

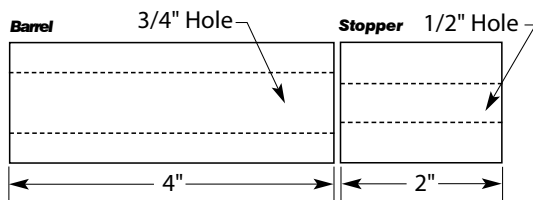
Turning a Pioneer Deer Call

Supplies Needed

- 1 1/2" x 1 1/2" x 6" Blank
- Pioneer Deer Call
- 3/4" WoodMaster Mandrel
- 1/2" WoodMaster Mandrel
- Glue (Thick CA or Epoxy)
- Sandpaper/Finish
- Drill or Drill Press
- Eye and Ear Protection
- 1/2" Drill Bit
- 3/4" Drill Bit

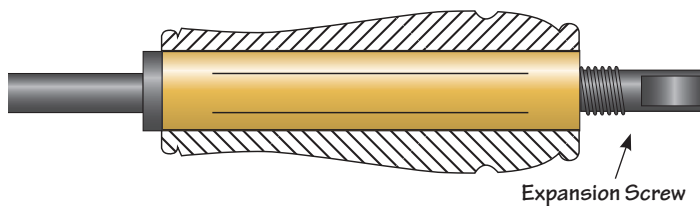
Wood Preparation

1. Select a blank 1-1/2" x 1-1/2" x 6".
2. Cut the blank to the sizes listed below.
3. Mark and drill the blanks as shown below. 3/4" diameter hole for the barrel. 1/2" diameter hole for the stopper.



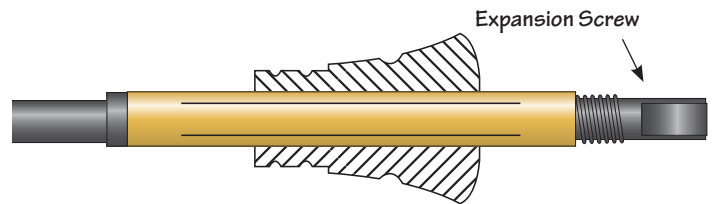
Turning the Barrel

1. Mount the 3/4" WoodMaster mandrel into a drill chuck or collet chuck.
2. Slide the blank onto the mandrel and tighten the expansion screw so the blank will not slip while turning.
3. Turn the blank to the desired shape. Note: make a 3/16" wide groove for the lanyard if so desired.
4. Sand and finish all exposed surfaces of the barrel.



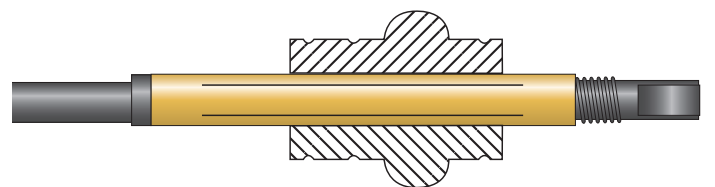
Turning the Stopper

1. Mount the 1/2" WoodMaster mandrel into a drill chuck or collet chuck.
2. Slide the blank onto the mandrel and tighten the expansion screw so the blank will not slip while turning.
3. Turn a 3/4" dia. tenon that will fit into the barrel. Use a set of calipers to size the tenon. Test the fit of the stopper tenon by stopping the lathe, and sliding the barrel over the end of the mandrel and onto the stopper tenon. This step may need to be repeated several times. **Do not to remove the stopper from the mandrel, as this will alter the alignment.**
4. Cut a two grooves in the tenon using the point of a skew to accept the o-rings. The o-rings should be slightly proud of the tenon and no larger or this will cause fitment issues.
5. Sand and finish all exposed surfaces of the turned stopper.



Turning the Stopper with Deer Extension Tube

1. Mount the 1/2" WoodMaster mandrel into a drill chuck or collet chuck.
2. Slide the blank onto the mandrel and tighten the expansion screw so the blank will not slip while turning.
3. Turn a 3/4" dia. tenon 1/2" long, that will fit into the barrel. Use a set of calipers to size the tenon. Test the fit of the stopper tenon by stopping the lathe, and sliding the barrel over the end of the mandrel and onto the stopper tenon. This step may need to be repeated several times. **Do not to remove the stopper from the mandrel, as this will alter the alignment.**
4. Turn a 7/8" diameter tenon 7/8" long on the other end of the stopper to fit the expansion tube.
5. Cut the o-ring grooves on the tenons using the point of a skew. (see figure below)
6. Sand and finish all exposed surfaces of the turned stopper.



Assembly

1. Install the o-rings into the grooves cut on the stopper.
2. Slide the o-ring over the tone board. Slide the reed through the o-ring to create the reed assembly.
3. Insert the reed assembly with the wedge into the stopper.
4. If using the extension tube. Slide the extension tube over the stopper.

