



Instructions for Acrylic Pen

Buffing System[®]

Item Numbers BG012, #2 MT or BG013, #1 MT



Use water to wet sand your acrylic pen blank as per your normal finishing methods. If you use a scratch remover, you may proceed to that step before removing your pen blank and mandrel from the headstock.



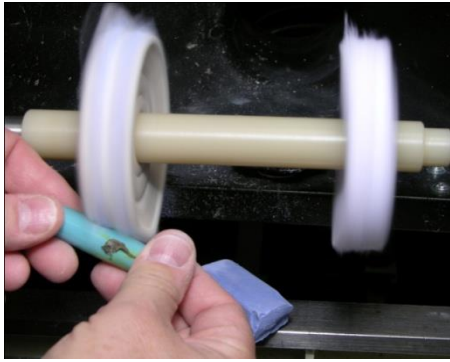
Insert the #1 or #2 Morse Taper, 8mm mandrel into the head stock of your lathe. Now, slide the 2" white plastic bushing onto the mandrel shaft followed by the 4" cotton (tan) wheel as shown. The tan wheel is the rouge applicator wheel.



Next place the large 4" white spacer on the mandrel shaft followed by the 4" flannel (white) buff wheel, the remaining 2" white spacer with the tenon and the locking nut. Bring up tail stock to support buffing mandrel. The white wheel does **not** get rouge applied to it!

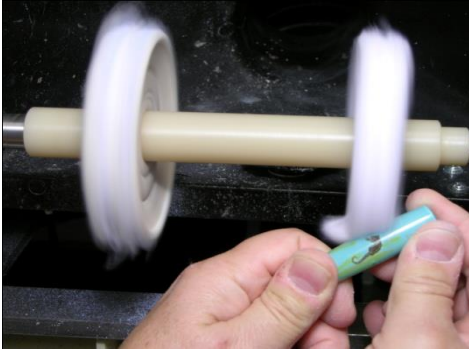


Apply a small amount of the blue polishing rouge to the cotton (tan) wheel. The cotton wheel should show slight traces of the blue plastic polish on the wheel. **ONLY** place the blue plastic finish on the cotton (tan) wheel. **DO NOT** place any of the blue plastic polish on the flannel (white) wheel! The flannel (white) wheel is the last step in the polishing process and should not have any blue polish on the wheel!



Lathe speed should be between 1,200 – 1,700 RPM.

Hold your pen blank with two hands and with a slight pressure, rotate the pen blank back and forth covering the entire pen blank for approximately 20 seconds.



After you are finished with the cotton (tan) wheel, use two hands rotating the pen blank side to side and up & down to remove any hints of blue polish that might remain on the pen with the finishing flannel (white) wheel for approximately 10 seconds. Inspect your pen blank to ensure a glass finish with **NO SCRATCHES!!!**



CAUTION: the first several times you use your pen buffing system, both of the wheels will “shed.” This is **normal** and will stop after a time. It is advisable to have a vacuum system available to “suck” up any of the cotton (tan) or flannel (white) wheel strands that might come off the wheels.



Finished pen blanks ready for assembly.

Replacement Buffing Wheels & Rouge:

- 4” Cotton (tan) Rouge Wheel – Item # BG014
- 4” Flannel (white) Finishing Wheel – Item # BG015
- Blue Buffing Rouge – Item # BG016