

# Casting Blanks w/Wood (Pens, Calls, Handles, Etc.)

## Products used in this application:

- \* Alumilite Clear Resin
- \* Measuring & Mixing Containers
- \* Stir Stick
- \* Digital Scale
- \* Latex-free Gloves
- \* Alumilite Liquid Dye or Alumidust
- \* Worthless Wood or other media
- \* Pressure Pot w/Air Compressor
- \* Moldbox (HDPE or Silicone)
- \* Lathe
- \* Sand Paper or Micromesh Sanding pads
- \* Plastic Polish (Novus 3 Step or similar)



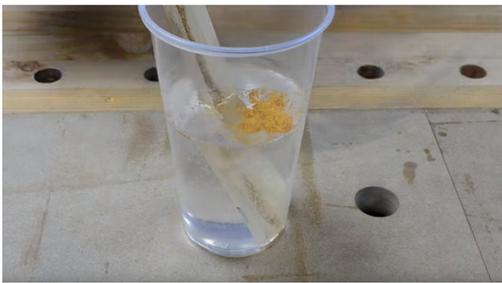
**Prepare Wood:** Before starting, dry and stabilize wood. Using available saw, trim wood to fit into mold-box. If using scraps, chips, or fines, simply pour them into your mold box. **Note:** Moisture in any substrate will cause bubbles in resin, therefore we recommend that humidity be less than 5% and/or stabilize wood.



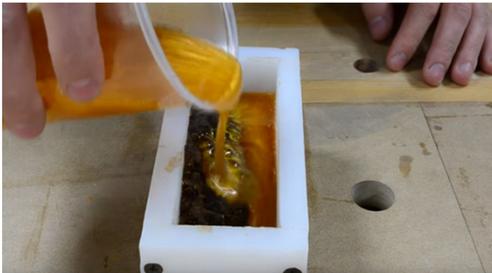
**Measure Resin:** Estimate (or use Volume Calculator on Alumilite.com) the amount of required resin to fill the mold-box and measure out side A and B per the instructions for the respective resin. Alumilite Clear is 1:1 mix ratio by weight, therefore you will need to weigh each side to achieve an accurate mix ratio. **Note:** improper mix ratio can result in tackiness, cloudiness, and soft resin.



**Mixing:** Combine part A and B together into a mixing cup and begin mixing. Continue mixing until all striations disappear and resin is clear. Scrap sides, bottom, and excess resin off stir stick often to ensure that all resin is mixed. **Note:** Mixing, pouring, and pressurization of pressure pot should be done within the stated working time of the resin.



**Adding Pigments:** Alumilite liquid dyes or Alumidust can also be added to the resin depending on the design you are going for. Alumilite Pearlescent powder can be combined with Alumilite Liquid Dye to achieve a pearl-effect similar to the many available Alumidust colors.



**Pour:** Slowly pour resin into mold box allowing it to naturally flow over and around the wood.



**Pressurize:** Place mold inside of pressure pot and pressurize to 40-60 psi. Many pressure pots have their air inlets in the lid, therefore introduce air slowly to avoid blowing resin out of your mold box. A deflector can also be placed over the mold box to divert air away from resin. Hold pressure until resin has hardened and can be demolded. Resin must cure under pressure to avoid visible air bubbles in your cured blank.



**Turning:** To ensure that the highest cured properties have been achieved, it's recommended to allow resin to cure for 12-24hrs. before turning.



**Sanding & Polishing:** Alumilite resins can be sanded using fine grit sanding paper or pads. Plastic Polish such as Novus can be used to polish Alumilite Clear to a high gloss.



**Assembly:** Once polished, assemble remaining pieces and you now have a one of a kind, unique pen, call, or whatever you chose to make!