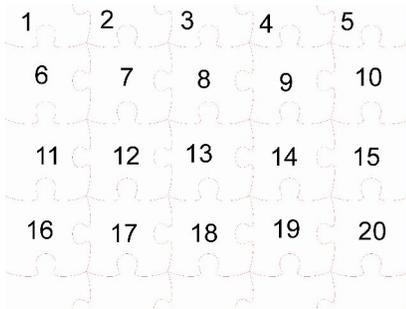


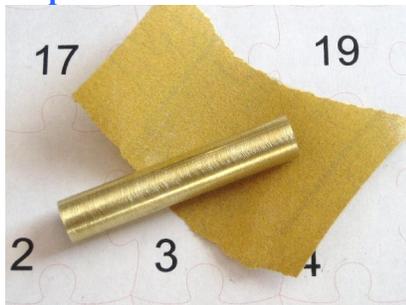
Baron / Navigator *Puzzle inlay kit assembly instructions*

Step 1:



Remove all puzzle pieces from the container and arrange the pieces as per included diagram. The puzzle pieces are conveniently numbered to correspond with the diagram. *Please note that the diagram might look different from this illustration.*

Step 2:



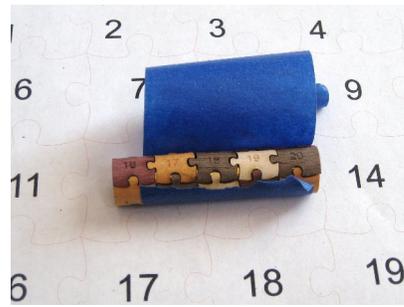
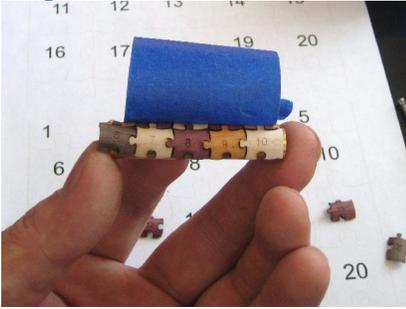
Take the brass tube from your pen kit and prepare it as you would do with any other wooden pen blank. Cut a piece of 2 inch blue painters tape, long enough to go around the tube twice.

Step 3:



Start placing the puzzle pieces on top of the scuffed tube. Start with number 1 and complete the first row. *Please DO NOT USE any glue at this stage.* Place the blue painters tape on the first row of puzzle pieces as per photo illustration.

Step 4:



Place the second row of puzzle pieces, numbers 6 – 8 and roll the blue tape on to the second row and follow with third and fourth row until the puzzle is complete. When the last puzzle is in place roll the blue tape to cover the last row and make sure it is tight. Use a $\frac{3}{4}$ inch tape and roll it tight around the tube to make sure that all the pieces are snug and tight.

Step 5:



Remove the scuffed brass tube from the assembled puzzle and use any familiar method to glue the brass tube into the assembled puzzle blank. Ca glue works great and cures pretty fast. Make sure that you give the glue enough time to cure before you proceed with the next step.

Step 6:



Remove all the masking tape and prepare to trim the ends of the barrel.

Please DO NOT USE a barrel trimmer it will tear the puzzle pieces off the ends of the puzzle blank.

Use a squaring jig to trim the ends of the barrel.

Please repeat steps 1 to 6 for both the upper and lower barrel to assemble your puzzle inlay kit.

Step 7:



Place the barrel with bushings on the mandrel and place in lathe. Use 180 grit sandpaper to sand the barrel to the desired shape. While sanding place a couple of (thin) CA glue drops on the barrel, that would fill all the small gaps in between the puzzle pieces and ensure a great finish product. Use progressively finer sandpaper until you are satisfied with the finish.

Step 8:



The barrel can now be finished with a finish of your choice. CA glue works great and would provide a great long lasting finish. The pen in this project was finished with CA glue.

Step 9:

Follow your pen kit instructions to assemble your new pen.



Baron Pen with CA glue finish