

United States Marine Corps Inlay Kit

Assembly Instructions

We're going to start by making sure all pieces are included and none are broken. If there are any missing or broken pieces, call or e-mail Ken at (702)523-9236 or kallenshaan@cox.net to get replacements. Even if you didn't purchase your inlay kit directly from Kallenshaan Woods, use this contact info as our vendors don't carry replacements parts.

Also, if a piece doesn't seem to fit well, use this contact info for a replacement or solution. Don't glue in a piece if it doesn't look right.

There are 2 delicate areas on the red barrel so to avoid breaking them (making it more difficult to complete assembly) we're going to assemble and glue the pieces surrounding these areas first. Our gluing technique for securing the inlay pieces has changed a bit for some of the kits. Instead of "flooding" seams with thin CA glue, we're going to be brushing thin CA glue (using a disposable nylon artists paint brush) along the seams followed by a quick shot of accelerator (the aerosol being the only way to go). To start assembly, temporarily slide the brass tube from your pen kit into the red dyed basswood barrel. Do not glue at this time as this is just for support and alignment while positioning the pieces in place. The first piece going into the red background barrel is the chain #1 followed by the gold/yellow anchor #2 piece. Use the supplied elastic bands to secure these pieces during assembly as needed. Proceed numerically ending with #7 the second "chain" piece. Now carefully remove the brass tube and brush some thin CA glue onto the seams of the assembled pieces followed by a quick shot of accelerator to cure the glue and lock everything in place.

Now you can position the preassembled globe and secure with an elastic band. Brush some CA glue on this with a bit of accelerator and then peel of the elastic band. Insert and secure pieces #10 and #11 with CA. Re-insert the brass tube and assemble pieces #12 thru #16. Remove the brass tube and secure these with more thin CA glue. The last 3 pieces to install are the eagle wings #17 and #18, and the eagle body #19. Because of all the cut lines in the Eagle, once assembled brush thin CA glue

over all of these cut lines on the eagle and the chains.

Once the thin CA glue has completely cured we're going to glue in the brass

tube. Check the fit to see if you need to sand the inside of the barrel for the brass tube to fit smoothly. We use our sanding mandrel for this but if you don't have one yet you can 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.

Position and center the brass tube inside the red barrel. Once all glue has cured, sand the ends flush

to the brass tube (don't use a barrel trimmer) and mount on the lathe

for turning and finishing. We use

a CA glue finish on all of our inlay

kit pens but any

other finish you prefer

will work well.

