

# Rogue Senior Cigar Holders

by Barry Gross

**T**oday, with the resurgence of cigar bars and upscale smoke shops, there comes a real need for items that cigar lovers can use. This project is a very popular item at craft fairs for women to surprise the cigar-smoking men in their lives and these two different-size cigar holders offer a great way to fill the need. The Rogue will hold cigars to approximately a 42-ring gauge and the Rogue Senior will hold a cigar with a ring gauge of 50.

Don't be smoked by your fellow penmakers; be the first to offer these products to your local cigar bar or smoke shop!

## CIGAR HOLDER BLANK PREPARATION

**Step 1.** Remove the pen parts from the plastic bag and line them up according to the manufacturer's instructions. For this project, I am using the Rogue Senior Cigar Holder in chrome with an oversize 1-1/4" x 1-1/4" x 7" Tasmanian eucalyptus burl (see **Fig. 1**).

**Step 2.** Lay the cigar tubes on the blank, and mark it upper and lower. Cut the blank to length with either a bandsaw or scroll saw (see **Fig. 2**).

*Tip 1:* Whenever drilling, I always use BladeCote to spray the drill bits to reduce friction and to extend the life of the bit. The BladeCote also aids in removing debris from the inside of the blank faster; thus reducing frictional heat, which will keep the drill bits sharper longer (see **Fig. 3**).

**Step 3.** Use a 4-jawed chuck or a dedicated drill chuck, and drill the cigar holder blank at around 1,000 rpm with a Norseman 7/8" drill bit (see **Fig. 4**). Drill both the upper and lower parts of the blank (see **Fig. 5**).



**Step 4.** Here is a comparison of the entry hole on the left and the exit hole on the right (see **Fig. 6**). See how clean both holes are by using a combination of the appropriate speed; a sharp, lubricated drill bit; and a constant feed rate while relieving the debris consistently?

**Step 5.** Rough-up the cigar tubes so that the two-part epoxy will have a good bonding surface with the tube and the inside of the eucalyptus blank (see **Fig. 7**).

*Tip 2:* Use a two-part epoxy rather than cyanoacrylate glue (CA or superglue) whenever you are gluing a larger blank, or when you are using "wet" or not quite dry wood. The reason is that the CA will bond almost instantly with wet wood because moisture accelerates glue set and the tube will get "stuck" halfway in the blank (see **Fig. 8**).

**Step 6.** When using two-part epoxy, make sure that you use EQUAL amounts of the epoxy and hardener and mix



Fig. 1

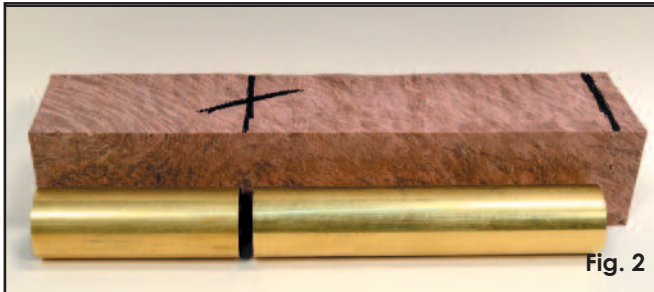


Fig. 2



Fig. 3

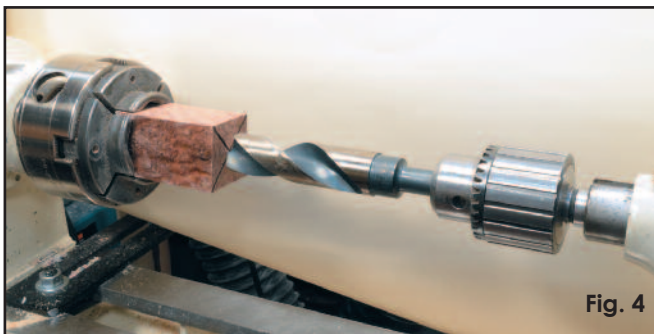


Fig. 4

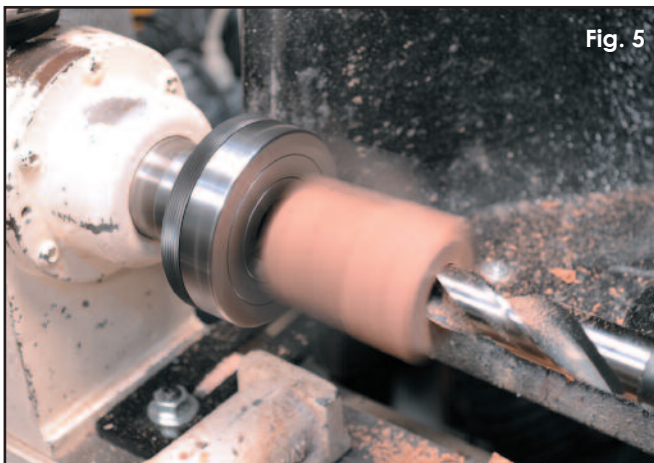


Fig. 5

## SUPPLIES

**Tools:** lathe with turning tools, including roughing gouge, skew, and small parting tool; scroll saw or bandsaw; disk sander with squaring jig; drill chuck and appropriate drill bit for cigar holder kit selected; Norseman 7/8" drill bit; pen press; for barrel trim sleeve: 7mm pen tube and piece of scrap wood

