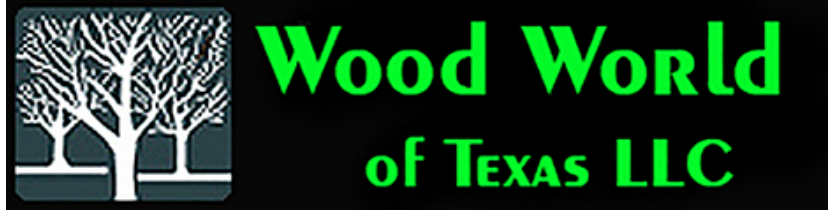


Cigar Humidor #10081



Needed:

Mandrel-A

Bushings - #10080

Drill - 55/64"

Wood Size - 1 1/8" x 1 1/8" minimum We prefer to use 1.5x1.5 or even 8/4 material

Material Preparation

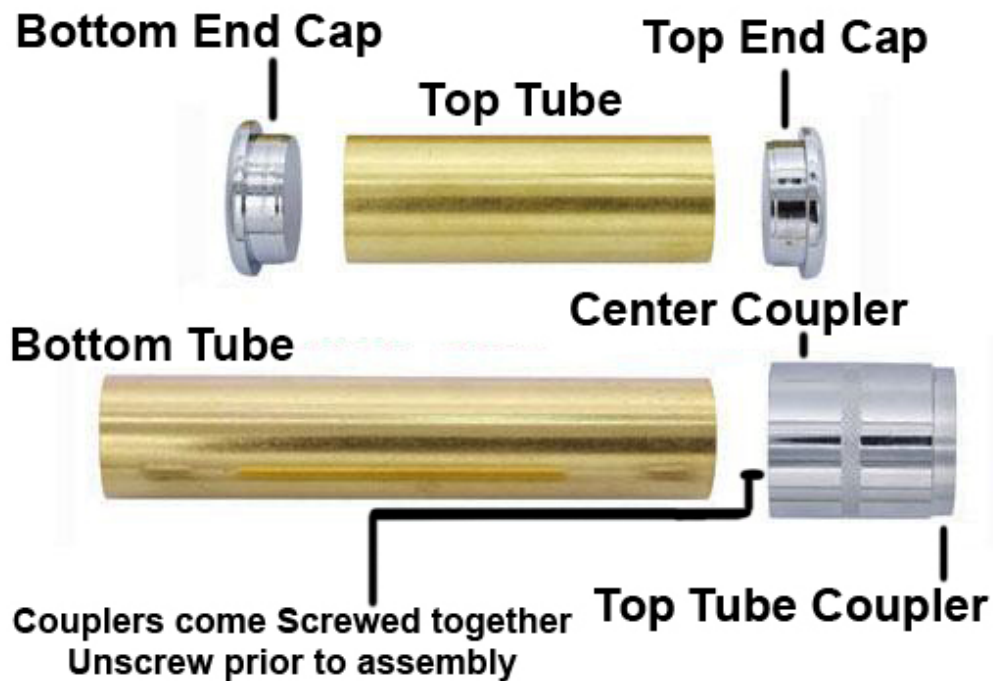
- Cut the material blanks longer, approximately 3/4", than the kit tubes.

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.

