



Cigar Click Pen Kit Assembly Instructions

• REQUIRED ACCESSORIES

- 7mm Adjustable or Long Mandrel
- Live 60-degree Tailstock or Mandrel Saver
- Cigar (3 or 4-Piece) Bushing Set EKB-11A or DKB-PKBIG-BU
- 10mm Drill Bit
- Blank Size: Minimum $\frac{3}{4}$ " x $\frac{3}{4}$ " x 5"
- Two Part Epoxy Glue or Thick CA (cyanoacrylate)



- 10mm Barrel Trimmer or Disc Sander
- Sandpaper: Standard and Micro Mesh
- Pen Press or Clamp
- Eye, Ear & Dust Mask Protection

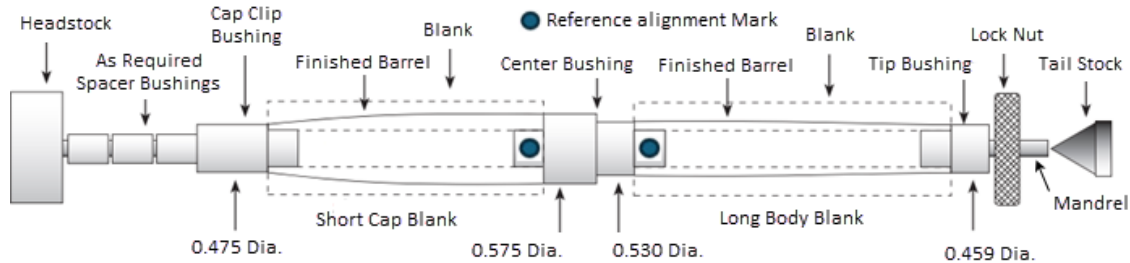
PREPARING THE BLANKS

- 1) To prepare the Blanks for drilling, draw a line lengthwise on the Blank with a permanent marker near the cut line. This provides a visual reference to maintain proper grain or pattern alignment. Cut two sections to the length of each Tube adding 1/4" for squaring off.
- 2) Mark the center of each Blanks end. This will determine the drilling location.
- 3) Drill Wood Blanks at 2,000 – 3,000 rpm and Larger bits or Resins at 250 – 500 rpm. Drill the holes through the center of the Blanks stopping an 1/8" short of the bit exiting each Blank. This will eliminate a Blank blow out.
- 4) Drill a centered 10mm hole lengthwise through the Cap and Body Tube Blanks.
Caution: Excessive pressure will cause the drill bit to wander and/or split the Blank. Slow the feed rate and back the bit out repeatedly for chip removal.
- 5) Trim away the small amount from the ends of each Blank to expose the hole.
- 6) Roughen the length of the outside Brass Tubes with 220 grit sandpaper to clean off the oxidation. This provides better glue adhesion. Wipe the brass residue off each Brass Tube. Trial fit each Tube in the Blanks before gluing.
- 7) To keep the glue from getting into the Tubes, plug both ends of the Tubes with a material of your choice. We recommend base plate wax. Push the Tube ends into a thin section of the material to seal each end. Wipe the residue left on the Brass Tube with acetone or alcohol on a clean dry towel.
- 8) Glue each Tube into the proper Blank. Put a liberal coating of glue on one Brass Tube. Working quickly, insert the Tube halfway into the Blank with a twisting motion to spread the glue evenly inside, then remove it from the Blank.
- 9) Put a little more glue on the Tube and insert it into the opposite end of the Blank. Align each Tube lengthwise just inside the Blanks. Continue with the other Tube.
- 10) Once the Brass Tubes are glued in place, set the Blanks aside for a day or so to give the glue time to set completely.
- 11) When glue is cured, use a hobby knife to remove the plugs and glue from the ends.
- 12) Use a Barrel Trimmer or a power disc sander to trim the excess material flush with the ends of the Brass Tubes. Trim the ends of the Blanks until you can just see the bright brass ends of the Tubes. The trimmed ends must be 90 degrees flush to the ends of the Brass Tubes. Do not trim past the end of the Tube.
- 13) The faces of the ends must be perpendicular to the Brass Tubes and parallel with each other. It is imperative that the length of the trimmed Blanks match the original length of the Brass Tubes and that the insides of the Brass Tubes are clean and free of any glue. Any excess glue left inside will split the Blanks during assembly.

