



Cigar Pen Kit Instructions

Required Materials

- 7mm pen mandrel
- Set of Cigar Pen Kit bushings
- 10mm drill bit
- CA (cyanoacrylate) glue or two-part fast-drying epoxy
- Pen blank
- Pen press, vise, or clamp
- Sanding supplies and finish



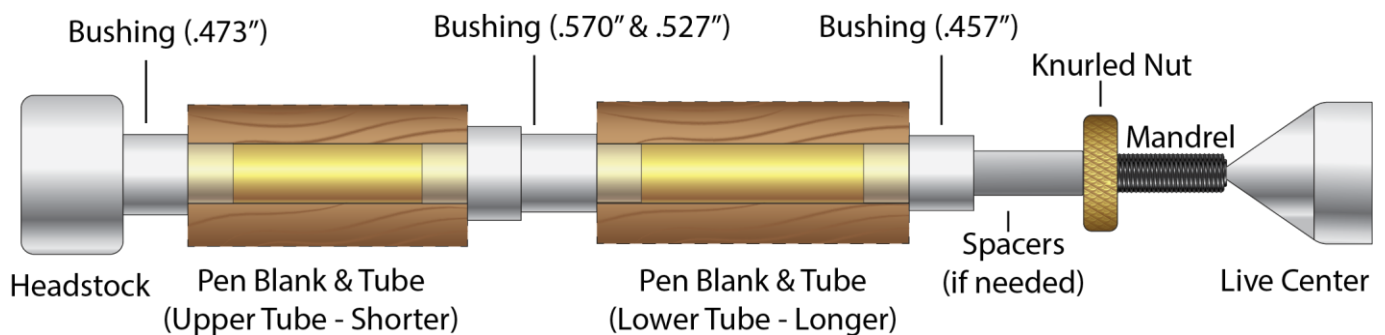
Blank Preparation

1. Cut blank to length of brass tubes, plus an additional 1/16" on each end for squaring off
2. Drill 10mm hole lengthwise through each blank
3. Rub the brass tubes with low-grit sandpaper to roughen them
4. Apply a line of glue to the brass tubes and insert each tube into the middle of the blanks with a twisting motion to spread the glue throughout the blanks
 - Ensure the inside of the tubes are free of any glue
5. Square off the ends of each blank with a barrel trimmer or sander to be flush with the brass tube

Turning the Blank

Follow diagram A below to set up the blanks on the mandrel for turning.

Diagram A



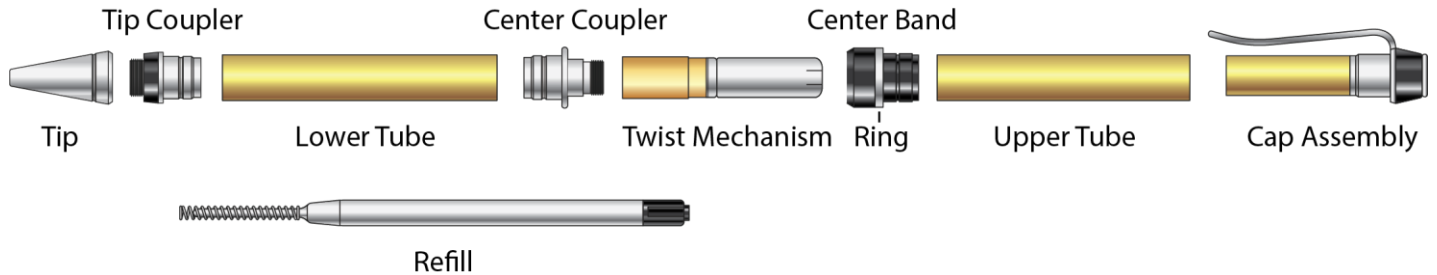
1. Turn down the blanks to the desired shape using lathe chisels, ensuring each end is flush with the bushings
2. Sand the blanks, progressing from coarser to finer grits
3. Finish blanks with choice of polish



Assembly

Follow diagram B below for assembly. Press parts using a pen press, vise, or clamp.

Diagram B



1. Unthread the Tip from the Tip Coupler
2. Press the Tip Coupler onto the narrower end (.457") of the Lower Tube/blank (longer tube)
3. Unthread the Twist Mechanism from the Center Coupler
4. Press the Center Coupler onto the opposite end of the Lower Tube
5. Thread the Tip back onto the Tip Coupler
6. Insert the Refill with spring through the Center Coupler
7. Thread the Twist Mechanism back onto the Center Coupler
8. Place the Ring onto the Center Band, then press this assembly onto the thicker end (.570") of the Upper Tube/blank (shorter tube)
9. Press the Cap Assembly onto the opposite end of the Upper Tube
10. Slide the assembled Upper Tube over the Twist Mechanism and press together by hand until snug

Additional Information

- Pen uses a Parker-style ballpoint refill
 - To replace refill, unthread the Tip