

Xiamen Rizheng Industry Co.,Ltd

Cigar Humidor Kits Assembly Instructions

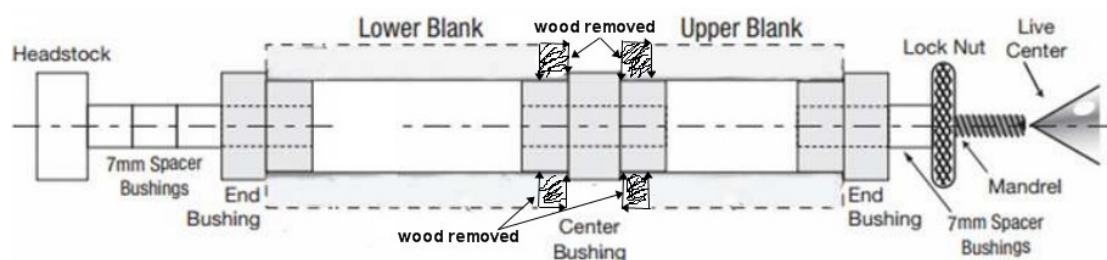
Required Accessories

- 7mm pen mandrel
- 3-piece Bushing Set RZ-PK204#-BU
- 55/64" drill bit
- pen blank 1 1/8" x 1 1/8" minimum
- Live Tailstock Center
- Glue (Thick CA or Epoxy)



Preparing the Blank

- Cut the material blanks longer, approximately 3/4", than the kit tubes.
CAUTION: These are very large blanks with a very large holes. We recommend cutting the blanks 3/4" longer than the tubes in case of blow out. Be sure and place a waste block under the blank to eliminate or mitigate blowout.
- Mark each blank to the length of the tube plus about 1/8". Drill pilot hole in each blank with a smaller bit (Smaller than the 55/64" Bit). Drill Pilot hole just past the mark that you made. Then drill with the 55/64" hole again just to the mark that you made.
- After you drill the holes then cut off the blank at the 1/8" longer mark you made. All of this is so you don't run the risk of splitting the blank. After you drill the holes then cut off the blank at the 1/8" longer mark you made.
- Rough up the brass tubes with sandpaper. (100-150 grit)
- Glue in tube using CA or Epoxy. Be sure and twist tube as you are inserting it.
- Face off both ends just to the brass tube. Be sure and do not take off any tube length. This process is done to make sure tube and blank are at a true 90 degree angle so that pieces press in flush. With this kit the easiest way to do this is on a belt sander.

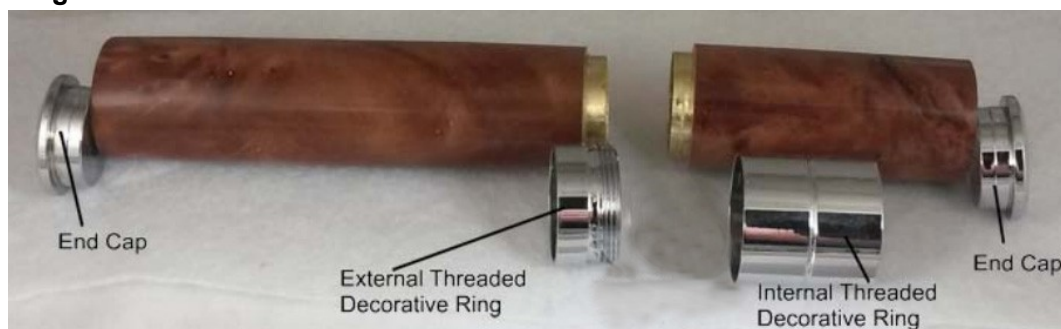


Turning the Blank

- Mount the bushings and blank according the diagram above.

- Thread on the knurled nut and hand tighten to hold all components in place.
- Slide the tailstock up snugly against the mandrel shaft inserting the live center point into the mandrel dimple, lock in place.
- Hand tighten the quill adjustment to firm up the mandrel. (DO NOT overtighten, it could damage the mandrel.
- Using sharp tools, turn the blank down close to the bushing diameter. Turn the barrel (straight or to a profile of your choice)
- Sand the blank down to be flush with the bushings gradually increasing the sandpaper grits.
- Finish the barrel with your choice of polish. Allow sufficient time for the polish to cure.

Diagram A



Assembly

- Arrange parts according to Diagram A.
- Press one of the end caps, it doesn't matter which one, into the end of the long finished blank without the tenon.
- Press the tube external threaded decorative end onto the end of the long finished blank with the tenon. Lay this assembly aside for a moment.
- Press the other end cap into the end of the short finished blank without the tenon.
- Press the internally threaded decorative ring onto the other end of the short finished blank with the tenon on it.
- Screw on the top and rest assured it will be fresh as a daisy when you are ready to enjoy it.