

Turned Letter Opener

CUT LETTER OPENER BLANK

1. Cut letter opener blank approximately 5/8" x 5/8" x 2-1/8"
2. Cut 1 WOOD SPACER - 2" long

It is important that BLANK be cut square to the brass tube

SQUARE BLANK BEFORE DRILLING

DRILL BLANKS

1. Using a drill press and a letter "O" drill bit, drill a hole lengthwise through the center of blank and wood spacer.
2. Glue blank to brass tube. Rough surface of brass tubes with fine grit sandpaper or steel wool. Apply CA (cyanoacrylic) glue to the inside of the blank at one end. Once the glue is applied, place the blank on end, glue end up, and quickly push tube into blank until it is flush with the end of the blank at the opposite end. The blank will have a small portion of tube remaining outside the blank, this is correct. Allow glue to dry and remove excess glue from edges and inside of tube. ***Note CA glue dries very quickly and these steps must be done as quickly as possible.**

***Remember, blanks must be square** - if not square, use belt sander to sand flush with brass tubes. Use a file against the shoulder of the blank where the brass tube is exposed and square the shoulder while turning slowly.

MOUNT BLANK ON MANDREL

1. Slide LARGE OD BUSHING flush to the FIXED COLLAR as shown in diagram.
2. Slide LETTER OPENER BLANK, with exposed tube toward mandrel threaded end, onto the LARGE OD BUSHING.
3. Slide 3-STEP BUSHING, largest diameter first, over the exposed brass tube and flush to LETTER OPENER BLANK.
4. Slide WOOD SPACER onto 3-STEP BUSHING.
5. Slide SMALL OD BUSHING into WOOD SPACER.
6. Finger tighten nut, snug. Do not over-tighten.
7. Turn LETTER OPENER BLANK down almost even with diameter of bushings, and then sand flush to bushings. The diameter of the LETTER OPENER BLANK should now match the bushings diameter. Final sand with finer grits of sandpaper and finish. You are now ready to assemble.

LETTER OPENER ASSEMBLY

*Moderate force is needed to press fit parts. A drill press or vise may be used to completely press parts together. Use wooden or padded vise jaws. Protect pen parts from scratches with cloth or thin pad. Pen parts are delicate! **Go slowly and carefully.**

- Step 1: Assemble the 3-PIECE CENTER RING as shown in diagram. Slide over the exposed brass tube flush to the shoulder of the BODY - if CENTER RING is loose, carefully glue in place.
- Step 2: Insert the stem of the BLACK FINIAL END through the GOLD RING and press into the end of the body.
- Step 3: Press the BOLSTER stem through the 3-PIECE CENTER RING and into the body.
- Step 4: Carefully thread the OPENER BLADE through the bolster and finally into the BLACK FINIAL END. Snug the OPENER BLADE being careful not to over tighten. (over tightening may shear the stem of the BOLSTER, causing irreparable damage). Letter opener is now finished.

Figure 1

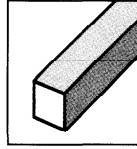


Figure 2

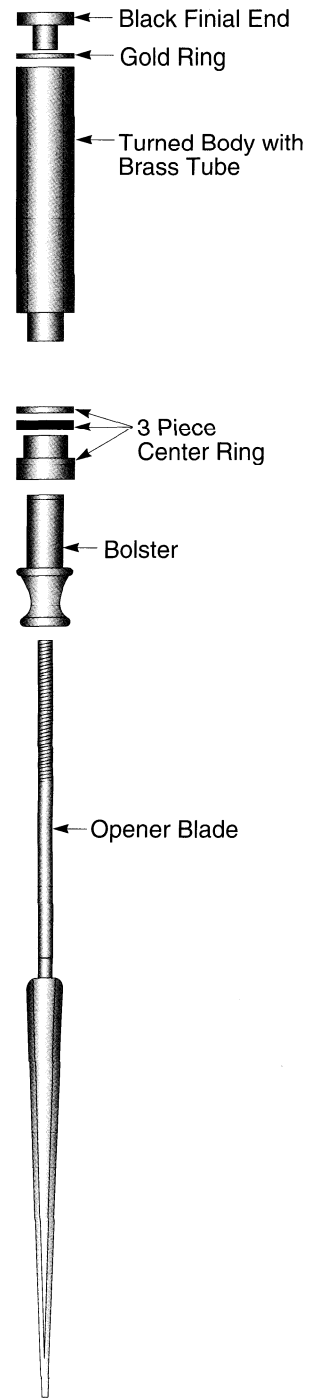
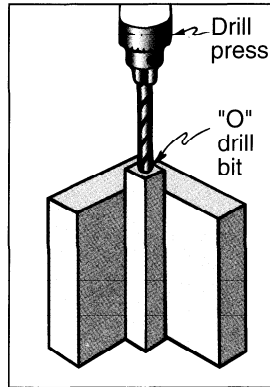


Figure 3

