

Penn State Industries

Abalone Sheet Instructions

Instructions for WXABL XX A,B,C,D

Genuine Abalone Shells are carefully sliced by master craftsman to a thickness of ½ mm. The thin strips are dyed and laminated to a 3M double sided film with a very strong adhesive.

Please Note: These strips are thin and delicate and must be handled with the utmost care. Once the strip is applied to a pen tube, it cannot be removed or it will crack. Be very slow and careful when applying the sheet to your tube because once adhered, it is adhered! Trying to remove it will damage the sheet. Once applied, the sheet is designed to be cast into a resin mold, then turned and polished. Each Abalone sheet is specifically cut to wrap around a specific pen tube and then matched to the pen kit of your choice.



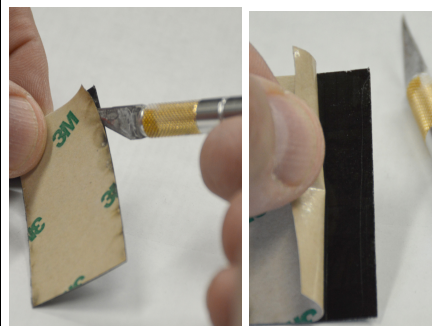
Step 1 - Rough up pen tube(s) if not already completed.



Step 2 – Use a marker and color the pen tube black. This is done to minimize any gaps that may be present after the sheet is wrapped around the tube.

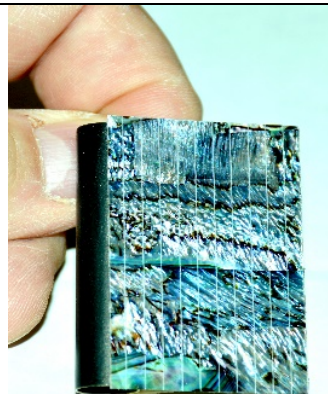


Step 3 – Cut the Abalone sheet slightly longer than the pen tube that you will be casting.



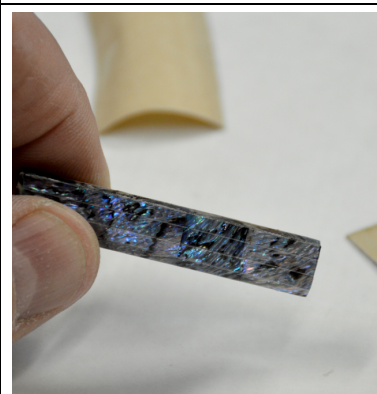
Step 4 – Carefully use a craft knife and start to peel back a corner of the 3M backing. Continue peeling the 3M backing as shown being careful NOT to touch the

sheet.



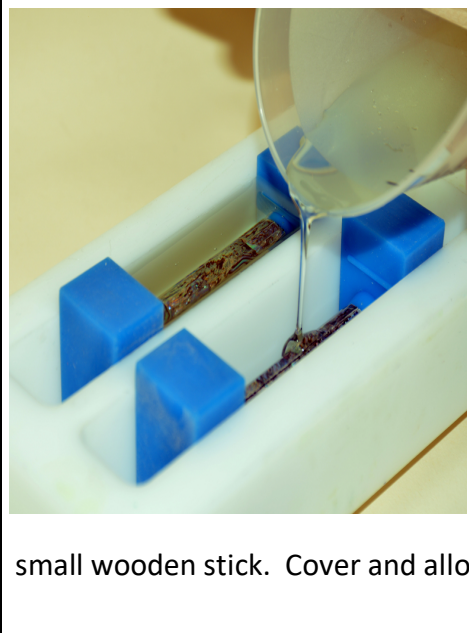
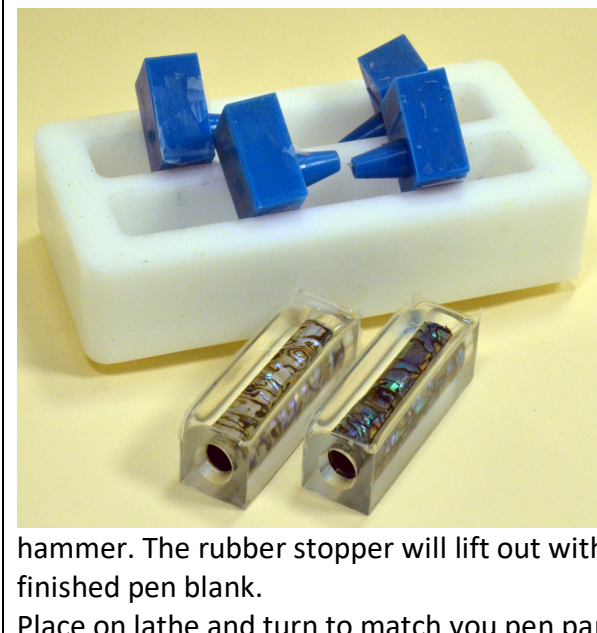


Step 5 – Apply the abalone sheet to the painted tube making sure it is perpendicular to the sheet.

Caution: make sure you place it on the tube straight the first time. It does not peel off!



Step 6 – Once the sheet is adhered to the tube, remove the 3M backing and continue to wrap the sheet around the tube.

	<p>Step 7 -After wrapping the sheet around the pen tube, trim off any excess from the top and bottom of the pen tube.</p>		<p>Step 8 -Use the CASTEV system to and mix the appropriate amount of resin according to the directions.</p>
	<p>Step 9 - After mixing approximately 2 ounces of resin with 12 drops of hardener, slowly and carefully pour the resin over the pen blanks. If air bubbles appear, remove them with paperclip or small wooden stick. Cover and allow to dry.</p>		<p>Step 10 - When the resin has cured, turn mold over and tap with a plastic hammer. The rubber stopper will lift out with your finished pen blank. Place on lathe and turn to match you pen parts.</p>

Each Abalone Sheet is made for specific pen tubes – a 3/8” sheet will only fit a pen kit that uses a 3/8” pen tube.

<p>3/8” Sheet is made for a 3/8” diameter pen tube:</p> <p>Sheet Size - 1 3/16" wide by 5 3/8" in length</p>	<p>10 mm sheet is made for a 10 mm pen tube:</p> <p>Sheet Size – 1 29/128" wide by 5 3/8" in length</p>
<p>10.5 mm sheet is made for a 10.5 mm pen tube:</p> <p>Sheet Size – 1 19/64"" wide by 5 3/8" in length</p>	<p>12.5 mm sheet is made for a 12.5 mm pen tube:</p> <p>Sheet Size – 1 69/128"" wide by 5 3/8" in length</p>