

Assembly Instructions for the St. Paddy's Day Inlay Kit



We're going to start by inserting the Shamrocks into the recesses in the curly maple barrel. They press in easily but start by aligning the stem first so it won't get broken when pressed into position. Once all 6 are in place, secure them with the included elastic bands as shown in Fig 1 and then flood the seams with thin CA glue.



Once the glue has completely cured we're going to glue in the brass tube making sure that it's centered with the Shamrocks. Check the fit to see if you need to sand the inside of the barrel for the brass tube to fit smoothly. If you do, wrap a piece of sandpaper (100G-150G) around a small dowel and sand the inside until the brass tube fits smoothly. Scuff up the brass tube with 100G sandpaper before gluing. I prefer 2-part epoxy to glue the brass tube in place. Never use polyurethane (Gorilla) glue with these inlay kits as the expansion while curing could seep through the glue joints of the inlay. Once all glue has cured, sand the ends flush to the brass tube (don't use a barrel trimmer) and mount on the lathe. If you'd rather not have the green trim pieces at the ends of your finished pen that's fine. If you do, using a parting tool, turn away both ends at about 1/8"-3/16". See Fig 2.



This will allow us to fit the 2 end trim rings over the brass tube. Remove from the lathe and glue the 2 green trim rings (sanding one end to remove the small burr left by the laser. Fig 3)



onto the barrel using 2 part epoxy. Secure with a small bar clamp to ensure a tight joint. Once the epoxy has cured, sand the ends flush to the brass tube again and return to the lathe for final turning and finishing using the finish of your choice.

E-mail Ken at kallenshaan@cox.net with any questions about this or any of our other laser cut inlay kits.