

## CIGAR PEN

### Instructions

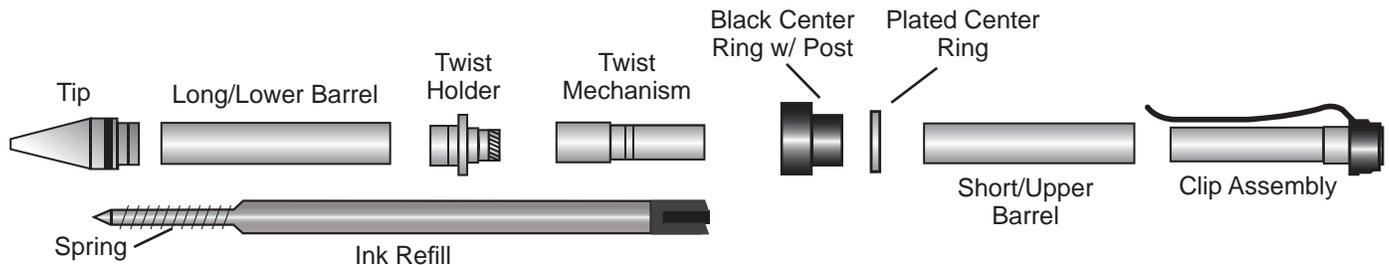
#### Kit Features

- Larger and more substantial than the Slimline pen
- Shows off the wood in a way a smaller pen cannot
- Uses smooth-writing Parker™ style refill (RE-PARK)

#### Required Accessories & Materials

- 7mm mandrel
- 3-pc. Cigar bushing set (PKCIGARBU)
- 10mm drill bit (DB10MM or DB10MMCT)
- 10mm barrel trimmer or belt sander to square the ends of the blanks to the tubes
- Glue (We recommend the thick “gel” CA glue—GTHICK2)
- Sanding and finishing supplies

#### Diagram A - Pen Parts and Assembly



#### BLANK PREPARATION

The tubes in a Cigar pen kit are of different lengths. Make sure that as you cut the blanks for the tubes you orient them so that the longer 2-1/16" tube will be used as the lower pen barrel. The upper tube is a little shorter at 1-7/8" long. **Cut** your blanks approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. If using wood blanks, mark the blanks so it is easier to keep the grain running in the same direction when you place them on the mandrel for turning. Use a medium drill speed to **drill** the blanks. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blanks, **sand** the exterior of the brass tubes to roughen their surface and use CA **glue** to glue the tubes inside the blanks. Sand or barrel trim to **square** the ends of the blanks.

#### TURNING THE PEN

**Set up** the mandrel as shown in Diagram C. In setting up your bushings, you will use the smallest of the three bushings (bushing 1) at the tip of the pen. The lower barrel goes on the mandrel followed next by the large combined bushing (bushing 2). Orient this middle bushing so the smaller end is toward the pen tip. Slide on the upper barrel, and then the last of the three bushings (bushing 3) will go at the top end of the pen. Keep in mind which pen barrel you are turning as the top and bottom. Remember, the upper tube is shorter than the lower tube. If you mistakenly get the short tube at the bottom of the pen, the refill will not retract properly. **Turn** the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

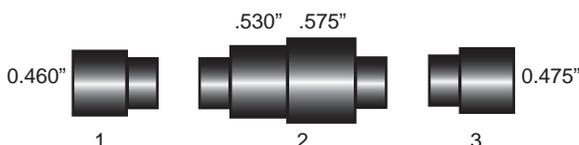
#### ASSEMBLY

(Line up finished parts according to Diagram A)

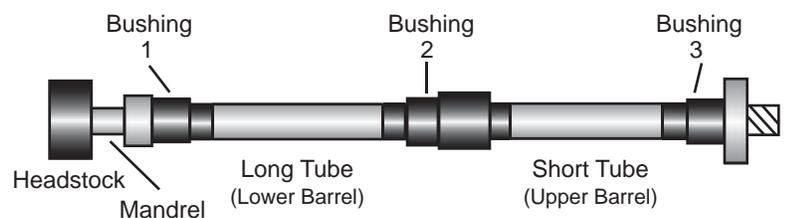
*To avoid damage to components when assembling, use a pen press or a vise with covered jaws.*

1. Assemble the three-piece tip assembly, which consists of the tip, the tip coupler, and the black trim ring. In some kits, these pieces may come pre-assembled.
2. Press the assembled three-piece assembly into the lower end of the long pen barrel.
3. Press the twist holder into the opposite end of the lower pen barrel.
4. Drop the ink refill with the refill spring into the threaded twist holder and screw on the twist mechanism. Check for proper refill retraction. If it doesn't retract fully, the lower tube dimensions have most likely been shortened, or the upper and lower pen barrels have become switched.
5. Place the plated center ring over the black center post and press into the lower end of the upper pen barrel.
6. The clip and cap assembly consists of three parts which in some kits may come assembled and in others may require assembly. The three parts are the cap, clip, and the cap post. Assemble, if necessary, and press into the upper end of the upper pen barrel.

