

## STEPS FOR MAKING THE VETERANS BOTTLE STOPPER

BY OZARK WOODTURNERS 11/10/15

1. CUT WOOD BLANK TO 1 ½ INCH SQUARE X 2 INCHES LONG. ENDS SHOULD BE SQUARED OFF.
2. CENTER DRILL ONE END WITH A 23/64 INCH BIT 7/8" DEEP.
3. MOUNT A BOTTLE STOPPER MANDREL WITH A ½ INCH DIAMETER BUSHING, (SEE VETERAN COORDINATOR) ON THE LATHE AND SECURELY THREAD THE TURNING BLANK ONTO THE THREADED MANDREL.
4. USING THE TAIL STOCK WITH REVOLVING CENTER FOR STABILITY AND SUPPORT, TURN THE BLANK ROUND AND CHAMFER THE HEAD STOCK END DOWN TO THE MANDREL SHOULDER DIAMETER.
5. YOU MAY HAVE TO USE A WRENCH ON THE MANDREL AND A RUBBER GRIPPING PAD ON THE BLANK TO REMOVE THE BLANK FROM THE MANDREL.

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6. MOUNT A BOTTLE STOPPER MANDREL ON THE LATHE AND SECURELY THREAD THE TURNING BLANK ONTO THE THREADED MANDREL.
7. USE THE TAIL STOCK WITH REVOLVING CENTER TO PROVIDE STABILITY AND SUPPORT THROUGH MOST OF THE TURNING. THE TAIL STOCK CAN BE REMOVED FOR FINAL TURNING, SANDING AND FINISHING.
8. YOU MAY HAVE TO USE A WRENCH ON THE MANDREL AND A RUBBER GRIPPING PAD ON THE BLANK TO REMOVE THE BLANK FROM THE MANDREL.
9. **NOTE: THIS STEP APPLIES WHEN USING A PENN STATE SILICON BOTTLE STOPPER ON A WOODEN DOWEL. (KIT NUMBER IS: #BS5).** APPLY A FEW DROPS OF WOOD GLUE TO THE INSIDE OF THE THREADED BOTTLE STOPPER AND INSERT THE SILICON BOTTLE STOPPER DOWEL INTO THE HOLE USING A TWISTING MOTION TO SPREAD THE GLUE. LET THE GLUE DRY BEFORE USING.