

Instructions for Closed End Cigar Pen Kit

By Dale DeHoff & Arizona Silhouette



The Closed End Cigar Pen Kit (Intro1)

is supplied with the wood pre turned with proper grain alignment, rollerball pen hardware, Delran alignment piece, rolled up cardboard cigar end and a plastic sleeve to protect the wood while turning. Dale has done all the hard work by assuring proper grain alignment on the body of the Faux Cigar. All you have to do is to follow the instructions below to create this one-of-a-kind **Faux Cigar!** To begin, insert the Delran sleeve inside the upper and lower barrels and make sure the grain is in proper alignment. Place a small strip of painters tape across the two barrels and draw a line across the piece of tape. This will assure proper grain alignment when assembling!

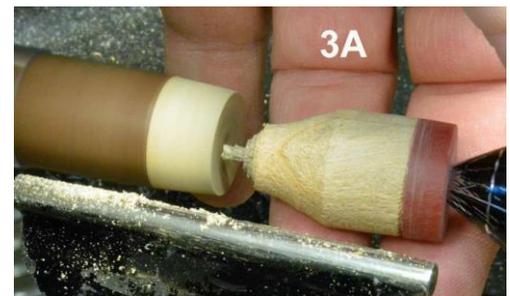
Step One: Place the plastic sleeve over the cap end (upper barrel) of the Faux Cigar blank and secure it in a four jawed chuck. (Do Not Over Tighten). The cap end is the one that has the Buckeye Burl on it as well as a piece of waste block glued to the end of the blank.



Step Two: Carefully reduce the waste block. At this time slightly and I mean slightly reduce the buckeye burl section to just a little bit smaller than the rest of the darker section of the pen blank.



Steps 3 & 3A: Use a thin parting tool, part off the waste block from the rest of the blank using your hand to catch the section that you just parted off as illustrated in photo 3A.



Step 4: Once parted off, make sure the buckeye burl section is slightly tapered and smaller in diameter than the darker wood section.



Step 5: Using a razor knife, scar the buckeye section by cutting in one direction (not in a circular pattern around the buckeye) but starting from the darker wood and slicing on an angle to the end of the buckeye and then going back and cutting in the opposite direction in a crisscross pattern.

Step 6: Using black acrylic paint found at any hobby store, paint the buckeye section with the black acrylic paint. Don't worry if you get paint on the darker wood section. If your paint line around the buckeye section is too perfect, it will not look realistic. Allow the black paint to thoroughly dry.



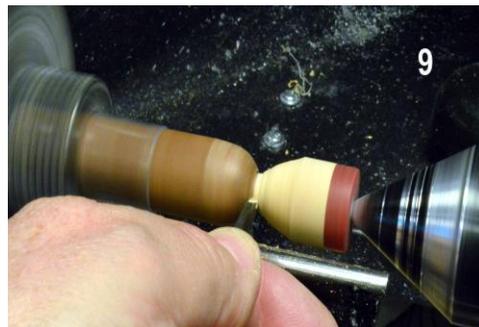
Step 7: White Out brand correction fluid (found at any stationary store) is now placed onto the black painted section to help simulate the "ash" on the end of the pen blank. Set aside the cap section.



Step 8: Place the plastic sleeve over the lower barrel assuring that the jaws of the chuck are not directly touching the wood. Bring up the tail stock for added strength.



Step 9: Using a sharp thin parting tool, carefully part off the waste block seen in step 8. Then round over



the end taking care not to shorten the end too much! This will be the end that accepts the cardboard piece simulating tobacco at the end of the cigar.



Step 10: Sand the end of the lower barrel you just parted off.

Step 11: To create the realistic end of the cigar, use a 3/8" forstner drill bit, drilling a hole 1/8" deep in the end you just



parted off and sanded in step 10. The rolled up piece of cardboard will be placed into this recess to simulate tobacco in the end of the cigar. If you do not have a forstner drill bit, you can use a sharp small parting tool as shown.

Step 12: Once the 3/8" hole is drilled, insert the rolled up cardboard into the end and drip thin CA glue into the hole to secure it in place. Allow the thin CA glue to dry thoroughly.



Step 13: Glue a cigar band of your choice (not supplied) to the lower barrel using a small amount of Mod Podge adhesive. Take care not to get too much glue onto the wood.