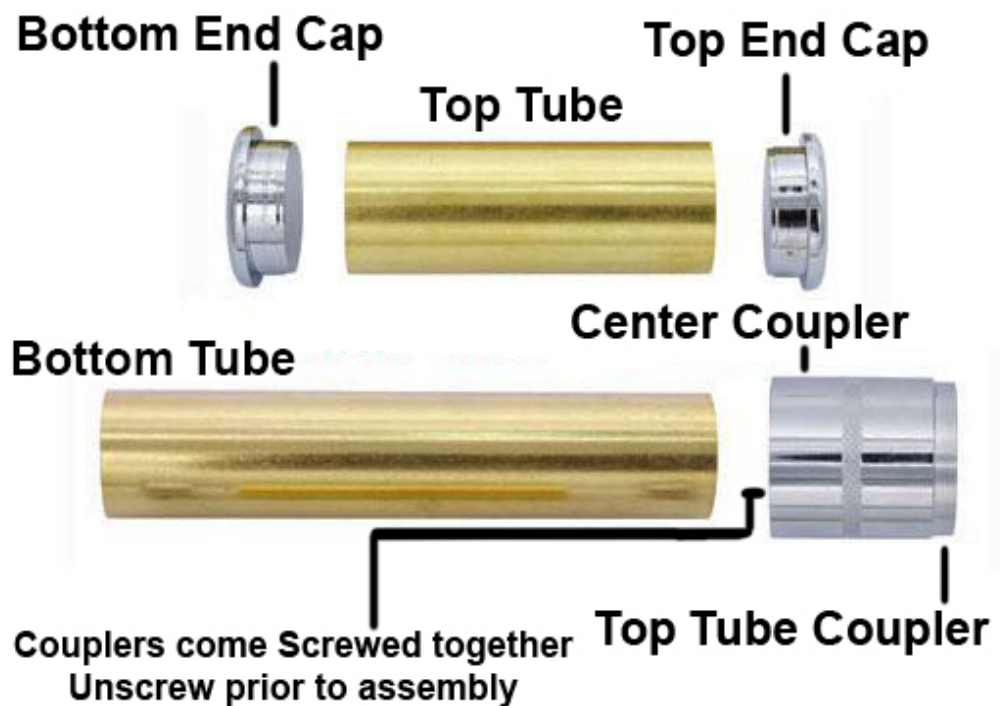
Turning the Blanks:



Bushings

- Assemble the blanks on the mandrel using #10080 bushings. Depending on mandrel length you may have to turn the top and bottom blanks independently. The shorter blank will be the cap of your kit and the longer tube the bottom. The Bushing are all the same diameter. If turning the top and bottom at the same time you will use the bushing with a step down on each end as the center bushing otherwise you can use the single step down bushings on each tube. Tighten the tail-stock before tightening the blanks on the mandrel. This will center the mandrel first. Then tighten the knurled nut on the mandrel.
- Turn the blanks to the desired contour making sure that the area next to the bushing is turned to the size of the adjacent bushing.
- Mark each blank on one end up 1/8" from the end. This will be your tenon. The couplers will press onto the tube here. Use a parting tool and part up from the bottom of the blank to your 1/8" line. Remove the blank material down to the tube. Make sure the shoulder are 90 degrees to the tube. Once complete you should have 1/8" of brass tubing showing beyond your turned blank.
- After turning the blank, sand the surface to desired grit.
- Apply the finish of your choice and polish.
- Remove the blanks from the mandrel and assemble.

Assembling the Kit



A common error resulting in a non-functional or damaged kit is the misalignment of the parts when pressing them in place. The use of a good pen press or small arbor press is recommended. When pressing in the various parts, by any means, **BE SURE** that the parts are straight and in line with the blanks. If the part is cocked or otherwise misaligned, at the very least, a poor fitting kit will result. At the worst, you may have a kit that is not usable. Exercise caution here!

Occasionally, you will have parts that are a little loose fitting. This can be corrected by using a **SMALL** dot of CA or Epoxy applied to the part before pressing them home.

1. Press one of the end caps, it doesn't matter which one as they are both the same size. Be sure and press an end cap into the non tenoned end of each of the blanks.
2. Unscrew the center coupler.
3. The longer piece with female threads and knurling is for the longer tube (bottom). The smaller diameter male threaded piece is for the (shorter) top (cap) blank.
4. Press the appropriate coupler piece onto the correct blank at the tenon end. The coupler is a press fit onto the tube and is stopped in rearward movement by the shoulder of the tenon if cut correctly.
5. Now grab your favorite Stick and place it into the Humidor and screw on the top and head to your favorite smoking spot. You can now be confident that it will not get crushed and it will be fresh when you are ready to enjoy it.