TURNING THE BLANKS

- 14) Use a permanent marker, place a Reference alignment "MARK" ● inside the Tubes to align the Blanks grain or pattern at the original cut line.
- 15) Mount the Bushings and Blanks on the Mandrel, make sure that your reference "MARKS" ● meet at the Center Bushing. This will maintain the proper Blanks grain or pattern alignment on the Pen Mandrel as displayed below.
- 16) Thread the knurled Lock Nut on to Pen Mandrel and hand tighten it to hold all the components in place.

- 17) Slide the Tail Stock up snugly against the Mandrel Shaft inserting the Live Tail Stock Center Point into the Mandrels end Dimple. If using the Mandrel Saver insert the Mandrel into its hole. Lock the Tail Stock in place. (Do not overtighten, it could damage the Mandrel). Excessive pressure may also crack the Blanks.
- 18) Using sharp tools, turn the Blank down to a diameter slightly larger than the Bushings. As you approach the final size, be cautious as the Blank may be very thin. (Turn them straight or to a profile of your choice.)

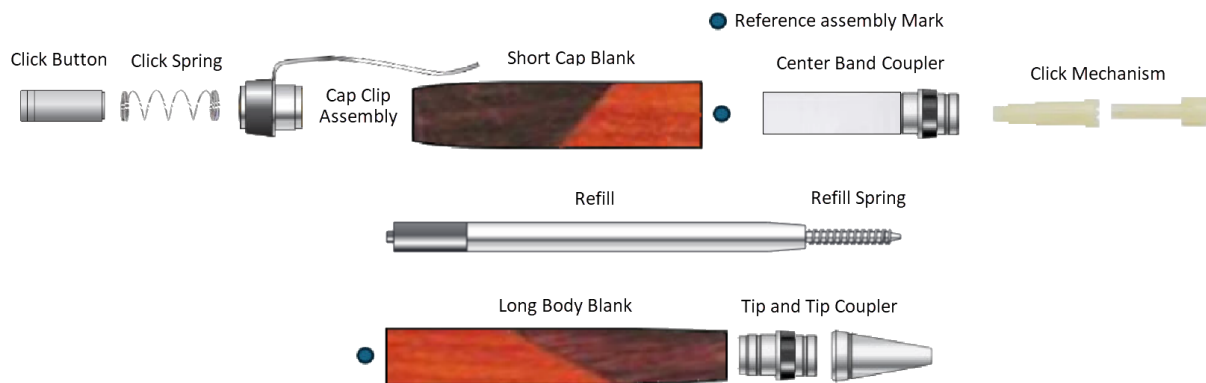


FINISHING THE BLANKS

- 19) Sand the Blanks flush with the Bushings gradually increasing the sandpaper grits.
- 20) Sand Wood Blanks from 120 to 600 grit paper. For Resin Blanks continue sanding with Micro Mesh from 1,500 to 12,000 grit. Woods and Resins require different methods to achieve better results.
- 21) Use a finish of your choice but be careful if using a CA or Polyurethane, etc. The Tubes may stick to the Bushings, and Mandrel. Use Non-stick Finishing Bushings to eliminate the sticking, as finish is applied.
- 22) Remove both Blanks from the Mandrel, lay them end to end and align the Blanks as you determined when assembled. If necessary, a light sanding of the ends on a sanding block will square the ends and improve the fit during assembly. Finish the ends of the Blanks with thin CA to seal the Blank.

CLICK CIGAR ASSEMBLING THE KIT

Layout the parts as shown below. Align the kit Blanks in the same orientation as determined on the Mandrel when pen Cap and Body will be assembled.



- 23) Press Cap Clip Assembly into the end of the Short Cap Blank, opposite the Reference alignment Mark.
- 24) Press the Center Band Coupler inserting white tube first into the end of the Cap Blank, at the Reference alignment Mark.
- 25) Insert the 2 piece Click Mechanism parts into the Center Band as shown.
- 26) Press the Tip Coupler into the end of the Long Body Blank, opposite the Reference alignment Mark.
- 27) Press both Cap and Body Assemblies together.
- 28) Remove the protective tip from the Refill point.
- 29) Insert the Refill with Spring attached into the Tip Coupler of the Long Body Blank.
- 30) Thread the Tip onto the Tip Coupler.
- 31) Place the Click Button Spring into the Click Button.
- 32) Thread the Click Button onto the exposed Cap Click Mechanism thread and tighten.
- 33) The pen is now ready to operate. Just click the button to extend or retract the refill.