

Cigar Longwood

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The following instructions are for how I make my Longwood Cigar Pen. Longwood pens can be made from just about any twist ballpoint pen. The only kit part that is not used is the Center Band and any associated decorative rings.

This Longwood Cigar Barrel, excluding the Center Band and Decorative Ring, should be the same length as a normally completed Cigar pen with the length of the Upper and Lower barrels and the Center Band at a minimum of 4-5/16”.

It is critical to ensure the hole is straight by drilling all the way through the blank from one end. The drill bit has to be long enough to go all the way through the blank.

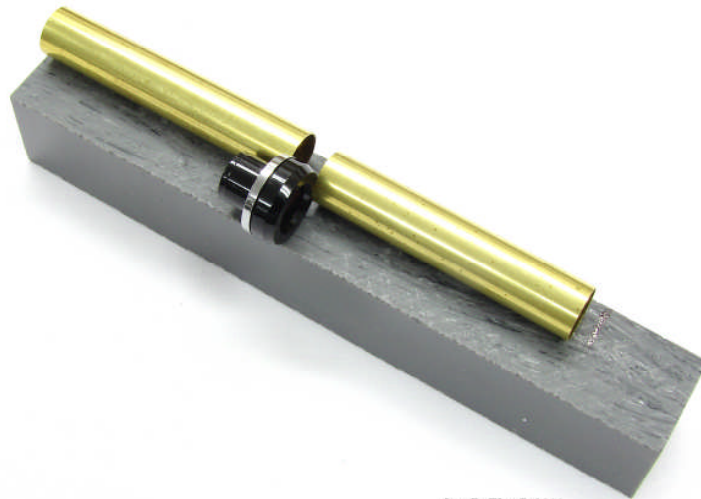
Materials Required:

- Cigar Ballpoint Pen Kit
- Some extra replacement Cigar tubes
- Cigar Finial and Nib Bushings
- 25/64ths Drill Bit
- Finishing Materials



Preparing the Pen Barrel:

1. Using the Shorter (Upper) brass tube, Center Band with Decorative Ring and the Longer (Lower) tube for a total length of 4-5/16". Mark and cut a minimum size 3/4" square pen blank to a length of 4-1/2" which will allow room to mill the ends square with the brass tubes.



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Mark the 3/4" Blank to Cut at 4-1/2"

2. Drill the blank all the way through the center from one end only with a 25/64ths drill bit



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Drilling the Blank Through From One End

3. Check that the hole is straight by ensuring a tube will fall all the way through the drilled blank hole
4. Place 2 Long tubes into the blank hole and mill both ends of the blank square to end up with the blank length at a minimum of 4-5/16"



Blank Ends Squared For Total Length of 4-5/16"

5. Remove both tubes from the blank hole and knock the 4 corners off the blanks with the band saw



Remove The 4 Corners Off The Blank

6. Take two Lower (Long) tubes and place a Cap bushing on one end of a tube and place a Nib bushing on the end of the other Lower (Long) tube.



Long Tubes with Cap and Nib Bushings

7. Slide the one tube with the bushing into each end of the blank



Tubes With Bushing Slide Into the Blank

8. Install the blank with the inserted tubes and bushings between centers on the lathe



Blank Installed Between Centers c/w Bushings

9. Turn the blank between centers a little proud of the bushings.



Blank Turned Down and Shaped

10. Sand the blank to 400x, buff with Super Fine Steel Wool and polish with Huts Ultra Gloss.



Finished Acrylic Cigar Barrel

11. Remove the blank from the lathe, remove the two Lower (Long) tubes from the blank. Glue in a Upper (Short) tube flush with the Cap end of the blank.



Glue In Upper (Short) Tube

Preparing the Nib Assembly:

1. Press the Twist Holder into one end of the Lower (Long) brass tube.



Twist Holder Pressed Into Lower (Long) Brass Tube

2. Machine off the Twist Holder Flange flush with the outside of the brass tube



Twist Holder Flange Removed

3. Assemble the Nib Adapter, Black Decorative Ring, and Nib and press into the other end of the Lower (Long) tube



Nib Installed on Lower (Long) Tube

4. Lay out the Parker refill and Twist Mechanism with assembled Twist Holder and Nib tube.



Nib Assembly, Twist Mechanism and Parker Refill

5. Install Parker refill into the Nib tube, screw the Twist Mechanism onto the Twist Holder and check operation



Assembled Nib Assembly

6. Assemble the Finial and Clip and screw onto the Clip Bushing



Assembled Finial and Clip Onto Clip Bushing

7. Press the Finial assembly into the cap tube



Finial with Clip Pressed Into Barrel Tube

8. Push the completed Nib Assembly through the barrel nib end and check the double twist action operation of the refill



Nib Assembly Ready to Install Into Barrel

9. Twisting the nib clock-wise or counter clock-wise retracts the refill tip.
10. Unscrew the nib counter clock-wise or pull out the nib assembly to access the refill.

Completed Longwood Cigar Ballpoint



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