

Berea Hardwoods Co., Inc.
Kit Instructions

Berea Hardwoods Circuit Board 2 gig USB Drive Key Chain (Berea #U0903/K-PCB-CHIP-xx)

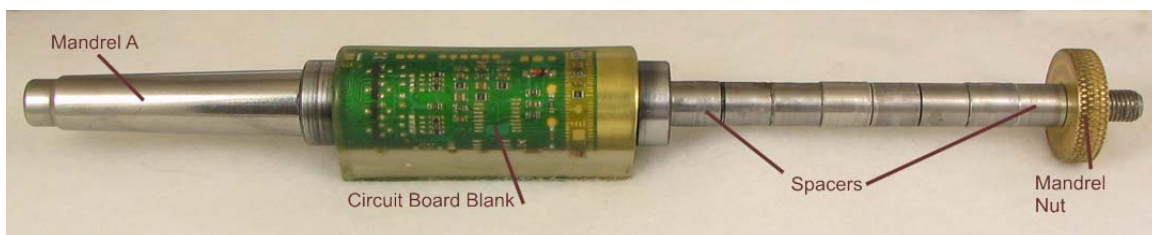


Needed: Mandrel-A
Bushings-25A
Drill-None
Wood Size- None

Preparing the Material Blank

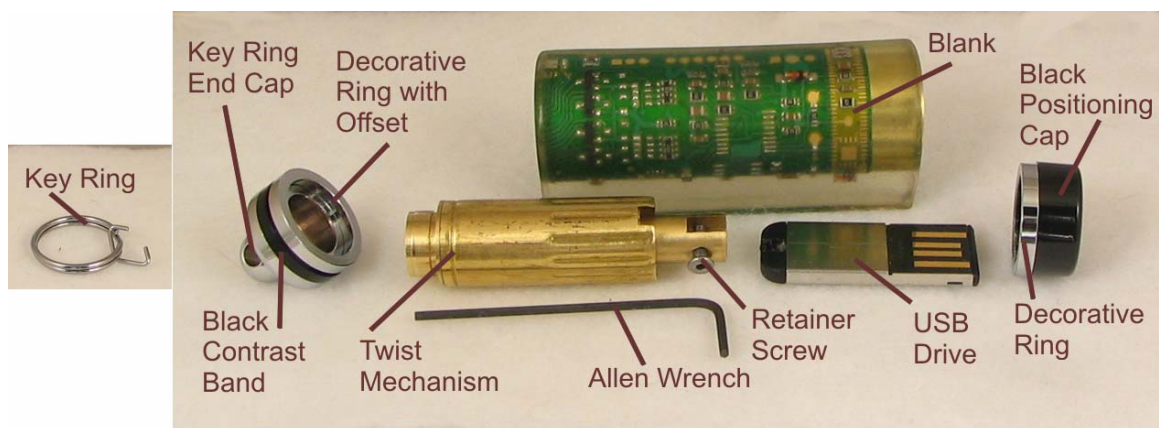
1. The material blank is provided with the brass tube already in place.
2. Using a barrel trimmer of the proper size, face off the ends of the blank until you can just see the bright brass end of the tube. STOP facing at this point. Your USB Drive's proper operation is dependent on having the proper length tube. This facing operation can also be done with the proper jig and a disk or belt sander.
3. Not having the proper tube length is the #2 cause of pen failure. Sanding, on a disk sander, using a jig to hold the tube square with the disk, is a more sure way of getting the proper length. It should be tried if you have any doubt as to your abilities to square the material with the barrel trimmer.
4. Another good method of squaring the ends of the blank is to turn the blank until it is just round. Using a miter gauge to maintain the blank perpendicular to the sanding disk, just touch the ends to the disk. Once the blanks are square and you can see the ends of the tubes brighten, then return the blanks to the mandrel and finish the turning until the desired contour is accomplished.

Turning the Material Blank



Mandrel Setup

1. Assemble the blank on the mandrel using the 25A bushings. Place the bushings in either position as they are both identical.
2. Tighten the tailstock before tightening the blank on the mandrel. This will center the mandrel first. Then tighten the nut that holds the blanks.
3. Turn the blank to straight contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
4. Now, measure back ¼” from the end with the wide gold band.
5. Turn a tenon on the end of the blank to the brass tube and to your measured mark of ¼”. Be careful not to undercut the brass.
6. After turning the blank, sand the surface in progressive steps until you get to 400 or 500 grit.
7. If a higher polish finish is desired continue sanding with Micro Mesh through 12000 grit.
8. Apply the finish of your choice and polish.
9. Remove the blank from the mandrel.



Parts Diagram

Assemble the USB Key Ring

Please refer to the Parts diagram

1. Assemble the Key Ring End Cap, the Black Contrast Band, and the Decorative Ring with the Offset. These may have to be pressed home.
2. Very lightly push this assembly onto the turned end of the twist mechanism.
3. Hold the twist mechanism firmly by the brass body and twist the end cap until the mechanism twists out of the barrel. Make sure you do this several times. If the mechanism seems a little rough, while the mechanism is retracted, using a cotton tipped swab, place a TINY amount of petroleum jelly or other light grease into the mechanism. Now, run the mechanism in and out until it moves smoothly.
4. Using a piece of wood with a ¼” hole drilled through it as a press plate, press the twist mechanism home in the end cap. Check the operation of the mechanism again.
5. Twist until the mechanism is exposed. Using the allen wrench provided, loosen the exposed screw.
6. Align the hole in the USB Drive and retighten the allen screw.
7. Push the end cap/twist mechanism/USB assembly into the end of the tube opposite the tenon you cut. Push it in until the end cap is home against the circuit board tube.

8. Twist the end cap to expose the USB Drive out the end of the tube where the tenon is located.
9. Drop on the decorative ring.
10. Align the slot in the black positioning cap over the USB Drive and push it home over the exposed brass tube.
11. Check the operation of your new USB drive.
12. Crimp the jump ring through the hole in the end cap finial.
13. Thread the split ring through the jump ring.
14. Great kit and very useful!

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