

ONE PIECE CIGAR PEN

A Tutorial by:
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<http://www.penturners.org>

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One Piece Cigar Pen Introduction - Ron Hossack

I've not really made that many pens, less than 25 and probably less than that. However, some pens just seem to jump out at me and shout "make me", the One-Piece Cigar is one of those.



I'm a big fan of wood. I just happen to like a full length pen and no center band for the most part.

The first pen I made was a slimline out of Spalted Blue Pine with no center band.

The first one piece cigar that I'm aware was first made by a fellow pen turner in our club, John Ferrell, who made the original using the tube from a Pendant Perfume Holder Kit.

I did my version by exchanging the Perfume tube with a Sierra tube.

This cigar works like a regular cigar except you extend the refill by twisting the nib instead of the barrel.

Items required

- Wood or Acrylic for your Blank (Finished length of 4.31)
- 10mm and 27/64" drill bits
- A Cigar Pen kit including tubes (Center Band and ring are not required)
- One Sierra/Wallstreet II pen tube (.410" Dia. x 2.21" long)
- Top Cigar Bushing (.475" Dia.)
- Nib Bushing from a Sierra/Wallstreet II (.474" Dia. resized to .459" Dia.)
- Masking Tape (Your choice of color)

I believe in the old saying "A picture is worth a 1000 words" as far as my instructions go also.



Preparation

Be sure to press the Nib Adapter and the Twist Holder into the tube before continuing with the next step.

Grind, mill or file off the ring of the center Twist Holder so that it is flush with the cigar tube diameter. One of the IAP members (holmgr) has made a nifty mandrel to make this part easier and neater.



<http://www.penturners.org/forum/showthread.php?t=51774>

I use my belt sander to get close and then finish up on the lathe with a file.

You'll know when it is done because the lower nib assembly will slide into the Sierra/Wallstreet II tube and rotate easily. The nib is shown on the lower image for orientation purposes only.



Blank

Measure the total length of all the parts of the cigar pen as they would be assembled (don't forget to add the dimensions for the center band into the length). The finished length should be about 4.31". I cut the blank on the long side at 4.50" for the Curly Maple pen. I like the look of this long wood.

This is a long blank and unless you have a drill bit long enough you will have to swap ends of the blank to finish drilling.

I personally use a smaller drill to start with and happened to have a 1/4" x 6" drill I used for a pilot hole.

My drill press has about a 3" throw so I usually do this on the lathe by putting the drill bit in the headstock and a dead center in the tail stock and drilling the blank that way by using channel locks to hold the wood. Once the drill is about half way I take out the dead center and use a scrap piece of wood as a 'push block' on the tail stock to finish drilling the blank.

I find it easier for a long blank to drill a pilot hole first because you won't need to clear the drill bit as much because it pushes it out the hole already drilled and any other drills after that you are more or less reaming to size.

Pick one end of the blank to be the clip end and drill a 10mm hole about 2.38" deep for the cigar tube.

The length of the Sierra/Wallstreet II tube is 2.21". Now using masking tape take a 27/64" drill bit and mark the depth on the bit to drill 2.38" deep. Drill the opposite end for the nib to the depth of the tape. This nib end of the blank is for gluing the Sierra/Wallstreet II tube.

Roughen up the Sierra/Wallstreet II tube (2.21") and the Cigar tube (1.91").

Before gluing the tubes, take a look at the improvised alignment mandrel which can be used for assembling the tubes to the blank and also for turning the blank.



<http://www.penturners.org/forum/showthread.php?t=53328>

Or if you prefer, plug the ends of both tubes with an apple, potato, play dough or dental wax. Apply your favorite glue to the tubes and press these tubes into your blank. My glue of choice at the present time is a polyurethane glue from Loctite called Sumo.

For bushings I was originally taking a cigar bushing and wrapping a piece of 1/8" masking tape to take up the difference between inside of the Sierra/Wallstreet II tube and inside of the cigar tube.

John Goodin (Johnnycnc) (<http://penturnersproducts.com>) was kind enough to make a special bushing with the cigar nib Dia. of .459" and the .381" Dia. to mount the Sierra/Wallstreet II tube. You could also take an old Sierra/Wallstreet II bushing and turn it to this .459" Dia.

After the tubes have set, remember to remove the material used to plug the tubes and thoroughly clean out the excess. Square up the ends of the blank to a total length of 4.31". Turn the blank to your preferred shape.

Assemble the Pen

Assemble the clip end on the blank. Screw the twist mechanism to the lower tube assembly.

Finally, just slide the nib assembly into the blank from its bottom.



Not too difficult was it? Hope you have fun with this as much as I did!

Good Luck,

Ron Hossack A.K.A "rhossack"

Samples

Curly Maple treated with Chromium Trioxide which is used by Black Powder shooters to get the warm brown color on the wood.



This is a piece of Mountain Mahogany, probably the hardest wood I've ever turned and the most colorful.



This is Cocobolo finished with CA and the kit is 'Gun Metal' finish.



Curly Pink Ivory dressed in Chrome.