Pen kit of choice (BHW 220 & BHW 221)\*

Blank of choice (Tasmanian eucalyptus burl was used for this project)

PFK-1 Acrylic sanding kit\*

PFK-2 Abralon sanding kit\*

APBS-1 Acrylic Pen Buffing System\*

Assorted grits of abrasive paper

Hot Stuff Super-T cyanoacrylate glue

(CA or superglue)\*

5-minute 2-part epoxy\*

BladeCote\*

Hobby knife

Compressed air

Paper towels

Small plastic bag

*\*All materials, including Rogue & Rogue Senior Cigar Holder kits, used for this project are available from Arizona Silhouette, 3430 Progress Drive, Suite C, Bensalem, PA 19020; phone: 888-717-4202 (toll-free); website: [www.azsil.com](http://www.azsil.com).*

*Please refer to all manufacturers' labels for proper product usage.*

thoroughly (see **Fig. 9**). Tube failure could be the result if the epoxy is not mixed adequately or unequal amounts are used!

**Step 7.** Place a light coating of the epoxy onto the cigar tubes and insert the coated tube into the blank, twisting it in and out as you go; this will ensure a good bond between the blank and the cigar tube (see **Fig. 10**). Let it stand for at least thirty minutes before starting to turn the blank.

**Step 8.** If any glue is inside the ends of the brass tubes after the glue has dried, remove it from the ends of the tubes by using a hobby knife (see **Fig. 11**).

**Step 9.** Place the cigar tube onto the mandrel with the appropriate bushings (see **Fig. 12**). You can only turn one piece at a time due to the overall length of the project. I do not square the blank at this time, but will square it after it is reduced closer to the diameter of the bushings in **Step 12**.



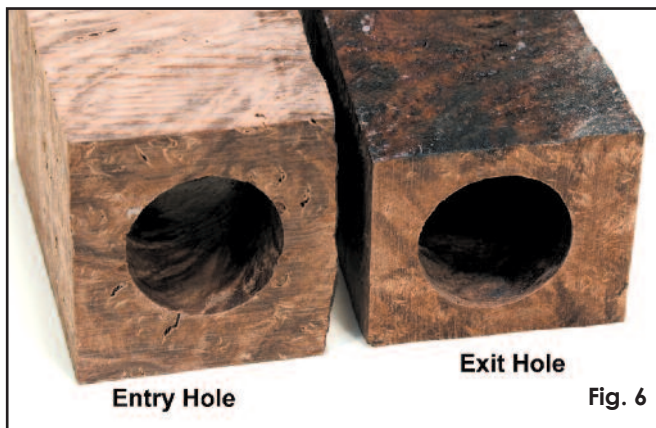


Fig. 6



Fig. 7



Fig. 8

**Step 10.** Use a roughing gouge to reduce the blank to round (see **Fig. 13**) and turn it slightly proud of the bushings—you will now square the ends of the blank. First, you must make a barrel trim sleeve that will fit inside the cigar holder (see **Step 11**). I always reduce the blank to almost flush to the bushings before I square the ends. By doing it this way, only a small amount of material is removed, rather than surfacing a large square piece.



Fig. 9



Fig. 10



Fig. 11

**Step 11.** Make your own barrel trimming sleeve as follows:

You can make a trim sleeve for any pen kit that does not have one. Start with any length 7mm pen tube and a piece of scrap wood (see **Fig. 14**).

Glue the 7mm tube into the scrap piece and place it on a mandrel with the bushings for the cigar holder. Then reduce the scrap piece down to the inside of the diameter of the bushings (see **Fig. 15**).



