

Basic Assembly Instructions for the Killer Whale Pen Inlay Kit



There's a total of 10 pieces in this kit. The woods used are Blackwood, Holly, Blue dyed and stabilized boxelder and Bethlehem Olivewood. A quick look at Fig. 1 will let you know if anything is missing so do that before proceeding. We'll start by sliding the brass tube into the blue barrel. Don't glue this in yet. We'll now fit the right side mountain piece, the white snowcap and the whale into the blue



barrel. Position the mountain first and then (starting with the tail) fit the whale into place. Then add the snowcap. Wrap a couple of the included elastic bands tightly around the assembly. (Fig.2).



Now we can remove



the brass tube. Make sure that the pieces are recessed into the blue barrel to eliminate any gaps. (You'll notice that the mountain piece stops short of the blue barrel by about 1/4". This will be the point at which the brass tube will be inserted to.) Place a few drops of thin CA glue over the seams to secure all 3 pieces to the blue barrel.

Now we can position and glue the left side mountain piece in place. The remaining 5 holly pieces can be positioned and glued with thin CA in any order. Go back and make sure that you've got CA glue on every seam on the barrel.

Once the thin CA 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. 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. Slide the brass tube just past the mountain on the right side. 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.



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