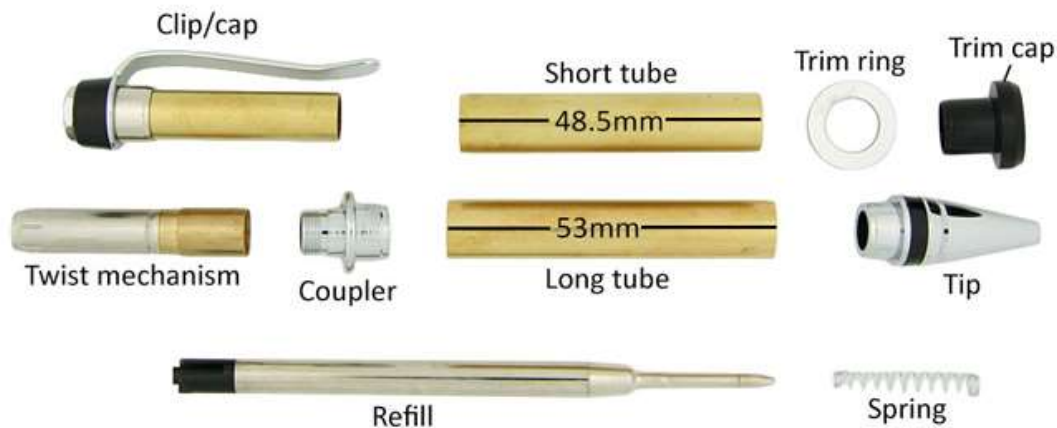




## Classic Cigar Pen Kit Fitting / Assembly Guide

The Prokraft Cigar pen kit is a precision kit with premium plated components, we recommend you read these instructions fully before making your pen

You will need: 10mm drill bit (for both tubes) set of cigar bushings (4parts code cigbsh)



1] Drill your blanks using the recommended drill size above, roughen the brass tubes with a little abrasive paper and glue each tube into the respective blank using your preferred glue

2] Once dry trim off any excess blank using your chosen method (sanding / pen barrel trimmer) ensuring each end is completely flat

3] Insert the bushings onto each prepared blank, there are 4 bushings. They are different sizes and must be in the correct order (see pic). If you cannot measure the bushings accurately a good tip is to get a flat surface and size them against each other and then place them in the correct order.



4] Mount each blank & bushing on the lathe using your preferred method – you can mount both parts together if you have a mandrel or individually if you prefer to turn between centres – our bushings are 4 individual to allow TBC turning.

5] Turn and finish your blanks as required.

6] To assemble the kit the parts can be carefully pressed together as indicated in the first picture. Ensure the refill is NOT in the pen when assembling the parts also make sure the mechanism is not pressed in place but screwed on after the front parts have been pressed in place.

The order to assemble & press the parts are:

- a] clip/cap – short tube – trim ring – trim cap
- b] coupler – long tube – tip/nib

7] Once these parts are pressed, the mechanism can be screwed on and the 2 halves pushed together

8] The refill and spring can be inserted by either unscrewing the heel/clip end from the tip/nib end or even easier is to unscrew the nib section. Ensure your refill is located fully into the mechanism using a gentle twisting motion.

Your pen is now complete and ready to use.