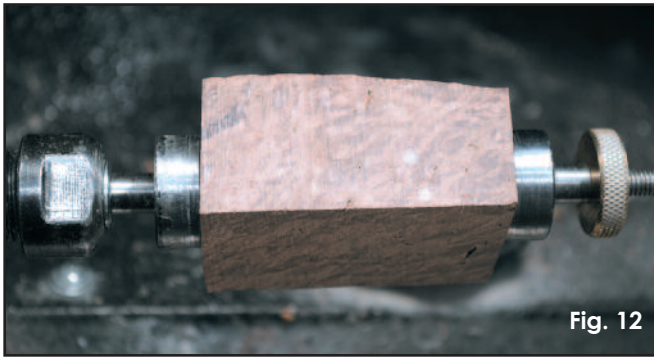


Fig. 12



Fig. 13



Fig. 14

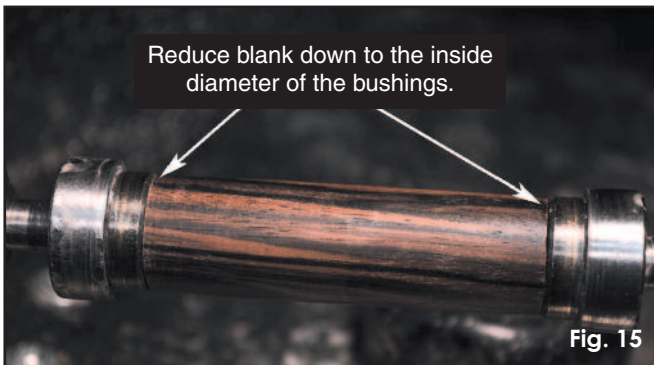


Fig. 15

The scrap piece must be able to fit inside the barrel (see Fig. 16).

**Step 12.** You will not be able to use a barrel trimmer to square a blank this large, so a squaring jig will be used (see Fig. 17).



Fig. 16



Fig. 17



Fig. 18



Fig. 19

**Step 13.** Square the cigar holder tube using the squaring jig and the trim sleeve you just made (see Fig. 18), and place your "squared" blank back onto the mandrel.

**Step 14.** Use a skew to continue to reduce the blank down to the bushings (see Fig. 19). The shape of the





Fig. 20



Fig. 24



Fig. 21



Fig. 25



Fig. 22



Fig. 26



Fig. 23



Fig. 27



Fig. 28



Fig. 29



Fig. 30

cigar holder is straight across, so be careful at this point not to get a catch with the skew!

**Step 15.** “Skew happens.” If you get a catch, repair the hole by taking some of the shavings and placing them into the hole. Then drip thin CA onto the repair (see Fig. 20), followed by using the skew again, but this time NOT tearing out a piece.

**Step 16.** Sand the cigar holder to 800 grit (see Fig. 21) and then use the Abralon pads to complete the sanding process (see Fig. 22).

**Step 17.** Use compressed air to remove any sanding debris that may be in the fibers of the cigar blank (see Fig. 23).

**Step 18.** Use a small parting tool to cut a square tenon on the end of the cigar holder blank (see Fig. 24). The Rogue Senior has to have a 3/16" shoulder or tenon cut into each end of the blanks to accept the centerbands and coupler for the top and lower portion of the holder.

**Step 19.** Apply approximately six to eight coats of medium CA glue, using a paper towel and your finger that is covered with a plastic parts bag (the ones you can never throw away—so you have lots of these!) (see Fig. 25).

**Step 20.** If the CA glue has a smooth finish, proceed to the next step. If you have some high spots or “bumps,” use a piece of 320-grit abrasive paper and lightly sand out those bumps (see Fig. 26).

**Step 21.** Wet-sand the blank using the acrylic finishing pads (see Fig. 27).

**Step 22.** Buff the blank using the acrylic pen buffing system with the special blue rouge designed specifically for acrylics (see Fig. 28). Repeat the process for the other half of the Rogue Senior Cigar blank.

**Step 23.** Once both halves of the Rogue Senior Cigar blanks are turned and polished, line them up for assembly according to the instructions (see Fig. 29). Use a pen press or small arbor press to assemble the cigar holder.

Here is the final photo of the Rogue Senior Cigar Holder (see Fig. 30).

## Barry Gross

Barry Gross is an artisan with over thirty years of experience working in several diverse media. He has published articles in several woodworking magazines, is an author of three books on turning, and has released a DVD on penmaking. Barry is a member of several woodworking organizations and the Pen Makers Guild. He is frequently a guest speaker/presenter at woodworking shows and turning clubs throughout the northeast. He was featured by Pennsylvania Cable Network for his unique style in using recycled material to make pens.

Barry was commissioned from the “White House” to make pens as gifts for former Vice President Cheney, and his pens can be found in the pockets of several well-known individuals, including Steven Spielberg, Greg Norman, Norwegian concert pianist Leif Ove Andsnes, and the former Speaker for the House of Representatives, Dennis Hastert.

Barry welcomes your questions and comments, and can be reached by e-mail at [2bgross@comcast.net](mailto:2bgross@comcast.net) or through his website at [www.azsil.com](http://www.azsil.com).

