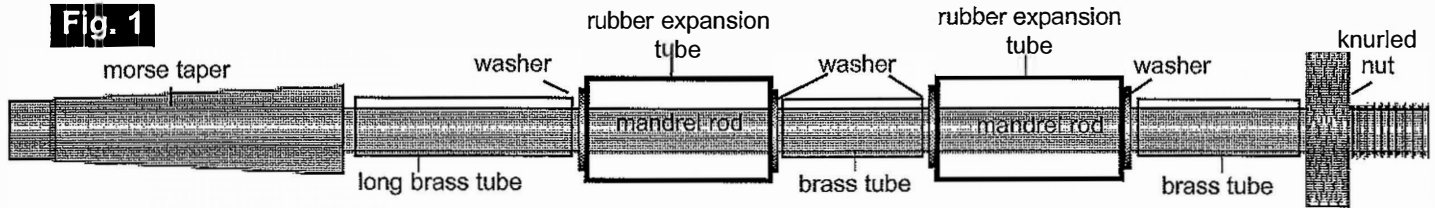
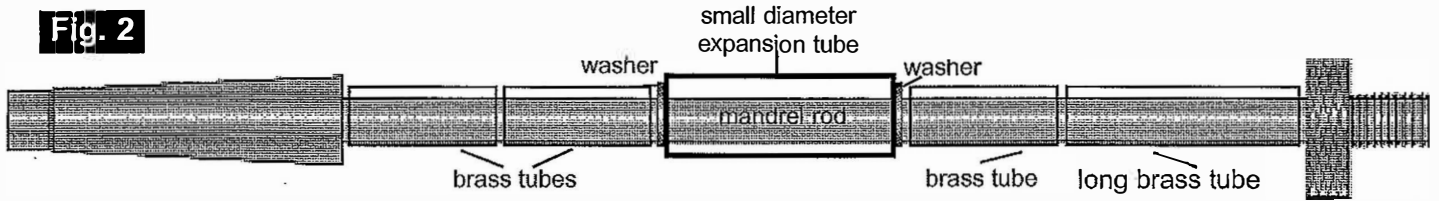


Barrel (Tone Chamber) Mandrel Set Up



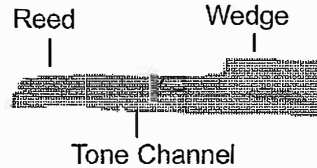
Stopper Mandrel Set Up



Barrel



Reed Assembly



Stopper



Materials: Mandrel Setup (Barrel):

- 1) Call Turning Kit 3000
 - 2) Reed Kit 3030
 - 3) Predrilled Wood Blank* Barrel is drilled with a 3/4" bit, and the stopper with a 31/64" bit.
 - 4) small set turning tools
 - 5) 7mm mandrel with appropriate Morse taper
 - 6) Sanding rolls, 4 pk. 1120
 - 7) HUT PPP™ combo 109, Crystal Coat™ 104
- * When turning keep grain the same as wood was cut.

Mandrel Setup (Stopper):

- 1) Load bushings, brass tubes, washers and 1/2" rubber expansion bushing onto mandrel as as shown. (Fig. 2)
- 2) Noting grain orientation place short blank on mandrel so that insert portion of stopper will be turned on tail stock end. Center over rubber expansion bushings. Tighten knurled nut until blank will not slide.
- 3) Turn as you did in the first setup, however turn so that stopper insert points toward tail-stock.
- 4) Inside end of stopper must be turned down to a diameter that will fit inside the core of the barrel. Using your metal taper gage turn the end to be inserted to a point where the gage just fits over the wood. Note that this size will be slightly over size. Very carefully sand the stopper down to the point where it fits perfectly into the barrel. You will need to remove the brass nut from the mandrel and slide the completed barrel onto the stopper insert a few times to get the ideal fit. Do not remove the stopper, it will alter your alignment.
- 5) To fit expansion tube, cut back side of stopper down to 7/8" and sand. Use rubber O-ring included to make a perfect fit.
- 6) Sand and finish with HUT™ PPP combo, Crystal Coat™ or finish of your choice.

Assembly:

- 1) Place reed on tone board and wedge on top of reed. Holding assembly together press into stopper
- 2) Insert completed stopper into barrel and you are now ready.