#### Diagram B - Pen Bushings



#### Diagram C - Turning the Pen



## CIGAR PENCIL Instructions

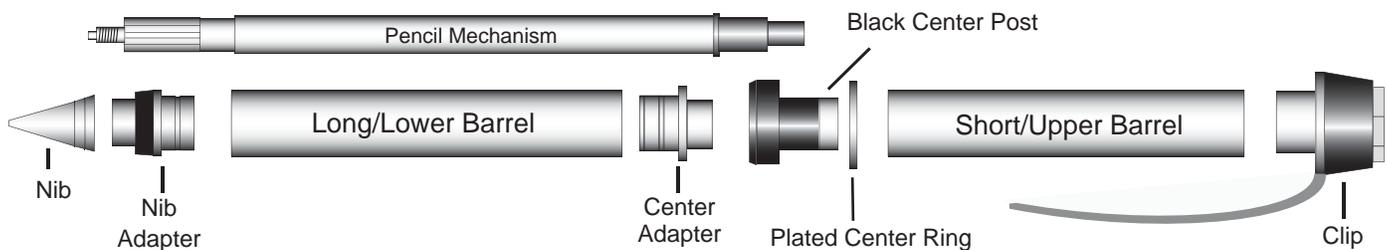
### Kit Features

- Larger and more substantial than the Slimline pencil
- Shows off the wood in a way a smaller pencil cannot
- Uses a heavier .9mm lead

### Required Accessories & Materials

- 7mm mandrel
- 3-pc. Cigar bushing set (PKCIGARBU)
- 10mm drill bit (DB10MM, DB10MMCT)
- 10mm barrel trimmer or belt sander to square the ends of the blanks to the tubes
- Glue (We recommend the thick "gel" CA glue—GTHICK2)
- Sanding and finishing supplies

### Diagram A - Pencil Parts and Assembly



### BLANK PREPARATION

The tubes in a Cigar pencil kit are of different lengths. Make sure that, as you cut the blanks for the tubes, you orient them so that the longer 2-1/16" tube will be used as the lower pencil barrel. The upper tube is a little shorter at 1-7/8" long. **Cut** your blanks approximately 1/16" longer than the tube to allow for squaring with the barrel trimmer. If using wood blanks, mark the blanks so it is easier to keep the grain running in the same direction when you place them on the mandrel for turning. Use a medium drill speed to **drill** the blanks. Raise the bit from the blank every 1/4" to 1/2" to allow the chips to clear from the flutes of the drill bit. Don't force the drill bit; use an even pressure and let the bit do the work. After drilling the blanks, **sand** the exterior of the brass tubes to roughen their surface and use CA **glue** to glue the tubes inside the blanks. Sand or barrel trim to **square** the ends of the blanks.

### TURNING THE PENCIL

**Set up** the mandrel as shown in Diagram C. In setting up your bushings, you will use the smallest of the three bushings (bushing 1) at the tip of the pencil. The lower barrel goes on the mandrel followed next by the large combined bushing (bushing 2). Orient this middle bushing so the smaller end is toward the pencil tip. Slide on the upper barrel, and then the last of the three bushings (bushing 3) will go at the top end of the pencil. Keep in mind which pencil barrel you are turning as the top and bottom. Remember, the upper tube is shorter than the lower tube. If you mistakenly get the short tube at the bottom of the pencil, the refill will not retract properly. **Turn** the pen blank to the bushing diameter at the ends. **Sand** with abrasives and **finish** with your choice of polish.

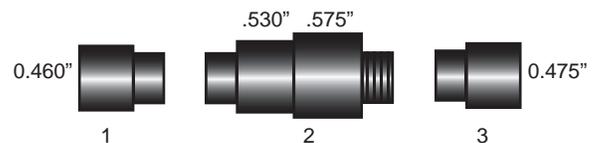
### ASSEMBLY

(Line up finished parts according to Diagram A)

*To avoid damage to components when assembling, use a vise with covered jaws or one of WoodTurningz' pen presses.*

1. Press the plated tip adapter with black trim ring into lower end of the long barrel.
2. Press the plated center adapter into the upper end of the long barrel.
3. Place the plated center ring onto the black center post and press into the lower end of the short barrel.
4. Press the clip assembly into the upper end of the short barrel.
5. Drop the pencil mechanism into the lower barrel and thread the tip onto the threaded tip of the pencil mechanism.
6. Slide the upper barrel over the pencil mechanism.

### Diagram B - Pencil Bushings



### Diagram C - Turning the Pencil

