



WORKING WITH INLACE ACRYLESTER™

The results you get from a finished Inlace Acrylester™ blank far exceed any effort it requires to turn it.

Step 1: Drilling the Blanks

Drilling Inlace Acrylester™ blanks is easily accomplished if a few simple steps are followed. Start by cutting the blank allowing a little extra length on each piece. Often when drilling plastic, the drill bit can catch, cracking the blank as it exits. Avoid this by not drilling through the bottom of the blank, then cut off the excess at the end. Be sure to clear the flute every 1/8" to 1/4" as you drill.

Step 2: Gluing the Tubes into the Blanks

Sand the outside of your brass tubes. Sanding cleans the tubes and provides the glue a better grip. CA glue and Epoxy are the most popular choices. When turning plastics in general, some blanks are more opaque than others. You may want to paint your tubes to keep the brass tubes from showing through, thus giving an unwanted brassy glow on parts of your project that are turned closer to the tube.

Use a small amount of the thick CA glue (GTHICK2) on the outside of the tube or the inside of the hole. Use enough glue to coat the entire surface. If you use too much glue, it will get inside the tube. Glue inside the tube needs to be removed and is most easily done before the glue sets up. After the glue sets up, use a box knife, Dremel tool, or similar device to remove it. The fit of a pressed-in part with the tube is very tight, and any excess glue is likely to cause cracking during final assembly.

Step 3: Turning the Blanks

Aggressive cuts and Inlace don't mix. The best way to turn Inlace Acrylester™ is to use a fingernail bowl gouge or a skew in proper form to give you a "shear" cut. Using a shear cut, you will slice the material from the blank instead of scraping it off. Cutting will cause less impact to the blank and require less sanding. (** We recommend only using carbide tools with Negative Rake Cutters to turn Inlace.) If you don't have proper form with a skew or don't have a fingernail gouge, a standard spindle gouge will work. However, be certain to keep your tools sharp and use light cuts, or chipping may occur. As you reach final dimension, you will want to slow up a little and start gently working out any remaining chips or grooves. If you have chipping that is too deep, you may use a drop of thick CA glue to fill the chip seamlessly. You will then want to turn the CA glue back to flush and finish polishing as usual.

Step 4: Polishing

Sand to 400- or 600-grit using WoodTurningz' five-roll sandpaper kit (SP5ROLL), then switch to Micro-mesh (MMESH) or the plastic pen finishing kit (PKFINKIT2X) and polish through all the grades. You may wish to stop the lathe once in a while and use your sandpaper or Micro-mesh (depending at what step you are) to sand the length of the blank to remove rotational scratches in the blank. If you get scratches that don't come out, drop back a step or two in the process and start there. Depending on your results, you may wish to use a plastic polish or buff to further shine the barrels. No friction polishes or finishes are necessary.

Note: *Be careful not to overheat the blank by setting your lathe on a high speed. This can cause the blank to melt.*

WORKING WITH MONEY BLANKS

Instructions working with Inlace Acrylester™ apply when working with money blanks with the following additions:

Special Step 2: Gluing the Tubes into the Blanks

The money blanks are made from actual U.S. currency, shredded and mixed for a random look with a clear Inlace resin. Small areas of the clear resin may allow the tube to show through after turning. You may wish to paint your tubes to keep the brass from showing through on parts of your project that are turned closer to the tube. First, sand your tubes with fine-grit sandpaper before you paint them for better holding power. WoodTurningz recommends either a black or green painted tube using paint that will be compatible with your glue, such as Rust-Oleum® Enamel (most acrylic or water-based paints will dissolve with CA glue, so test before you glue your blanks). CA glue or Epoxy are the most popular glue choices and will dry clear for the painted tubes. WoodTurningz recommends using the thick gel CA glue (GTHICK2).

Special Step 4: Polishing with CA Glue

If you prefer a completely smooth finish, you may wish to apply a CA glue finish. If you need CA glue finishing instructions, please contact WoodTurningz, and we will provide these for you.

Special Note for Filling Small Pits:

Due to the nature of casting complex objects in resin, you may occasionally notice a pit or a small bubble that was not eliminated in the casting process. Unfortunately, this is unavoidable but is easily corrected once the piece is turned down to its rough shape. If you see a pit, simply use a wet towel to remove any sanding debris and fill the pit with a small amount of thick CA glue. You will then want to turn the CA glue back to flush and finish polishing as usual.

WORKING WITH WOODTURNINGZ' GENESIS™ BLANKS

Instructions working with Inlace Acrylester™ apply when working with Genesis blanks with the following additions:

Special Step 2: Gluing the Tubes into the Blanks

Genesis blanks are made using an organic mesh which adds to the opaqueness of the overall blank and makes seeing the brass tubes a thing of the past. For gluing in your tubes, WoodTurningz recommends using a thick gel CA glue (GTHICK2); however, Epoxy glues will also work.

Special Step 4: Polishing with CA Glue

If you prefer a completely smooth finish, you may wish to apply a CA glue finish. If you need CA glue finishing instructions, please contact WoodTurningz, and we will provide these for you.

Special Note for Pen Blank Texture:

Upon completion, you will notice that the organic mesh can be felt protruding slightly from the surface. This is unavoidable and will happen any time you are using mixed media. While many people like the unique tactile feel that is created by the mesh, if you find the texture objectionable, the blank can be covered with a CA finish and then polished. If you need CA glue finishing instructions, please contact WoodTurningz, and we will provide these for you.

WORKING WITH COFFEE BLANKS

Instructions working with Inlace Acrylester™ apply when working with coffee blanks with the following additions:

Special Step 3: Turning the Blanks

Aggressive cuts and Inlace resins don't mix, **especially** for the coffee blanks. The coffee beans are very weak and brittle. You can actually break a blank in half with your bare hands, so you have to take extreme care when turning them. The skills of an experienced pen turner will come in handy when turning coffee blanks.

Special Step 4: Polishing

You **must** finish your coffee pen with a CA glue finish. This will seal the coffee beans and provide a hard surface for protection. If you need CA glue finishing instructions, please contact WoodTurningz, and we will provide these for you.

Special Note for Filling Small Pits:

Due to the nature of casting complex objects in resin, you may occasionally notice a pit or a small bubble that was not eliminated in the casting process. Unfortunately, this is unavoidable but is easily corrected once the piece is turned down to its rough shape. If you see a pit, simply use a wet towel to remove any sanding debris and fill the pit with a small amount of thick CA glue. You will then want to turn the CA glue back to flush and finish polishing as usual.