



Big Samoan Cigar Pen Kits - Assembly Instructions

A. Cutting Blanks:

Cut blanks length of the brass plus 1/8" extra on each side to allow for trimming to create 90 degree attachment point for other components. Starting with a solid blank free of checks or other defects will help ensure good results and enhance safety.

B. Drilling:

Drill the blanks using a drill press and wood clamp or other suitable device for securing the blank in an upright position to ensure stability throughout the drilling process. Ensure the blank is a true 90 degrees to the drill press table. Drill a 10mm hole completely through the blank.

C. Glue the Blanks:

Lightly rough up the exterior of the brass tube using fine sandpaper to ensure glue adhesion. Cut a thin slice of potato approximately 1/8 inch thick. Push the tube into the potato slice, creating a plug to keep out the glue. Using a good quality wood glue, polyurethane glue or Cyanoacrylate glue, coat the inside of the blank and the outside of the brass tube with your glue of choice.

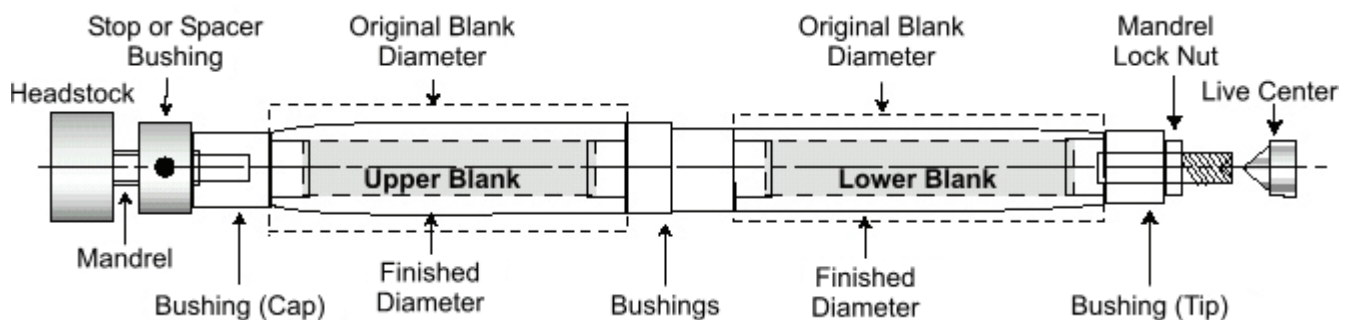
Slide the brass into the blank, potato end first. After inserted, use a small rod or expired pen refill to push out the potato cork and any excess glue. Clean up the ends and set the blank aside to dry for 24 hours. Using a fast drying Cyanoacrylate glue will eliminate the 24 hour drying period.

D. Dress the Ends:

Using a belt sander or barrel trimmer, trim the excess wood down to the brass, ensuring little or no brass is removed. This creates a 90 degree attachment point for other pen components.

E. Turning the Blanks:

Slide the bushing and the pen blanks onto the mandrel in the order required by the kit. Use the diagram below to help line up the blanks and bushings in the correct order. The two largest diameter bushings go in the center, the length of the corresponding bushing should match.



After aligning the bushings and blanks, thread the locking nut and hand tighten. Slide the tail stock over to the end of the mandrel, so that there is a snug fit (do not over tighten or the mandrel and live center could be damaged). Adjust the tail stock to remove any play and achieve the snug fit, then tighten the locking nut on the tail stock.

Turn the blank down to the approximate diameter of the bushings and then switch to sand paper to go the rest of the way.

F. Sanding:

Once the pen is turned to approximately 1/16" of the final diameter (more if wood is brittle or hard to turn), switch to sand paper and sand to the diameter of the bushings.

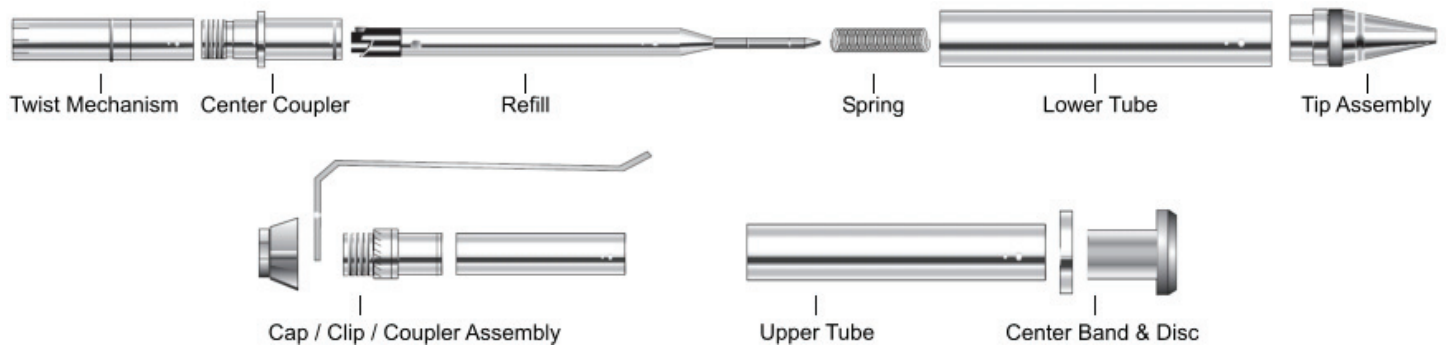
Woods subject to tearing out may require more than 1/16 inch. Start with 150 to 220 grit and sand out the gouge marks. Use finer grits, 240 to 320, and 400 to 600 to finish. Stop the lathe and sand with 400 to 600 grit in the direction of the grain to remove any sanding marks that remain.

G. Finishing:

Finish with your desired wax or friction polish. If using a brush on polyurethane, be sure not to weld the blank to the bushing.

H. Final Assembly:

Use caution and a clamp or vice with wooden jaws to avoid cracking the wooden parts or damaging gold plating.



1. Layout all parts as shown above and assemble tip; screw threaded black disc and tip onto tip coupler and press tip into small end of lower tube.
2. Press center coupling into opposite end of lower tube assembly (do not press directly on the threads, use a drilled support block to protect threads).
3. Insert refill and screw on twist mechanism.



4. Assemble and press Cap / Clip / Coupler Assembly into smaller end of the upper tube.
5. Slide disc over center band and press into opposite end of upper tube.
6. Take both upper and lower completed assemblies and push together by inserting the twist mechanism into the hole in the upper clip assembly ensuring grain matches if wood grain was initially matched.

Congratulations, you have completed the Big Samoan Cigar Pen!

If you have any problems, feel free to contact me at your convenience.