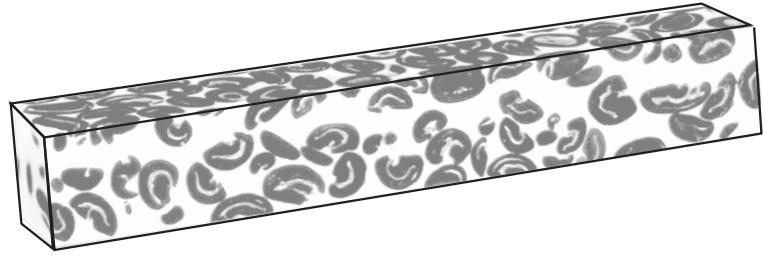


# COFFEE BEAN BLANKS

## MATERIALS REQUIRED:

- Thin CA (crack filling) glue - #PKGLUE51
- CA Accelerator (optional) - #PKGLUE9
- Universal Pen Blank Squaring Jig (optional) #PKSQUARE
- Plastic Finishing Pads - #PKFINKIT
- Options for gluing to tube:
- Mid-Cure Epoxy - #PKGLUE2 or pen makers' CA - #PKGLUE61



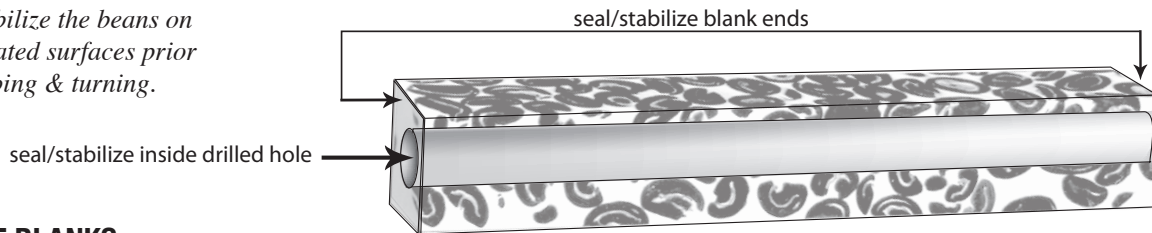
In order to preserve the aroma of our Coffee and Cream pen blanks the beans used have not been treated for stability; therefore they may tend to break and/or dislodge from the cast acrylic when being drilled or turned. The most common areas are at the ends of the blank and along the tube. Consequently, we found the following steps yield the best results. These steps will secure the beans and avoid dislodging during turning. It is better to avoid using a project that requires you to turn your blanks down to a very thin wall thickness.

## PREPARATION:

Carefully cut your blanks to size and square them prior to drilling. Avoid using a barrel trimmer. Sand using the Universal squaring Jig #PKSQUARE, if available.

Spread thin CA on both ends over any exposed beans, allow to penetrate for at least a minute then allow to dry or spray with CA accelerator. Carefully drill the blanks without disturbing any exposed beans.

*Seal/Stabilize the beans on the indicated surfaces prior to tubing & turning.*



## GLUING THE BLANKS:

There are 2 methods for gluing the tubes into the coffee bean blanks - without using these techniques the beans may disengage from the tubes while turning them down to size.

Method 1: Use a cotton swab to spread thin CA inside the drilled hole and completely cover the inside of the blank (do not use too much glue or there may not be enough room for the tube). Allow a minute to penetrate then spray with CA accelerator. Put the tube dry into the hole to insure that it slides completely through - file down any rough parts that may inhibit the tube from sliding in easily. Use medium viscosity CA or Pen Maker's CA with an insertion tool to glue the tube into the blank. Use CA accelerator to speed drying (optional).

Method 2: Use a generous amount of Mid-Cure Epoxy on the tubes prior to inserting - enough epoxy to assure the inside of the blank is completely covered with glue. Insert into the blank turning and twisting to insure complete inside coverage. Allow a few hours to completely dry.

## TURNING:

Sand the squared edges of the blank prior to turning so they no longer have sharp edges. Use a very sharp tool and take light cuts. In the event a bean pops out - press some fine ground coffee along with thin CA to fill any voids.

## FINISHING:

Sand with graduated grits to finish. The exposed beans should emit a familiar coffee aroma after sanding. Use the Plastic Finishing Pads for final finishing - DO NOT USE these pads wet as it may dissolve some of the surface of the beans. Do not use waxes, lacquers and other polishes since they will inhibit the coffee aroma from emitting from the pen.