

Lighter Chain Kits Assembly Instructions

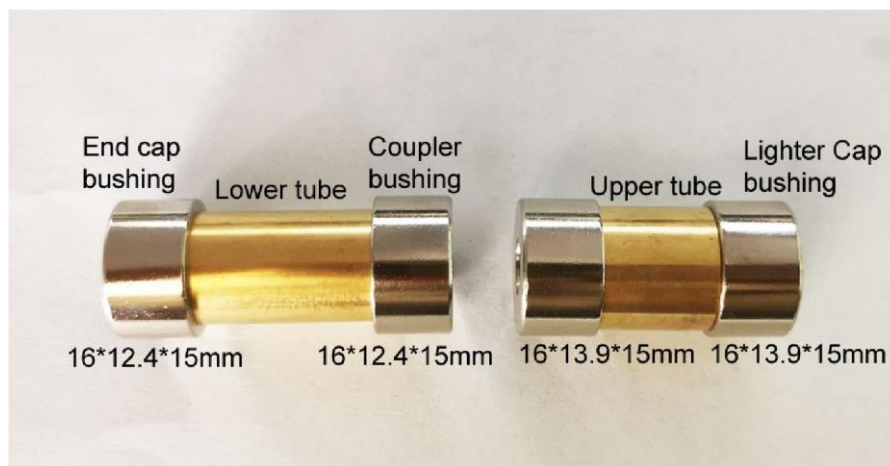
REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- Drill bit 13.2mm RSDB132, 14.6mm DB37/64)
- Bushing Set BU457
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PREPARING THE BLANK

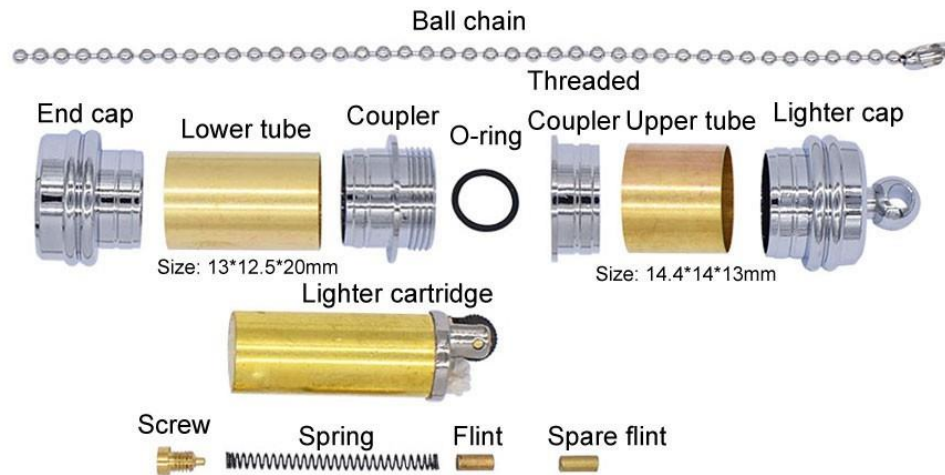
- From 7/8" or larger square stock cut blanks to the length of the tubes plus 1/16"..
 - Drill a centered hole lengthwise through each blank.
- Upper blank (shorter tube)—drill a 14.6mm hole through.
- Lower blank (longer tube)—drill a 13.2mm hole through.
- Spread glue over the tube, then insert it into the blank with a twisting motion to spread the glue evenly inside.
 - Center the tube lengthwise inside the blank.
 - When the glue dries, use a barrel trimmer, universal squaring jig, or a belt/disc sander to take the wood down, flush to the brass tube.



TURNING THE BLANK

- Mount the bushings and blanks according to diagram A.
- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the Tailstock up snugly against the Mandrel shaft, inserting the live center point into the Mandrel dimple. Lock Tailstock.
- Hand tighten the quill adjustment on the tailstock to steady the mandrel. Do not over tighten, it could damage the mandrel shaft.
- When using Mandrel Saver, there is no need for extra spacer bushings or the knurled nut. Slide tailstock directly against bushings and tighten until blank and bushings are secure.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel straight or to a profile of your choice.

- Sand the blank down to be flush with the bushings, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow Sufficient time for the polish to cure—refer to polish instructions.



ASSEMBLY

- Line-up the parts according to the above picture.
- Press the end cap into one end of the lower tube.
- Press the coupler with o-ring into the opposite end of the lower tube.
- Press the threaded coupler into the upper tube.
- Press the lighter cap into the opposite end of the upper tube.
- Insert the flint and then spring then secure them by installing screw in the lighter cartridge.
- Remove the felt pad from the lighter cartridge and use lighter fluid to fill the lighter cartridge being careful to not overfill. Replace the felt pad.
- Slide it into the lower tube till it is flush with the o-ring coupler.
- Attach the ball chain to lighter cap's hole and complete your lighter.