

Groover and lead layer linked in a single process - Steps 4 to 6

5. Writing cores -- made from a mixture of graphite and clay -- are placed into the grooves. Other pencils may use wax based cores for coloring pencils as well as many other formulations used to make cosmetic pencils.

6. A second grooved slat is glued onto the first -- making a "sandwich." This is done with a machine called a "lead layer" where the sandwiches are then "clamped" to hold them together tightly while the glue dries.

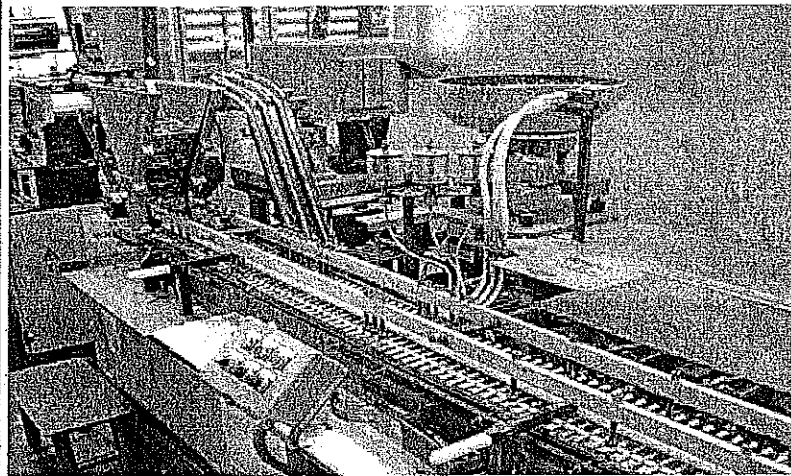
7. Once the glue dries the sandwiches are transferred to equipment called a "Shaper" and are first "trimmed" to assure that the sandwich is square and that all the pencils will be the proper length, then the sandwich is machined into pencil shapes such as hexagonal, round or triangular.

8. The individual pencils cut from the sandwich are ready for further processing. Any defective pencils such as uncentered leads or chipped wood are discarded at this point.

9. Next each pencil is painted in a machine receiving from 4 to 10 coats of lacquer depending on the desired quality of the finish and the color of lacquer. A recess is cut to accept the ferrule.

After painting some pencils are wrapped with decorative film or foils with fancy designs although most pencils are imprinted with the brand name by stamping the foil into the surface of the pencil.

10. On a "tipping" machine an eraser and a ferrule (the metal ring that holds the eraser to the pencil) are crimped into place on each pencil.



Eraser Tipping Machine

Following tipping pencils are packaged in many different ways for shipment to distributors, wholesalers or direct to retail stores where you buy your pencils.

To see more about how pencils are produced you can [watch the Let's Make a Pencil Video](#).

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