



1) ROUGH OUT BLANK TO ROUGH SHAPE BETWEEN CENTERS. TURN TENON ON TOP FOR DOVETAIL CHUCK JAWS.

2) CHUCK BLANK USING TAIL STOCK LIVE CENTER TO ALIGN TO CENTER. SUPPORT W/ STEADY REST IF AVAILABLE. (RECOMMENDED)

3) MARK TOP/BODY PARTING LINE.

4) BORE TO DIMENSIONS SHOWN W/ FORSTNER BITS. CONSTANT AIR FLOW IS REQUIRED AS THE BIT GOES DEEPER. BACK DRILL OUT FREQUENTLY TO CLEAR CHIPS.

5) SAND & FINISH BOTTOM AND INSIDE 1-3/4" BORE.

6) PART BODY FROM TOP USING NARROW PARTING TOOL. THIS WILL REQUIRE A CUT SLIGHTLY WIDER THAN PARTING TOOL TO AVOID BURNING. IMPORTANT THAT FINAL JOINT SLOPES LEVEL OR SLIGHTLY UPWARD ON TOP SURFACE AND LEVEL OR SLIGHTLY DOWNWARD ON BODY SURFACE.

7) BORE TOP PER INSTRUCTIONS. SAND & FINISH BOTTOM SURFACE OF TOP.

8) CHUCK BODY INTERNALLY USING EXTERNAL CONE TO INSURE TOP END OF BODY IS ACCURATELY ALIGNED. BORE REMAINING 1/2" OF BODY W/ 1" FORSTNER BIT. THE PLASTIC STOPPER THAT FITS INTO TOP IS SLIGHTLY OVER 1" DIA. USE SCRAPER TO CAREFULLY OPEN TOP BORE IN BODY TO PROVIDE GOOD FIT W/ STOPPER. DO NOT FIT TOO TIGHT AS ANY FUTURE WOOD MOVEMENT WILL CAUSE MILL TO BIND, BUT TOO SLOPPY WILL RESULT IN UNSIGHTLY FIT.

9) INSERT STOPPER INTO TOP AND SLIDE TOP & BODY TOGETHER. IF FIT IS TOO LOOSE WRAP STOPPER W/ TAPE TO CREATE TIGHT FIT WHILE FINISH TURNING.

CHUCK ENTIRE ASSEMBLY W/ THE TOP TENON INTO DOVETAIL CHUCK JAWS AND BOTTOM ALIGNED & SUPPORTED W/ CONE CENTER INSERTED INTO BORE AT BOTTOM.

FINISH TURN BODY & TOP AS SINGLE ASSEMBLY IF SHAPE IS A CONTINUOUS FLOW AS IN ILLUSTRATION. TURN ANY DESIRED V-NOTCHES OR BEADS AT JOINT BETWEEN TOP & BODY AT THIS TIME. SAND & FINISH TOP/BODY ASSEMBLY AS 1 UNIT AT THIS TIME.

NOTE: OTHER SHAPES SUCH AS A KNOB TYPE TOP MAY NEED TO BE DONE DIFFERENTLY.

10) CHUCK TOP INTERNALLY AND TURN OFF TENON, TURN SHAPE OF TOP AND THEN SAND AND APPLY FINISH TO TOP.

11) INSTALL CRUSH GRIND MECHANISM PER INSTRUCTIONS PROVIDED W/ MECHANISM.