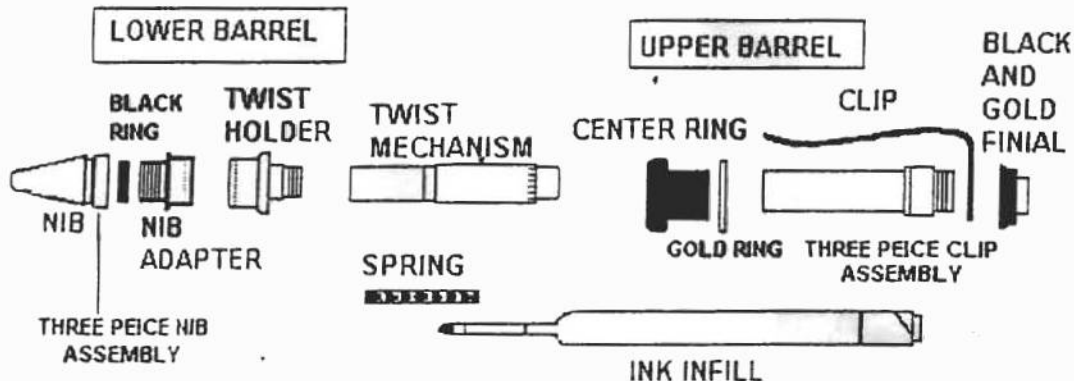


CIGAR PEN INSTRUCTIONS



TOOLING

A MANDREL

10 MM DRILL

11A BUSHINGS

WOOD BLANK 3/4 IN. X 3/4 IN. X 5 IN.

TURNING INSTRUCTIONS

1. CUT WOOD BLANKS (1-SHORT, 1-LONG) SAME LENGTH OF TUBES OR A LITTLE LONGER TO SQUARE OFF.
2. DRILL WITH 10MM BIT, EPOXY BRASS TUBE INTO MATCHING WOOD BLANK.
3. TURN TO DEPTH COLLARS, SAND & POLISH.
4. SET UP FOR BUSHING AS FOLLOWS:
LOWER BARREL (LONG TUBE) USE BUSHING WITH SMALLEST O.D. (.4600) AND SECOND LARGEST BUSHING (.5300)
UPPER BARREL (SHORT TUBE) USE BUSHING WITH LARGEST O.D. (.5765) AND SECOND SMALLEST (.4740) MATCH BUSHING TO PART IF THESE NUMBERS DON'T HELP YOU.

ASSEMBLY

LOWER BARREL (LONG TUBE)

1. PRESS NIB ASSEMBLY (3 PARTS) INTO BLANK AT END WITH SMALLEST O.D.
2. PRESS TWIST MECHANISM HOLDER INTO OPPOSITE END (LARGER O.D.)
3. PUT SPRING ON INK REFILL SMALL END FIRST AND SLIDE INTO LOWER BARREL.
4. SCREW TWIST MECHANISM ONTO TWIST MECHANISM HOLDER.

UPPER BARREL (SHORT TUBE)

1. SLIDE GOLD RING ONTO BLACK DECORATIVE RING, PRESS THIS INTO BLANK AT END WITH THE LARGEST O.D.
2. CLIP ASSEMBLY (3 PARTS) SLIDE CLIP OVER THREADS AND SCREW ON FINIAL.
3. PRESS THIS ASSEMBLY INTO OTHER END OF BLANK (SMALLER O.D.)
4. SLIDE CAP OVER TWIST MECHANISM.
5. PEN IS FINISHED, CAP CAN BE TURN TO MATCH WOOD GRAIN.