

## Turning a Dymondwood Pen Blank

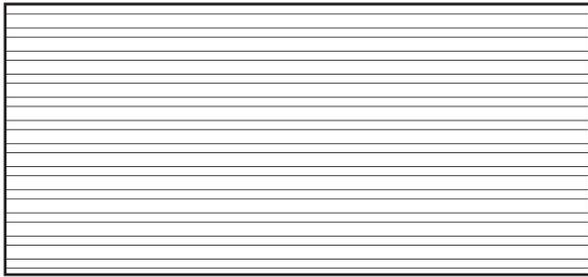
Dymondwood is natural hardwood veneers that have been impregnated with resins and coloring agents. Basically, the material is a wood and plastic combination that has the working characteristics of plastics. In drilling Dymondwood, some precautions must be taken to eliminate overheating and causing cracking, which may not be noticed until the pen is being assembled.

### Recommendations

- Sharp bits – Brad point
- Drill press speed 800–1,000 rpm
- Slow, steady feed, clearing the bit often
- Cool the bit with a damp cloth if it becomes too warm to touch (with the drill stopped)
- Drill almost to the bottom of the blank, but not through it or you may split the blank
- Cut the last 1/8" off the blank with a band saw, opening up the hole
- BE SURE THE BIT DOES NOT GET HOT!
- If the blank shows hairline cracks, run a little thin CA glue into the crack and let it dry. You may want to re-drill through the blank.

### Basic Pattern

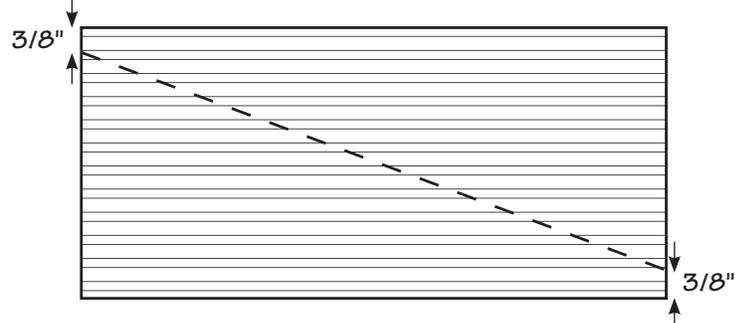
1. Set your band saw to the required width of pen blank and make 2 cuts, which should produce 3 pen blanks of equal width. These blanks will have a straight grain appearance, similar to quarter sawn lumber.



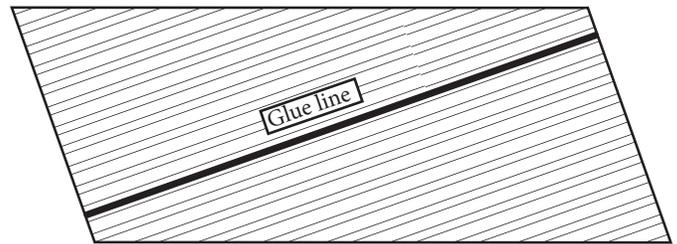
### Oblique Pattern

1. Any deviation from the parallel grain or basic pattern will produce an oblique or angled pattern. The further the deviation from parallel, the more striking the pattern will become. To produce this pattern, one part of the block is sawed off at an angle to the flat edge, then glued on to the outer edge, producing a block which is parallel on the sides, but angled on the ends. Follow the cutting sequence which follows.

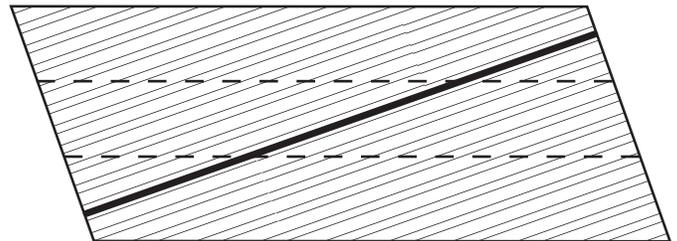
2. Mark in 3/8" from each edge, and join the marks with a line, then use a band saw and cut down the line. This will give you 2 pieces the same size.



3. Lightly sand each of the shiny edges (not the cut edges) to remove the gloss and any oil or dirt which may be on the surface. This will prepare the edge for gluing.
4. Position the 2 pieces as shown.



5. Glue together with epoxy or gap-filling super glue.
6. Set your band saw to the required width of pen blank and make 2 cuts, which will give you 3 pen blanks.



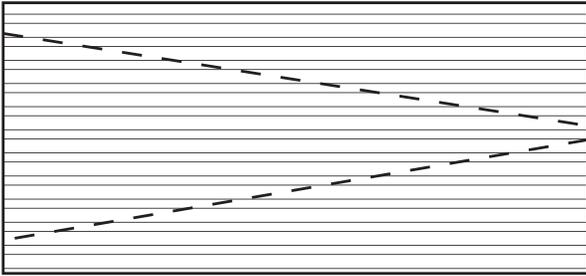
7. Square the ends of the blanks. They can be cut square on the band saw, miter saw, etc.



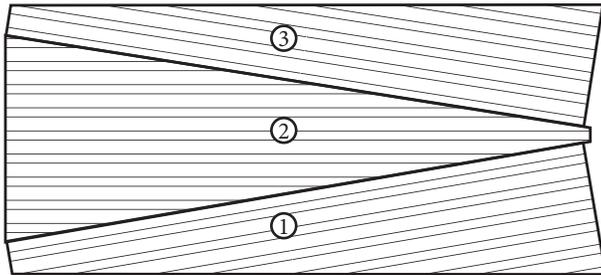
8. At this point, you are ready to proceed with the regular procedure for making pens.

## Reverse Oblique Pattern

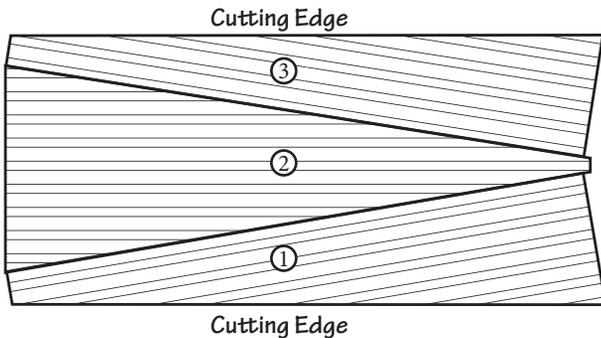
1. The reverse oblique pattern can be done easily if you cut straight and use a belt or disc sander to sand the cut edges flat and true. The design will yield 3 pen blanks, all of which will be different. It is very effective when the glue-up is made from different colored blocks.
2. Mark and cut lines as shown.



3. Sand the cut edges flat and true on piece #2.
4. Sand the glossy edges of pieces 1 and 3 to remove oil or dirt from the surface.
5. Assemble the 3 pieces shown.



6. Glue together with epoxy or gap-filling Super Glue.
7. Set your band saw to the required width and make 2 cuts. This will give you 3 pen blanks.



8. Square the ends and the pen blanks are ready to use.

For all those who had problems with Dymondwood, Colorwood, or other laminated pieces, After gluing in the tubes, put a drop of thin CA on a piece of plastic wrap or other non-porous disposable material. Swirl each end of the blank in the drop of CA. If you are careful, you will not get any inside the brass tube. The CA strengthens the end grain and prevents tear out and splintering. Helps with finish too!