



PKR LET4 – 4 Ring Letter Opener Kit Finishing Guide

NB: Please read these instructions fully before starting – we recommend watching our assembly video to assist

To complete this kit you will need: 9.7mm (3/8”) drill bit (L4DRL) Bushing Set (L4BSH), suitable glue and pen mandrel.

The LET4 letter opener kit comes with 4 chrome rings which are positioned after the blank is turned and is made in a different way to most tube based kits.

It is up to the maker to choose where these rings are fitted, this guide will explain their positioning equally spaced along the handle. This is probably the most complex of possible arrangements. The brass tube is 56mm long and the length of all 4 chrome rings together is 6mm – you are therefore aiming to get 50mm of blank section -in this example it will be 5 x 10mm pieces the interstitial bushing fits onto the brass tube to create a length slightly longer than 56mm so the blank parts are compressed for turning

1] Use a blank 70mm long and 16x16mm square minimum

2] Drill the blank using a 9.7mm (3/8”) drill bit

3] Ensuring all ends are square, cut the drilled blank into 5 x 10mm pieces – these cuts must be square.

4] De-burr any flaking material from the cut blank surfaces so they will push together without any gap – one or 2 passes over abrasive paper on a flat surface is ideal

5] Push the 5 pieces of blank onto the brass pen tube with the interstitial bushing towards the centre – **DO NOT GLUE THEM**

6] Insert the bushings at either end of the brass tube and mount onto a mandrel or between centres. There must be enough pressure of the bushings on the blank parts to compress them for turning – if they are loose the blank parts will spin and turning will not be possible.

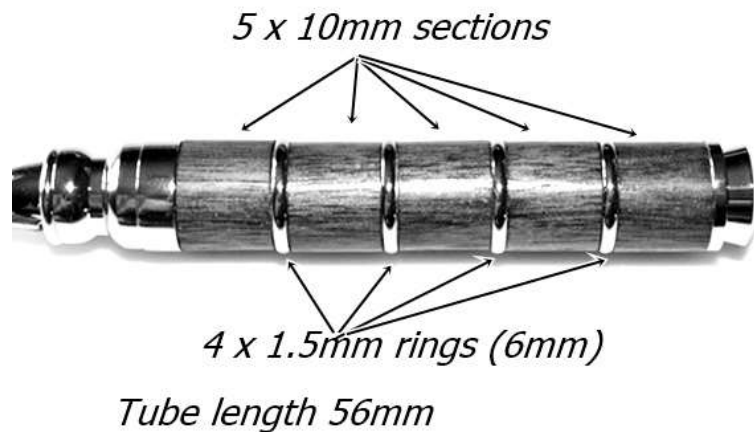
8] Once turned to the bushing diameter the parts can be finished. (NB: if a thick finish coat is used such as CA or melamine use a sharp skew chisel to create a break in the coating so the parts can be separated when finished)

9] Lightly sand the brass tube and return each part, in order, with a small amount of glue (a slow setting glue is recommended) and push each chrome ring in between each turned part. There is no need to glue the chrome rings. If required the handle

can be returned to the lathe for any extra finish or wax required but do NOT use any abrasive as it will strip the finish from the chrome rings.

10] Unscrew the blade from the head section and then using a suitable tool, press the head and end cap onto each end of the tube until they reach the turned parts and fit flush

12] Re-screw the blade section – voila!



Please note: the configuration of the chrome rings is up to the maker, they can be pushed together to make a 4-ribbed piece or 2 x 2 rings or indeed any configuration and can be placed anywhere desired along the brass tube.

Because the parts are turned before gluing it is possible to practise or amend your design before the kit is finally assembled. This means you do not risk losing the kit to a poor cut or turning error unlike most others.

If you feel the kit requires too much work you can discard the rings and turn as any other common tube-type kit and glue the blank onto the tube before turning.