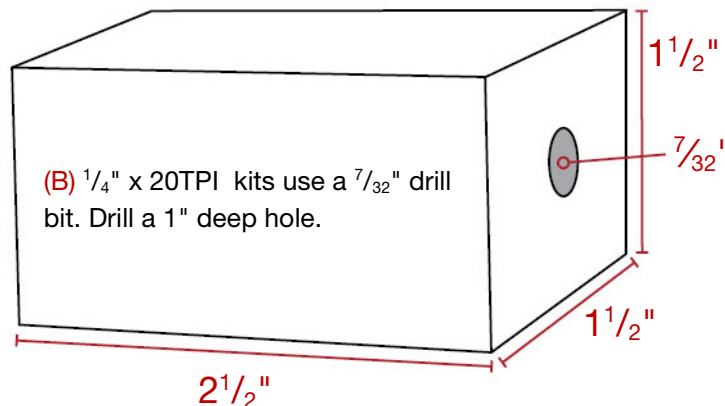


## Bottle Stopper Turning Kits

Product: (A) #150767, #150968, #159490, #159491, #160765, #160766 6/3/2015

(B) #144631, #148874, #149242, #150868, #822942



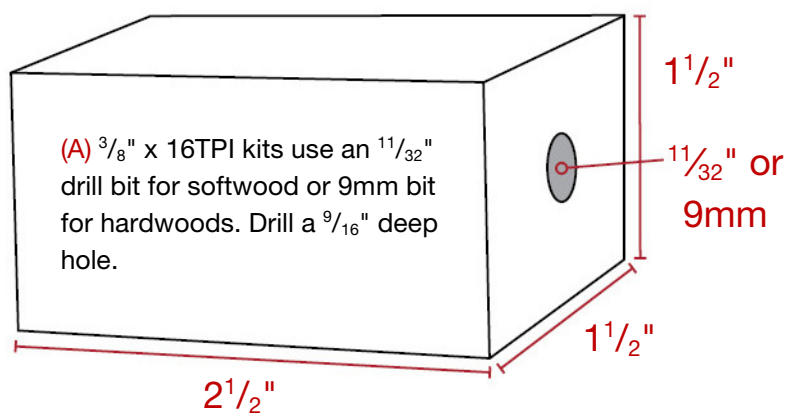
### From Setup To Sanding:

These are the supplies we suggest you have on hand to complete these tuning kits:

- (A) 11/32" or 9mm Drill Bit for 3/8" x 16TPI Kits
- (A) 3/8" x 16TPI Whiteside Mandrel (153584)
- (B) 7/32" Drill Bit for 1/4" x 20TPI Kits
- (B) 1/4" x 20TPI Whiteside Mandrel (153583)
- 1 1/2" x 1 1/2" x 2 1/2" Turning Block
- Drill Press or Lathe Drill Chuck
- Sandpaper/Micro-Mesh
- Eye & Ear Protection
- Dust Mask

### Cutting & Drilling Blanks:

Dimension turning stock to the sizes shown below.

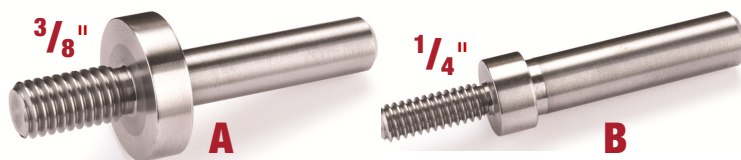


### Squaring the Blank:

Either during the dimensioning process or once mounted on the lathe, ensure that the ends of the turning stock are flat and square.

### Mandrel Preparation:

Mount and secure the appropriate stopper mandrel in either a 4-jaw scroll or lathe drill chuck. Thread the turning block onto the mandrel until it seats tightly against the shoulder of the mandrel.



### Turning & Finishing the Blanks:

Bring the live center up to the turning block and lock into place. Turn the blank to your desired profile. With the lathe spinning, begin sanding with 120 grit paper progressing through the finer grits finishing at 320 grit. Once finished with sanding, apply a finish of your choice.

### Assembly:

- Remove the turned block from the mandrel.
- Kits (A) thread the turned block onto the Bottle Stopper Turning Kit.
- Kits (B) use a few drops of CA or epoxy to secure the threaded post into the turned block. Once cured thread on the stopper.