

Segmented Pen Blanks

By Steve Kondo

These are laminated wood blanks, **sharp tools are a must!**
Extra care should be taken when drilling & turning.

Drilling:

1. Mount per your preferred method (either on lathe or in a pen vise)
2. Center and pre-marked for reference, drill slowly so you don't generate excessive heat
3. Back your drill bit out every 1/8 – 1/4 to clear out cuttings/shavings.
4. **Drill from both ends, a little more than 1/2 way each side**
****this ensures perfect center alignment of the segments when assembled****
5. Insert tubes with your preferred adhesive **flush with the chevron ends**
****I recommend using Thick C.A. to glue in the tubes****
6. **Turn/sand away the excess wood at square end**
(Do not use a barrel trimmer as it will cause a chip-out and/or blow out on the ends)

Turning:

Sharp tools and light cuts are a must!

1. Mount on lathe with your preferred method (mandrel/bushings, TBC, etc.)
2. Using your preferred gouge/skew/scraper, take smaller cuts to turn blank round
(I turn these @ 2600-3000 RPM, I turn round with a roughing gouge, then finish sizing with a round carbide scraper).
3. Turn blanks to desired shape bringing them equal to bushings diameter
4. Sand blanks with slower speeds (100-300 RPM) starting with grit needed, continue through 600+ grit
(I dry sand these from 320 through 600 using Abranet discs, sand while turning slowly on lathe, and then stop Lathe and sand with the direction of the grain (laterally), in succession for each grit)

Finishing:

- ~ Once sanded to optimal finish quality, Blow off any debris that might be in some voids, wipe blanks with Denatured alcohol (DNA) to remove any dust/debris from the pores of the grain, allow 1-2 minutes to dry.
- ~ Apply your desired finish of choice as you normally would with any kit.
- ~ For C.A., I apply 2 coats thin flex, sand smooth, then apply 6 coats Medium flex, sand smooth 400 to 600.
- ~ I then wet sand using Micro Mesh 1500 through 12000.
- ~ Final polishing with desired compound (I use Maguire's Ultimate Polish)

Assembling:

Clean out tubes removing any excess debris/adhesive, assemble as you normally would
You have a choice of chevrons at either end, or together @ center band, whichever is your preference

I guarantee my blanks 100% against defects, and will replace any blank that has a defect

I use mainly Burls, Double Dyed Burls and Acrylics and they are well known to have voids within the wood, I have no control over that aspect

I am not responsible for user error when turning and drilling. If you follow the above advice, you'll have a perfect blank every time.

If you deviate from these instructions, I am not responsible for an imperfect final product.