

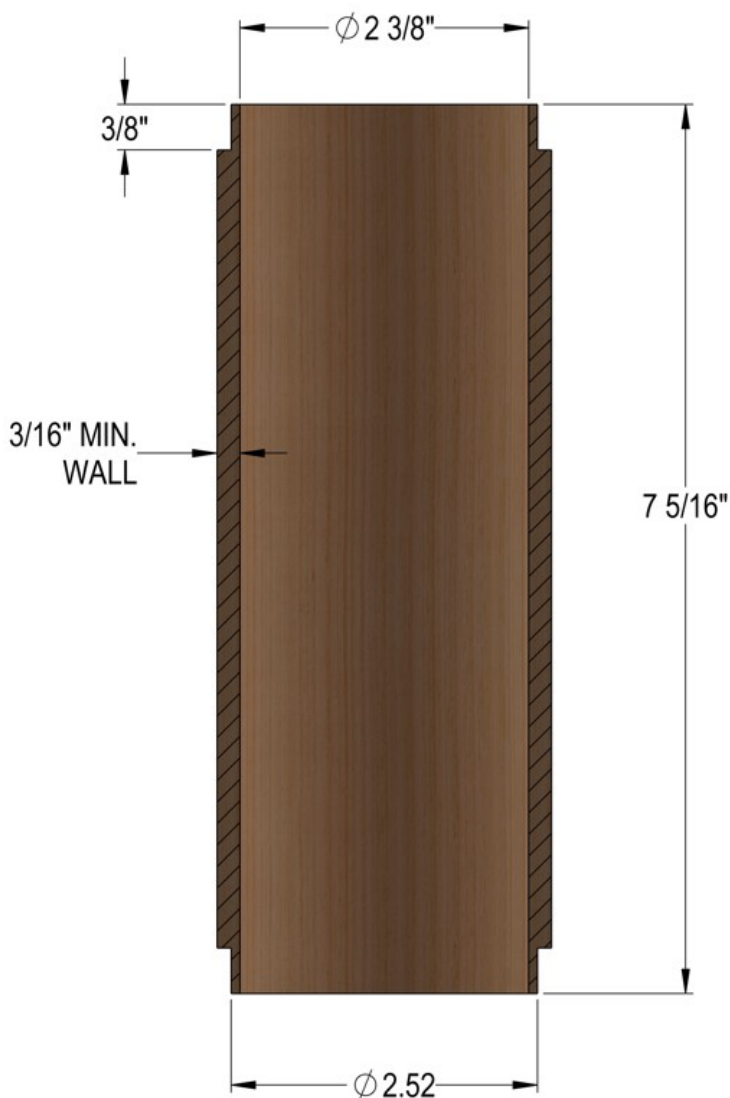
## WoodRiver Insulated Beverage Bottle

Product: #183470

9/7/2022

## Supplies Needed to Complete Kit:

- 2<sup>3</sup>/<sub>8</sub>" Forstner Bit
- 6" Forstner Bit Extensions
- Turning Stock 3" x 3" x 7<sup>5</sup>/<sub>16</sub>"
- Lathe
- Turning Tools
- Drill Press or Lathe Drill Chuck
- Sandpaper
- 5-Minute Epoxy
- Eye & Ear Protection
- Dust Mask



## Boring/Turning/Shaping the Mill:

- Mark centers on both ends of the blank. If using the lathe to bore, mount the blank using a 4-jaw chuck and live center.
- Using a lathe drill chuck, bore a 2<sup>3</sup>/<sub>8</sub>" diameter hole the entire length of the 7<sup>5</sup>/<sub>16</sub>" long blank. It may be necessary to rotate the blank 180 degrees, re-mount onto the 4-jaw chuck to bore completely through.
- Create two jamb chucks to fit snugly into each end of the blank. Mount the blank between centers using a 4-jaw chuck, jamb chucks, and 60° live center.
- Begin by turning the blank to round.
- Next, create the two required tenons. Refer to diagram for measurements. Test fit the Trim Ring and Base Cap to ensure a proper fit.
- Turn blank to your desired profile.
- Sand the blank up to 320 grit.
- Apply a finish of your choice.

## Assembly:

- Using 5 minute epoxy, glue Base Cap (B) to the bottom of the turned body. Apply epoxy to the interior lip of the Base Cap, this will help prevent squeeze out. Be sure to remove any excess glue. Set aside to cure for 5 minutes.
- Next, apply 5 minute epoxy to the upper portion of the interior of the turned body. Insert Bottle (A) into the turned body rotating it as you go.
- Apply epoxy to the interior lip of Trim Ring (C) and install on to the upper tenon. Set aside to cure fully before use.

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