

# Instructions for MaxWood Cigar Pen Turning Kit: MW-PKCG

## What You Need:

- 7 mm Mandrel: MW-5132 or MW-5133
- 3 Pc. Pen Bushing Set: MW-5018
- 10 mm Drill Bit
- 10 mm Barrel Trimmer: MW-BTK (optional)
- 2 Part Epoxy Glue or Insta-Cure (cyanoacrylate)



## Pen Assembly

In most cases the tip, clip / coupler parts will be furnished assembled. Ensure the assembly is screwed together tightly.

- Line up finished parts according to Diagram C

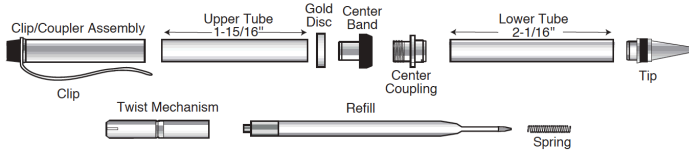


Diagram A: Parts Breakdown

## Preparing the Blanks

- Cut 3/4" square blank to the length of the brass tube (add 1/16" for squaring off).
- Drill a 10mm center hole, lengthwise through the blanks.
- Spread the glue over the tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Center the tube lengthwise inside the blank.
- When the glue dries, square the ends of the blank. Use a 10mm barrel trimmer or a belt / disc sander to trim the wood down flush to the end of the brass tube.

## Turning the Blanks

- Place the stop bushing, or 7mm spacer bushings, onto the mandrel hand tight. Next, place the cap bushing (longer) wide dia. in first, on the mandrel. Slide on the upper blank (shorter), then place the center bushing (wide dia. first) on the mandrel. Slide on the lower blank (longer) and follow with the tip bushing (shorter). Thread on the lock nut hand tight. Bring the tail stock snug with the mandrel. (Do not overtighten, it could damage the mandrel.)
- Slide the stop bushing toward the blank, adjusting to remove spaces. Then tighten the set screw, and tighten the lock nut.
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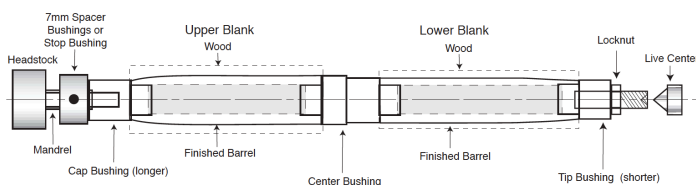


Diagram B: Turning the Blanks

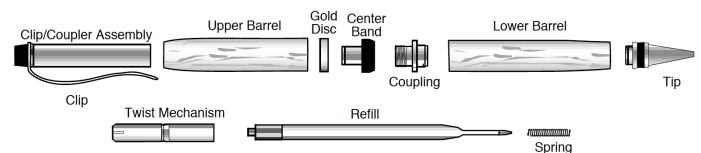


Diagram C: Pen Assembly

## Upper Barrel

- Press clip/coupler assembly into the tapered end of the barrel.
- Place gold disc over center band and press into opposite side.

## Lower Barrel

- Press tip assembly into the tapered (smaller) end of the barrel.
- Press the coupling, recessed end in first, into the opposite end.
- Place the refill with spring inside barrel.
- Screw the twist mechanism over the refill onto the coupler to the end.

## Final Assembly

- Engage both barrels. Slide the twist mechanism inside, until parts are connected.
- Operate the pen by twisting the two halves to extend or retract the refill.

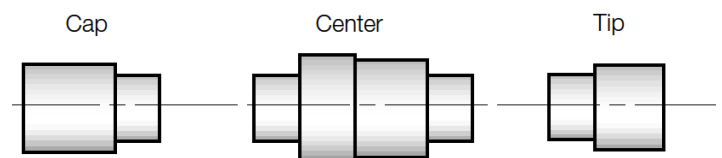


Diagram D: Bushing Set Breakdown