

SHELL PEN BLANK

Instructions

WARNING

YOU MUST have proper ventilation, dust collection and PPE. Use an appropriate respirator and eye/face shield. Failure to follow can result in injury or death. You do NOT want to breathe in seashell dust!

TURNING THE SHELL PEN BLANK**CHEAT METHOD**

1. Cut Blank to tube length leaving about 1/8" on either end for squaring.
2. Drill out blank with a sharp bit using whatever method you like.
3. EPOXY in the tubes and follow epoxy times for full cure.
4. Square blank and mount with bushings.
5. Turn lathe on HIGHEST SPEED - Using a rotary/DA or Lap belt sander to bring your blank down to within the hand sanding and finishing level for your bushings. While you are sanding, intermittently STOP, clean you blank with alcohol and fill any voids with CA glue. Thin works best to build up. Use CA, accelerator, CA, etc until you have filled the void. Go sparingly so you don't create white spots. Continue sanding to tolerance.
6. Hand sand while still on the lathe to your bushing size and then complete the finishing process with CA. Utilize whatever method at this point.
7. Recommend CA and then working up with Micro Mesh to the final grit, removing and then buffing with a buffing wheel.
8. Assemble pen as desired.

NORMAL METHOD

1. Cut Blank to tube length leaving about 1/8" on either end for squaring.
2. Drill out blank with a sharp bit using whatever method you like.
3. EPOXY in the tubes and follow epoxy times for full cure.
4. Square blank and mount with bushings.
5. Turn lathe on HIGHEST SPEED.
6. Using Carbon Tools or EXTREMELY SHARP HSS – begin to work the blank in very small increments and continue to work in ONE DIRECTION. Hold the chisel firmly, the shells like to push back on tools. This really is a time that you must learn to apply only the right amount of pressure to remove some material. It's a touch and feel as you go experience.
7. Stop the lathe and fill voids with CA. Continue to turn and remember – fast lathe- SMALL, SHALLOW CUTS. JUST ENOUGH TO REMOVE MATERIAL.
8. This is a long process. It can take up to two hours to get this right the first time you do it, Eventually, you will learn the method, but go easy to start.
9. If you are using non carbon tools, you will need to sharpen many times during turning.
10. Bring blank to size just before bushing.
11. Now you may fill any voids and start your sanding and finishing process.
12. Finish the blank by applying CA and sand with micro mesh.
13. Finish on the buffer and assemble your pen.
Pat yourself on the back. You just finished, arguably, the toughest blank you can make!

TIPS

- Sharp and fast and slow, gentle cuts.
- Go ONE direction.
- You will have voids. Period. Pay attention to them and use alcohol each time you stop and before you apply CA so you don't make your voids cloudy.
- The best finish will be CA followed by buffing.
- Sparks will fly. When the shells hit sandpaper and chisels- you may see sparks.
- NEVER- put your finger on the blank while spinning- shells can have razor sharp edges. I know this from experience. Wait until the blank stops spinning and then test the surface that way.

Have fun!