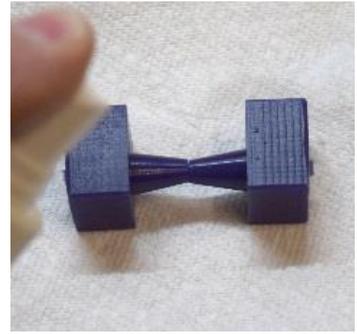


# Arizona Silhouette DogBone<sup>™</sup>

## Mold Instructions©

Prepare your pen tubes as you see fit, in this example abalone shell slices were wrapped around Venetian pen tubes (10.5mm & 12.5mm). Once you have your pen tubes prepared, follow the steps below.

**Step 1** – Spray the inside of the mold and the sides of the silicone plugs with mold release and allow it to dry. (do not spray mold release on your finished pen tube or the resin will not stick to it!)



**Step 2** – After both the mold and silicone plugs are dry, push the silicone plugs snugly into your prepared pen tubes. There are two different sizes silicone plugs supplied with the DogBone mold. Make sure you are using the appropriate size plugs in order to get a snug fit into your pen tubes to avoid resin leaking into the inside of the tubes.



**Step 3** – Firmly press your pen tubes with the silicone plugs in each end into the mold chamber. Make sure it is firmly seated in the bottom of the mold.



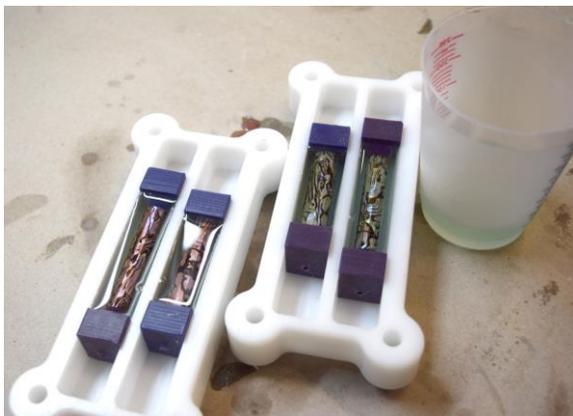
**Step 4** – Mix your resin according to the manufacturer's instructions. Three (3) ounces of resin was thoroughly mixed and then carefully poured into the mold filling each chamber. Take care not to overfill the chambers.



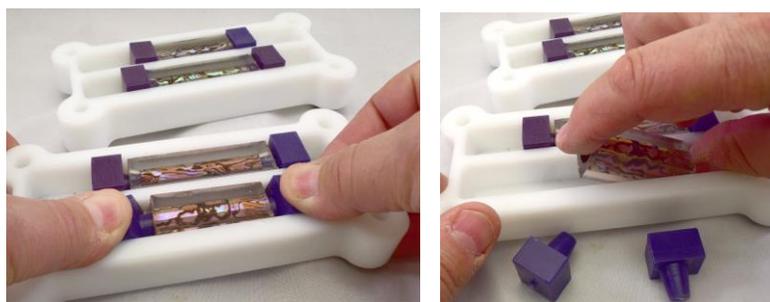
**Step 5** – If any air bubbles appear, tease them to the surface. Also, if using a pressure pot and more than one mold, stack them and place into pressure pot. Polyester resin was used for this example so a pressure pot was not needed.



**Step 6** – Here are the two DogBone molds filled with resin. **Please Note:** only 1.5 ounces were used to fill all four chambers and you can see the remaining resin in the cup. In fact, enough resin was leftover to pour two more Sierra Grip pen tubes that have pictures wrapped around the pen tubes.



**Step 7 – Demolding:** Once the resin is dry, carefully pull the silicone plugs apart from the pen tube and then simply pull the casted piece out from the mold.



**Step 8 – Final Images:** Here are the 6 pen blanks that were casted using 3 ounces of polyester resin without a pressure pot. The two finished pens were made from a previous cast from the DogBone mold.