Step 14: Seal the label with a few light

coats of thin GluBoost CA glue applied with a paper towel making sure that you do not get the CA glue onto the wood.



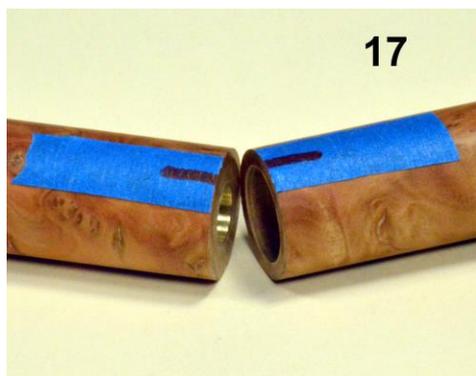
Step 15: Lightly buff both halves of the blank to a finish of your choice.



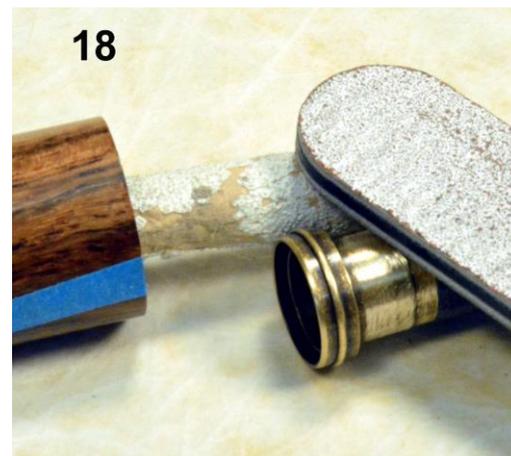
Step 16: Optional – If you want to spray the halves of the pen blank with a matte finish, spray it lightly!

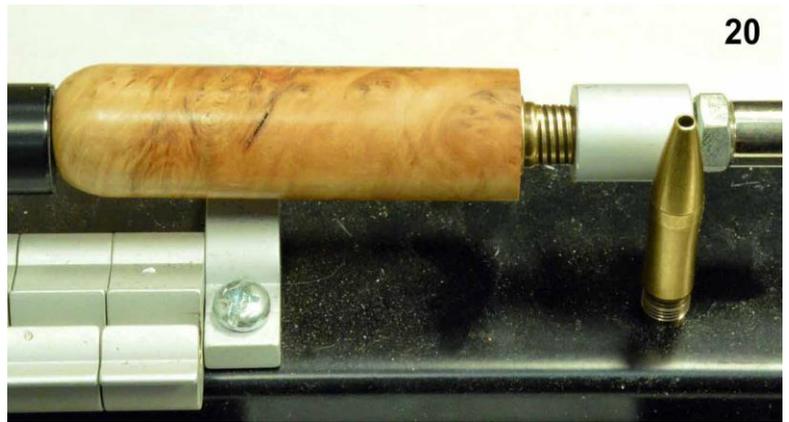
Step 17: Assembly – Line up the upper & lower sections of the pen blanks that have the painters tape on it with the line drawn.

Step 18: Rough up the inside of both upper & lower barrel brass tubes with sandpaper as well as the center band and the nib section to prepare them to be glued in using 5 minute epoxy.



Steps 19 & 20: Place a small amount of 5 minute epoxy on the nib section with the trim ring and press it all the way into the lower barrel. Set aside for 15 minutes until the epoxy fully cures.





Steps 21 & 22: Screw the nib section all the way onto the center band. Use a small amount of 5 minute epoxy and apply it to the center band and gently push the two barrels together **by hand**, making sure the lines on your painters tape are exactly matching. By doing this you are assuring a perfect grain match! Once it matches, **CAREFULLY** unscrew the lower barrel (nib) section making sure the orientation of the grain did not move and then press it all the way into the upper barrel (ash end) using a pen press.

Step 23: Insert the spring into the lower barrel followed by the refill and then screw the nib section in place. Screw the two sections together and admire your **Faux Cigar Pen!**



Trouble Shooting Tip: If you place the rollerball refill in the lower barrel and it does not go all the way into the lower barrel, you may have some epoxy on the inside of the barrel. Take a 1/4" drill bit and **CAREFULLY** drill out the glue or excess wood. Be careful not to go through the end of the barrel!