

Native Pens

Cigar Pen Instructions

Required:

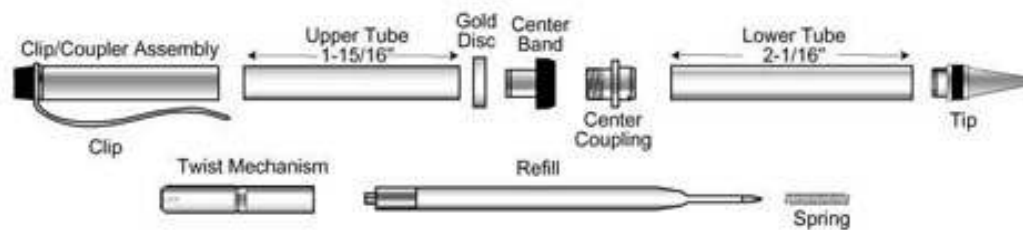
1/4" Mandrel

10mm Drill Bit

Pen Mill

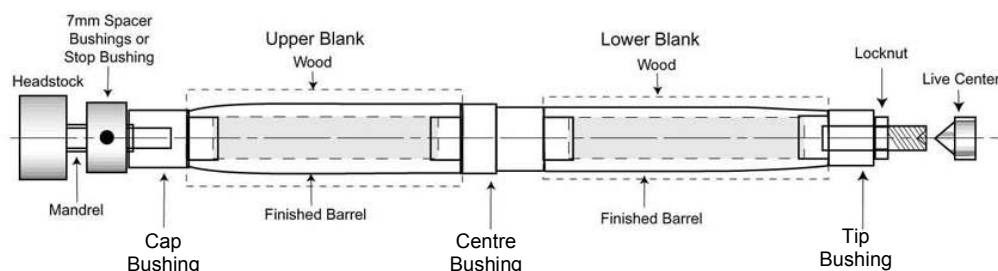
Cigar Bushings

Pen Kit Parts:



Turning the Pen Barrels.

1. Cut a pen blanks slightly longer than the brass tubes. Note; the upper and lower tubes are different lengths.
2. Drill the blanks through the centre, lengthwise, with a 10mm bit.
3. Sand the surface of the brass tube. This can be done by hand or mounted in the bushes on the lathe. This will clean off any oxidation and roughen the surface for a better glue bond.
4. Bond the tubes into the timber blanks. This can be done with CA or two-part epoxy glue. Insert the tube with a twisting motion then push it in until slightly under flush. About equal distance in from each end of the timber blank.
5. Allow glue to cure as required by glue manufacturer.
6. Clean all the dried glue from inside the brass tube. Not cleaning out all the glue from the tube is the most common cause of pen failure.
7. Using a Pen Mill, face off the ends of the blanks until you can just see the bright brass end of the tube. STOP facing at this point. Another method to square the ends is sanding on a disc sander against a square fence or using a jig to hold the tube square to the disc then lightly touching the end with the Pen Mill to finish them.
8. Once the blanks are square and you can see the ends of the tube brighten you can mount the blanks to the mandrel.

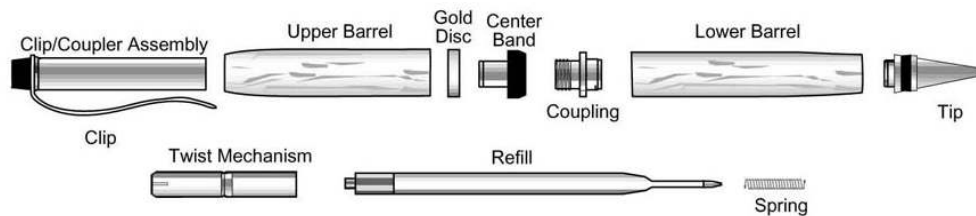


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9. Turn the blanks until the desired shape is reached, then sand the blanks down to the bushings and finish the pen to your specifications. Remove the barrels from the mandrel and it is ready for assembly.

Assembly of the pen.



1. Press the clip / coupler assembly into the tapered end of the Upper Barrel.
2. Place the Gold disc over the Centre Band and press into the opposite end of the Upper Barrel.
3. Press the Tip assembly into the tapered end of the lower barrel.
4. Press the Coupling, recessed end first, into the opposite end of the Lower Barrel.
5. Insert the Refill with Spring into the Lower Barrel.
6. Screw the twist mechanism over the Refill onto the Coupler to the end.
7. Slide the Twist Mechanism into the Upper Barrel until the parts are connected.
8. You pen is finished.