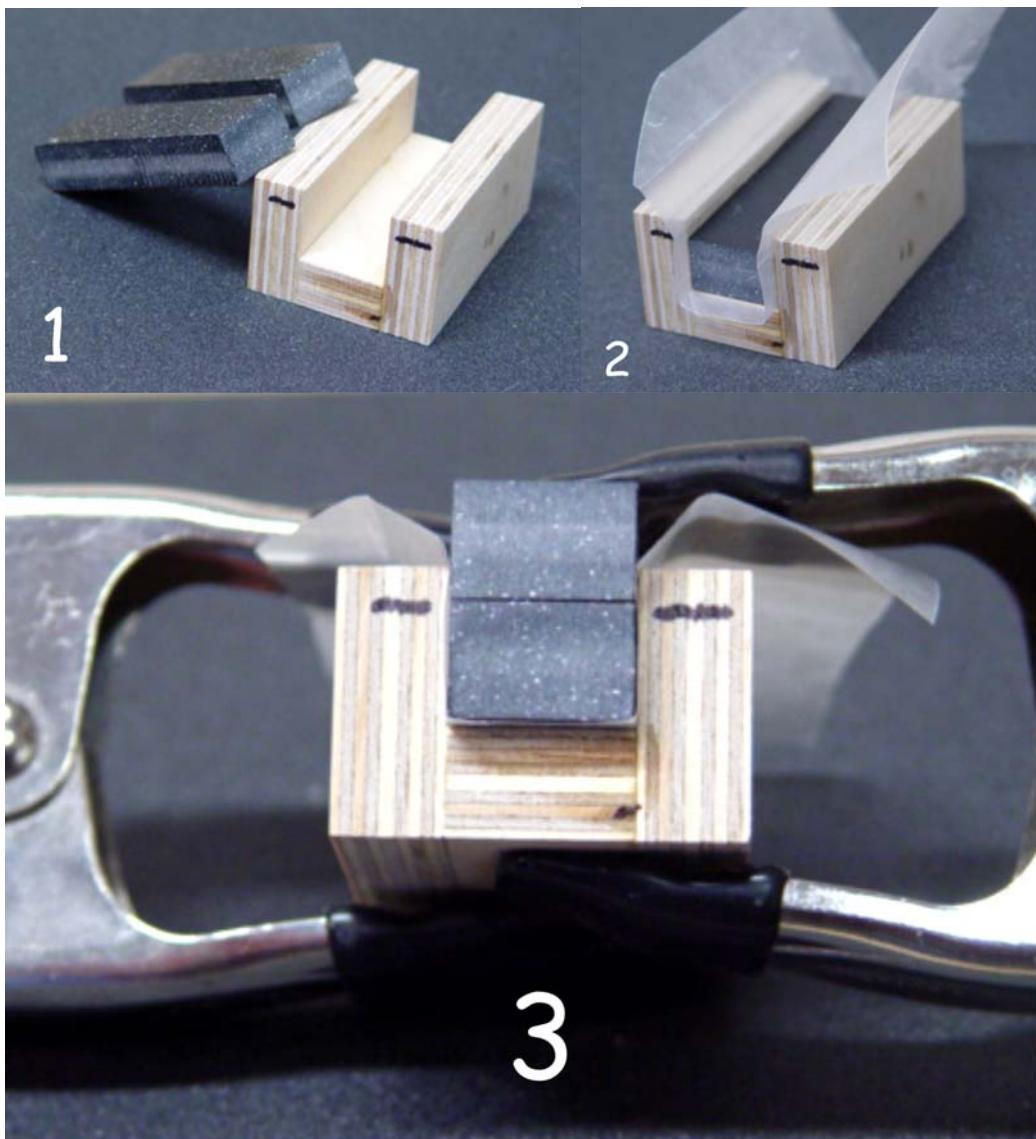


Instructions for gluing up Corian blanks to make thicker pens.



First, determine how wide you want to make your blanks. In the examples above, they are about $\frac{3}{4}$ " wide. The Corian itself is $\frac{1}{2}$ " thick, so they will end up being 1" thick by whatever size width you choose.

Now, Make up some little jigs out of $\frac{1}{2}$ " plywood or whatever. Make them just a fraction wider than what you need so that you can fit a piece of wax paper in there. Make the sides of the jig about $\frac{3}{4}$ " high inside as shown so that part of the top piece sticks out above the jig. This is for clamp clearance.

OK, we're ready to get started. When you glue the pieces together, make sure you are gluing the top surface of one piece to the top surface of the other. The reason for this is that when they pour the sheets, they do it upside down, and more of the particulates settle to the top of the sheet (which ends up being the back). If you were to glue the top of one piece to the bottom of the other or 2 bottoms, you would end up with a very noticeable seam line.

Before you glue, sand the tops flat and rough them up by rubbing them on some 180 - 220 grit paper that has been taped down to a FLAT!!!!!! surface. Then clean them off with denatured alcohol. Check and make sure the pieces and the wax paper fit in the jig.

If all is OK, squirt a fair amount of thick CA on one piece. Now, quickly rub the two surfaces together to get an even and complete coverage of glue. Make sure there are no voids. Quickly drop one piece into the jig, then the other on top, and hit with 2 spring clamps. The jig keeps them from sliding around in one direction, use your fingers to keep them end to end. You have to work quickly, but don't worry, there is enough time to do this. Cheap vinyl gloves help keep the fingers clean.

After a few minutes, I spray with accelerator and then proceed to drilling. Something worth noting: While I have never had any problems drilling so soon after gluing, some have reported that the CA has taken much longer to fully harden. I don't know if it

has anything to do with different climates or brands of glue. This being the case, you should probably leave them clamped up for a while, or do some experimenting. Just be sure to **always wear your face shield !!!!!** Flying pieces of Corian can be sharp and dangerous.

A few notes on drilling:

It is very helpful to make your blanks a bit long, drill to the needed depth, and then cut off the end. Corian, or any solid surface material will blow out very easily if the bit comes out the end while drilling.

Also, while drilling, squirt some cold water in the hole each time you back out the bit. This keeps everything cool, lubricated, and allows you to drill fairly quickly. You don't want to get it too hot. Keep your drills sharp. The Drill Doctor works great if you have not already tried one.

Lastly, when you are turning and doing your final sanding, you may be able to see a slight glue line. But once you get to the final buffing, it will all but disappear. Use your favorite plastic finishing procedures and you should have no problems. I usually wet sand to 800 and then hit it with EEE Ultrashine from PSI. When gluing in your tubes, I recommend Gorilla glue or epoxy.

I have made hundreds of pens this way with no problems. But I'm sure you will refine your own methods from these guidelines.

Good luck, and have fun.

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