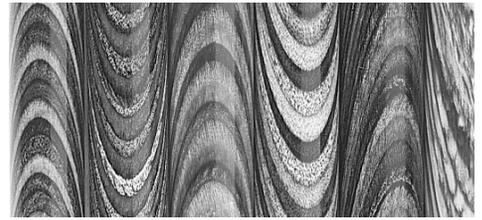


Diagonal Dymondwood Project Blanks

Item #PK-XDA through #PK-XDG



Drilling and Turning: *The Wood*

These dymondwood blanks you are about to turn are a high-tech, natural wood/plastic composite, which is produced by impregnating and laminating 1/16" thick selected hardwood veneers. Sheets are vacuum impregnated with special dyes and plastic resins. Then they are pressed under tremendous heat and pressure to produce this wood. To create the special effects, the wood block is then cut diagonally to make these unique pen blanks. Blanks are cut to: 5/8" x 5/8" x 4-5/8" long.

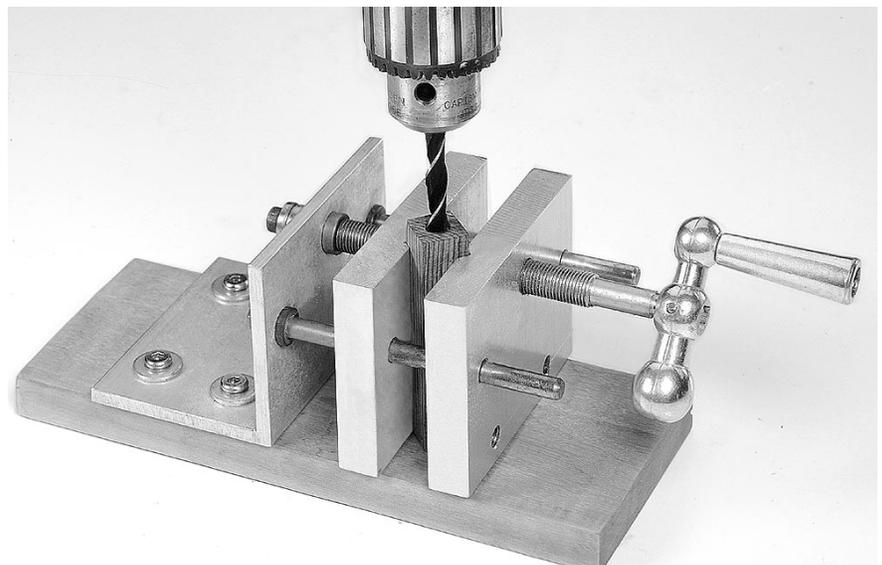
Note: *Special attention must be taken while working with dymondwood. Avoid overheating the wood when drilling, it may cause internal cracking that you may not discover until you finish turning it.*

Hints for Drilling

Due to the hardness and plastic/resin composition of this material we recommend using high quality HSS bits such as precision or carbide tipped brad point drill bits. These bits will keep the blank from wandering and will last longer. Run the drill press at the manufacturer's recommended speed. Drill down with short bursts of pressure. Long bursts will overheat the bit and may split the wood. Clean the waste off the bit often, and cool the bit with a damp cloth when overheated.

Using a Drill Jig

For an accurate bore, and to minimize wandering of the blank, we recommend using PSI drilling center vise #**DRILL-CENT**. It will save you time, material, and frustration. Insert your blank in the holding notch and secure the base with a C-clamp to the drill press table. Use a scrap of wood under the blank to be drilled for support. This will relieve the pressure caused by the bit at the bottom of the blank. To avoid splitting the wood, start with light pressure when the drill first meets the wood. Ease up on the pressure when you are close to hitting the bottom of the blank. If the wood cracks, use super glue to repair it, then re-drill the blank.



Turning the Wood

Dymondwood is hard, and will build up heat quickly, thus dulling your tools. Always keep your blades sharp while cutting. When turning is complete, use sanding grits in stages of 240, 320, 400 and over. Dymondwood is veneer with resin impregnation, therefore it is stable and requires no further sealing of the wood.

Polishing

We recommend using Hut™ perfect pen polish #**PK-PF1** and #**PK-PF2**, or PSI Shellawax cream friction polish #**PKSWAX** for finishing the project. These are some of the best polishing compounds you can find.

