

Penturning - Casting Kit Instructions

Make sure you have adequate ventilation! Resin and Hardener are FLAMMABLE! Keep away from heat and fire!

List of Materials Included:

32oz. High Performance Resin, Hardener, 5 pair latex gloves, 5 stir sticks, 8 oz. measuring cup

1. Cover a flat and level work area with newspaper.
2. Get the tubes from your pen kit and start to create your particular pen that you want in the design. Such as greeting paper, wall paper, cigar labels, beer caps, stamps, items from the scrap book section of a craft store etc. The items you use for wrapping the tubes must lie flat on the tube and look nearly seamless. Any seam that is noticeable now will be magnified by the finished casting!
3. Add 1 ounce of High Performance Resin into the measuring cup. Add 6 drops of hardener if it is 60-69 degrees or 5 drops of hardener if it is 70-75 degrees. Mix with stir stick VERY SLOWLY, trying not to introduce bubbles into the mix. Let mixture stand for 10 minutes allowing the bubbles to rise to the top of the cup.
4. As soon as mixed well with stirrer, remove bubbles from mix and wipe on newspaper. Working time is about 20 minutes, so this part of the cast must be completed and poured within that time or the resin will start to harden and be ruined.
5. Pour mix slowly into mold making sure you do not overflow the resin out of the mold. Discard the rest of the mix, saving the measuring cup. Remove any bubbles that appear in the tube by using a paperclip. You will have to watch the mix for about 15 minutes, as additional bubbles may appear and need to be removed. Keep dust and dirt from getting into the mold or they will become part of your pen! Let resin cure for 24 hours.
6. Congratulations! You now have pen blanks ready for turning!
7. Square the ends of the pen blanks using a squaring jig. If you use a barrel trimmer make sure it is sharp. A carbide trimmer is not recommended because it is too aggressive.
8. Place your blanks on a mandrel with the appropriate bushings and start to round over the edges of the pen blank with a roughing gouge. Turn with a very light pressure and very sharp tools!
9. Continue to reduce the blank until it gets to the bushings.
10. Lightly sand with 320 grit to remove any tool marks and then use the acrylic finishing pads to wet sand the pen blank. Use a scratch remover and then buff it with the Acrylic Pen Buffing System.
11. Assemble Pen Kit with your newly created pen blanks.
12. Enjoy your new pen!

