

Large Stainless Steel Bottle Stopper

Supplies Needed

- 11/32" or 5/16" Drill Bit
- 1 1/2" x 1 1/2" x 2" Blank
- 3/8"-16 TPI Drill Tap
- Stopper Mandrel with 1" Bushing
- Glue (Flexible CA or Epoxy)
- Digital Calipers
- Drill Chuck
- Sandpaper/Finish
- Drill or Drill Press
- Eye and Ear Protection

Turning Instructions

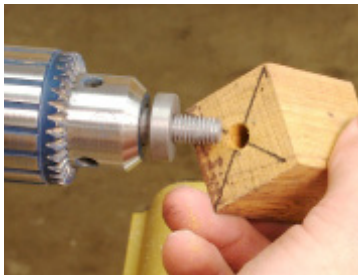
1. Select a blank approximately 1 1/2" diameter by 2" long with the grain running the length of the blank. Square the ends of the blank.



2. Center mark and drill a 11/32" diameter hole about 5/8" deep in the end of the blank. Make sure the drill bit is properly positioned at 90 degrees to the end of the blank prior to drilling so that the blank will seat flat against the mandrel face. *Hint: Wrap masking tape around the drill bit to act as a depth gauge.*



3. Using a 3/8"-16 tpi tap and crescent wrench tap the hole in the blank.



4. Mount the stopper mandrel in a drill chuck mounted in the lathe. Select the 1" dia. bushing and slide it onto the mandrel. Screw the blank onto the threaded portion of the mandrel until it seats firmly against the mandrel face. Secure a revolving center against the end of the blank for support while turning.



5. Turn the blank to shape with the revolving center supporting the work piece. Sand and finish the stopper. Slide the tailstock out of the way to sand and finish the end of the blank. Remove the revolving center and gently turn away the nub left by the revolving center. Sand and finish.

Adding a Decorative Insert (Optional)



1. Measure the diameter of the insert. Scribe the end of the stopper using the sharp points of the caliper to indicate the diameter of the recess required for fitting the insert. *Hint: When scribing the stopper, do so with the lathe turning at a slow speed to prevent a catch.*



2. Turn the recess to the proper diameter and depth. Be sure to check for fit often to avoid turning an oversize recess.



3. Using a flexible instant glue or RTV silicone adhesive, place a small amount of adhesive in the recess and press the insert firmly into place.

Assembly



1. Remove the finished stopper from the mandrel. Place a few drops of thick CA glue or 5 minute Epoxy into the threaded hole of the finished stopper. Screw the finished stopper onto the threaded stud of the bottle stopper. Make sure the turned stopper seats firmly against the shoulder of the stopper for a proper fit.

Bottle Stopper Care

In order to keep your bottle stopper looking and performing as new, please follow the recommendations below:

- DO NOT store a bottle on its side as constant pressure from within may loosen the stopper resulting in a spill.
- Wash the stopper periodically in warm water and polish as needed.
- Hand wash only.