

# BG Artforms

## Pen Casting Kit Instructions

**Make sure you have adequate ventilation!**  
**Resin and Hardener are FLAMMABLE!**  
**Keep away from heat and fire!**



Open the pen blank casting kit to inspect all the components.

32oz. High Performance Non-Yellowing Resin  
5 pair latex Gloves - Hardener  
5 Stir sticks – Measuring Cup  
Mold & Assorted corks and rubber stoppers



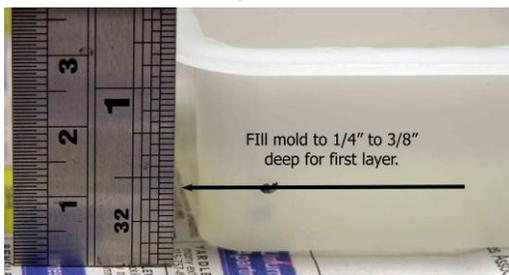
Cover a flat and level work area with newspaper and set mold on newspaper.

Put Measuring cup next to mold and add 1 ounces of High Performance Resin into the cup. Add 6 drops of hardener if it is 60-69 degrees or 5 drops of hardener if it is 70-75 degrees or warmer.



Mix with stir stick VERY SLOWLY, trying not to introduce bubbles into the mix. As soon as mixed well, with stirrer, remove bubbles from mix and wipe on newspaper. Working time is about 10 - 15 minutes, so this part of the cast must be completed and poured within that time or the resin will be ruined

Pour mix slowly into mold until it is about 1/8" to 1/4" deep. Discard the rest of



the mix, saving the measuring cup. Remove any bubbles that appear in mix by using stir stick and wiping them on newspaper. You will have to watch the mix for about 15-20 minutes, as additional bubbles may appear and need removed. The mix needs to cure for at least 2

hours, but preferably overnight or 8 hours. Keep dust and dirt from getting into the mold or they will become part of your pen!

During the time that your first pour is curing, prepare your pen tubes by gluing thin objects to them, wrapping pictures around them or anything that you might have that you want to turn into a pen design. Such as greeting paper, wall paper, postage stamps, etc.



Once you have completed preparing your pen tube, place a suitable size cork / rubber stopper into one end of the tube and then place the copper ball bearings into the tube to weight it down. Place the other cork / rubber stopper into the other end.



Place the completed and weighted pen tubes into the mold.

In measuring cup, mix 2 ounces of resin with 12 drops of hardener if it is 60 to 69 degrees, or with 10 drops of hardener if it is 70 - 75 degrees, and mix as above.



Pour resin into mold over and around the tubes until the tubes are 90% or almost covered. Do not completely cover the tubes. Gently "roll" the tubes (while in the resin and still liquid) to release any air bubbles that might be trapped underneath. Position the tubes squarely in the mold to cure. Remove bubbles as in the

previous cast by using the stir sticks and wiping on the newspaper. You will have to remove the bubbles multiple times over a period of about 10 to 20 minutes. Any bubbles left will be a part of your finished work, and possibly ruin your cast. It is common for the tubes to move slightly during this time - make sure they stay straight in the molds until the resin "flashes" (becomes gel - like). As soon as the resin begins to flash, do not disturb it any longer or it will ruin your cast! Let the resin cure for 24 hours!

After 24 hours resin should be hard to the touch of a stir stick. Check by touching stir stick to an area near the mold edge, away from the tubes (DO NOT TOUCH NEAR THE TUBES AS FINGERPRINTS OR MARKS MAY RESULT!).

Put 2 ounces of resin into the measuring cup and add 12 drops of hardener if 60-69 degrees, or 10 drops of hardener if 70-75 degrees. Stir as above being careful again not to introduce bubbles. Pour resin into mold to fill the mold to the top and again for about 10 to 20 minutes, you will have to remove bubbles using a stir stick and wiping them onto the newspaper.

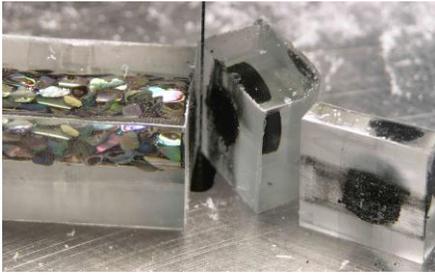


Let resin "cure" for 24 hours.

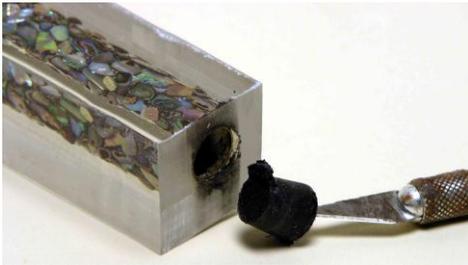
After "curing" remove from mold by twisting ("flexing") ends of mold carefully. Mold can be reused many times if not destroyed in this process. Block will "pop" out of the mold. DO NOT TOUCH AREA OF THE FINISHED WORK OR FINGERPRINTS WILL RESULT!! Handle by the edges.



Cut the resin mold into two pieces (pen blanks) with a band saw or scroll saw using light pressure, observing all safety precautions. Do not force the saw blade to cut the resin with undue pressure or it will crack the resin.



Make an additional saw cuts at the tube ends to expose the cork/rubber stoppers. Cut near, but not into the brass tubes or your pen may not operate correctly.



With a sharp pin, nail or exactly knife blade remove the stopper completely. Congratulations! You now have pen blanks ready for turning!



Carefully, square the ends of your pen blank!



Turn your acrylic pen blank using **sharp tools** and **light cuts** to remove the acrylic. I use a skew as a scraper to give the final pass before sanding.



Sand with a piece of 220 or 320 grit sandpaper to remove any tool marks and then use the PFK-1 Acrylic Finishing Kit, followed by the Acrylic Pen Buffing System (APBS-1) to polish your cast pen blanks.



APBS-1

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Other finished pen blanks –

