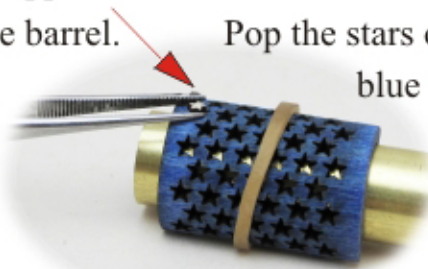


Instructions for the Stars and Stripes Inlay Pen Kit (Sierra, Bolt Action)



The blue half barrel requires 50 stars. 60 are included with the kit so you can afford to lose or break a few. Before you start inserting the stars, support the blue half barrel with the brass tube securing it with one of the supplied elastic band. This will allow you to apply enough pressure to the stars without crushing the blue barrel.

are in place, thin CA glue edges which



Pop the stars out from the back of their frame and insert them into the recesses in the blue barrel pressing them in as far as you can. Once all stars slide the brass tube out from the blue barrel and apply over all the stars being careful not to get any on the might effect the fit of this piece later.

Fit the blue star barrel in place in the stripe barrel and then slide the brass tube inside that assembly. Secure with a couple of the supplied elastic bands. Insert the long and short stripes in place now. Make sure everything is aligned and then tube out and apply thin CA glue all the pieces into position.



carefully slide the brass to permanently lock

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 there's the same amount of space on either end. Once the glue has cured, sand the ends flush with the brass tube using a belt or disc sander. 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.