

# Basic Instructions for the Stars and Stripes Inlay Kit



## Stripe Barrel Assembly

We're going to start with the red and white stripe barrel. Don't insert the brass tube into the lower white barrel until all the stripes are glued in place. Position the dyed red stripes into the recesses in the barrel. There's only one way they'll fit. Make sure they are well seated to avoid gaps when turned to the final diameter. Apply a small dot of CA glue at 3 or 4 points along the length of the stripe and then move to the next one. Once they are all in place, you can apply CA glue along the seams to totally seal the barrel. There's a good chance that a few of the stripes ended up below the inside surface of the barrel. This will require you to sand away the excess inside the barrel with a dowel wrapped with sandpaper until the brass tube fits. Now glue the brass tube in. I use 2-part epoxy for this. Make sure you center the brass tube with the barrel so when you sand away the ends you won't have a solid natural maple ring at one end of the barrel. Once the epoxy is completely dry, sand the ends flush with the brass tube. Don't use a barrel trimmer for this. I use a disc sander and then square it up on the lathe in a collet chuck.



## Star Barrel Assembly

For those of you who have made the stars and stripes kits in the past (pre 04/08), you'll notice that the brass tube is no longer installed in the barrel and the stars are now cut all the way through the barrel.

We'll start the star barrel assembly by wrapping a piece of parchment paper around the brass tube and inserting it into the barrel. Brush water-thinned yellow glue in approx. 4-5 star recesses at a time. Have a bunch of stars ready to poke gently with an EXACTO knife (see picture) one at a time and align with the recess. Use your exacto knife as a roller to press them in making sure you get them at least flush with the barrel so they won't disappear when you're turning the barrel to final dimensions. Replace the parchment paper a couple of times during the glue-up procedure to prevent it from getting too gummed up. Use the thinned glue liberally and don't worry about squeeze out. You should get plenty. Allow a couple of hours for glue to fully set up. With it being thinned, it will obviously take a bit longer.



Now you can glue in the brass tube. I would suggest using 2- part epoxy for this. Make sure you get the brass tube aligned accurately with relation to the stars. Once the epoxy is dry sand the ends of the barrel flush with the brass tube.

Don't use a barrel trimmer for this. At this point, the barrels are mounted on the lathe with the bushings and carefully turned down to final diameter.