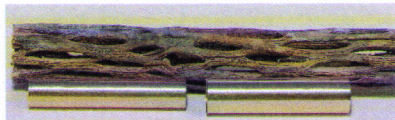


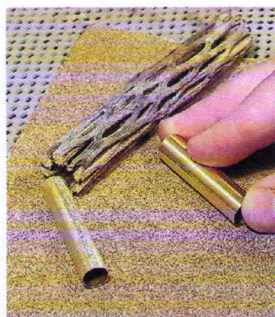
# Cholla Cactus Pens© - By Barry Gross - BG Artforms

## Pen Blank Preparation:



Step One:  
Line up your pen tubes against the piece of cactus you

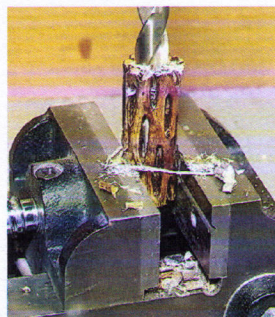
have chosen to ensure the correct length of cactus and cut them leaving about 1/16" on each end.



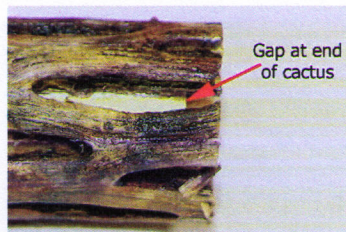
Step Two: Rough up the pen tubes so the glue will have a good bonding surface with the tube and the inside of the cactus.



Step Three:  
Try and place the drill bit into the center of the cactus piece you have selected. It should be just snug or slightly larger



Step Four:  
Using a drill centering guide or a dedicated drill chuck, carefully drill down the center of the cactus.



Step Five:  
You may have gaps between the end of the pen tube and the cactus blank - this is normal.

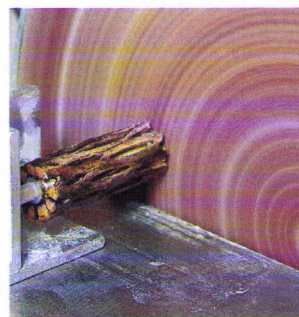


Step Six:  
Cut small pieces of cactus, wedge them into the ends of your blank and secure the pieces with thin ca glue.



Do Not Use Barrel Trimmer To Square  
tear it apart!

Step Seven:  
Do not use a barrel trimmer on the ends of your cactus blank - it will

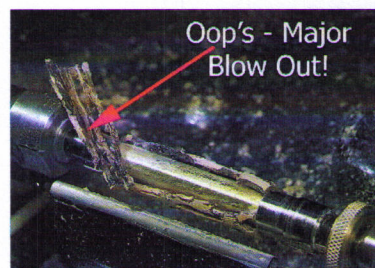


Step Eight:  
Use a squaring jig to square the ends of your cactus blank.



Step Nine:  
Place your cactus blank on your mandrel and carefully taking **LIGHT** bites, rough it down to just slightly larger than the bushings.

Step Nine:  
Place your cactus blank on your mandrel and carefully taking **LIGHT** bites, rough it down to just



Step Ten:  
If you take too aggressive bite on your cactus blank it will blow apart. Do not fear, that is what ca glue is for!



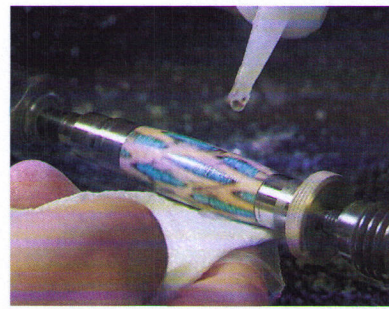
Step Eleven:  
Glue the blow out piece back into place using medium ca glue. You are now ready to fill it with a Stone Filler color of your choice.





**Step Twelve:**  
Fill each section of the cactus blank with the Stone Filler color of your choosing and drip thin ca glue into that section.

Turquoise Stone Filler is used here as an example.

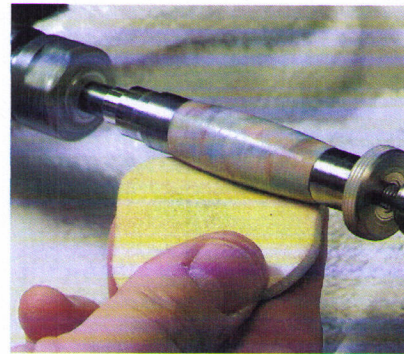


**Step Sixteen:**  
Hot Stuff medium ca glue is applied to the cactus blank as a finish.

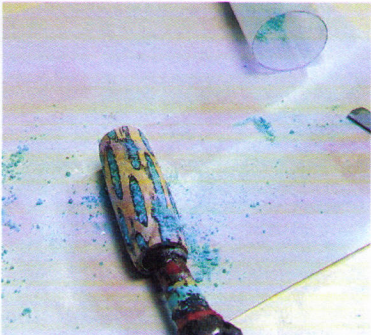


**Step Thirteen:**  
Since you have filled the cactus with stone, I suggest using a carbide tool to turn the blank. You can use regular high speed steel tools

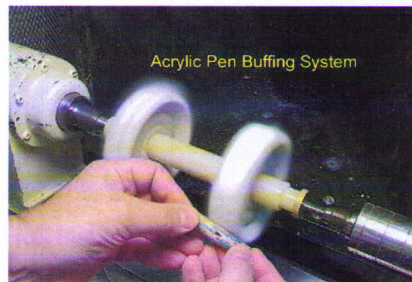
but they will dull quickly where the carbide tip makes fast work of the stone.



**Step Seventeen:**  
Use the PFK-1 cushioned abrasive pads to wet sand the ca finish.



**Step Fourteen:** If you have any voids in the blank after turning it down, re-fill the area with the turquoise and return to the lathe to smooth it out.



(APBS-1) to give your cactus pen blank a completely scratch free shine.

**Step Eighteen:**  
Use the specially designed Acrylic Pen Buffing System



**Step Fifteen:**  
Sand the blank as you normally would to 800 grit and then use Abralon sanding pads to prepare the

surface for the ca finish.



Turquoise Stone Filler.

**Final**  
Cholla  
Cactus  
Pen filled  
with

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