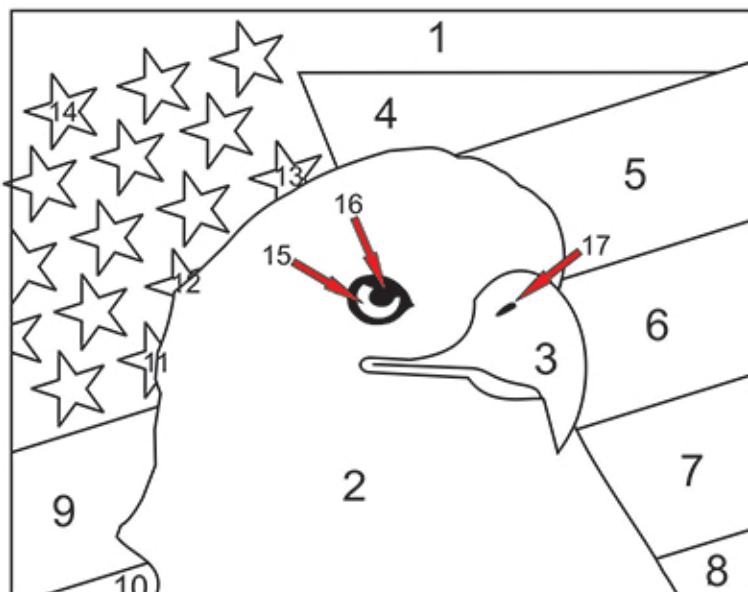


## Instructions for the All American Eagle Inlay Kit (PSI Bolt Action, Sierra Style Pen Kits)



The first piece going in to the blue barrel (#1) is the Eagle (#2). Once this piece is aligned, slide the brass tube from your pen kit into the barrel to lock the 2 pieces together. Hold this in place with one of the supplied elastic bands double wrapping it to make it extra tight. Next is piece #3 the yellow beak. Follow this with pieces #4, 5, 6, 7 and 8. Double wrap these as well with another one of the supplied elastic bands. Next are pieces #9 and 10. Wrap these with another elastic band. Once all of the red and white stripes are in place you'll probably notice a few gaps in one or two areas around the eagle head and possibly by the beak. If so, add another double wrapped elastic band so you have 4 bands equally spaced along the barrel. Carefully remove the brass tube and the pieces should compress just enough to eliminate these gaps. Apply thin CA glue to the seams of the eagle and stripes being careful not to get any glue into the remaining recesses for the stars, etc. Once the glue is dry you can proceed to the 2 eye pieces #15 and #16. For the Sierra version insert beak accent #17. This piece isn't used in the Bolt Action version. Apply thin CA to these as well. Finally it's time to insert all of the stars. There are 3 partial stars and 13 complete stars. Since the stars were cut from a cylinder it is important that they are properly oriented. They will only go in one way. Notice the curve on the underside of the star for a hint in aligning these accurately. Slide the brass tube back in partially for support while pressing in the stars. When all stars are in position, slide the brass tube out and seal all seams with thin CA glue. Allow to dry.

Now we'll glue the brass tube into the blank. Check the fit of the tube as you might have to lightly sand the inside of the blank for a good fit. If you do, wrap a small dowel with 100G sandpaper and sand the inside of the barrel until



the tube fits smoothly. Use 2-part epoxy to glue in the brass tube. Make sure the tube is perfectly centered so the blue rings on both ends will be sanded away completely. Once the glue has cured, sand the ends flush with the brass tube using a belt / disc sander or a miter saw. Don't use a barrel trimmer. Now you can mount the blank on the lathe for final turning and finishing. Apply whatever finish you're comfortable with as they all work well with these inlay kits.

  
**Kallenshaan Woods**  
Laser Cut Inlay Pen Kits

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