

BOTTLE STOPPER KIT

COMPLETE KIT CONTENTS:

- Chrome plated bottle stopper
- Threaded coupler insert
- 6 ring silicon or cork stopper

OTHER NECESSARY ITEMS:

- Bottle stopper screw chuck kit
- #PK-BS1-M for 3/4" x16" tpi lathe
- #PK-BS1-MJ for 1"x8 tpi lathe
- Alternate: PSI screw chuck #PK-TOP-M or 4 prong drive center (#1MT only) with a 3/16" and 3/8" dia. drill bit
- 23/64" drill bit (included in PK-BS1 kits above)
- 2 part epoxy or insta-cure CA glue

Note: For best results and a high production rate, use our bottle stopper screw chuck kit. If not available, use #PK-TOP-M, or a 4 prong drive center. Either will require enlarging the mounting hole to 3/8" for assembly.

PREPARING THE BLANK FOR TURNING:

The blank size will vary based on your top profile design. Generally, the blank size is 1-1/2" square x 2" 1/2" to 3" long

USING PSI BOTTLE STOPPER SCREW CHUCK:

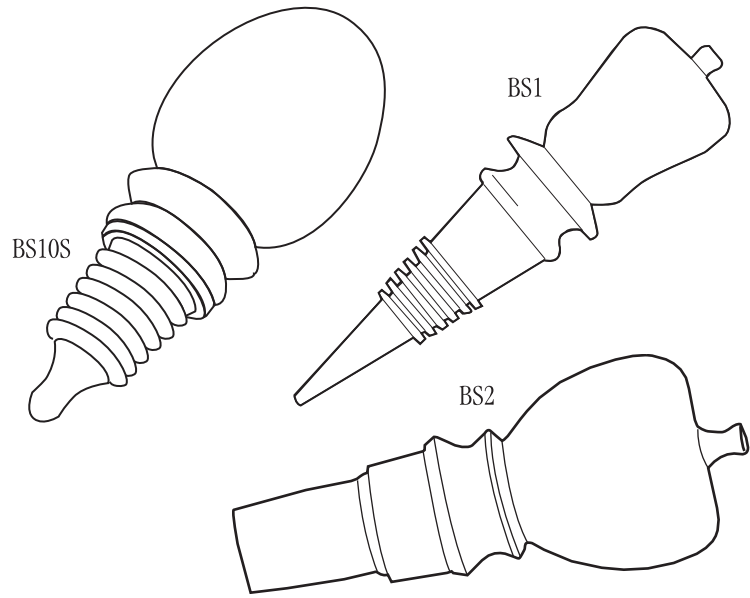
- Mount the chuck on the head stock spindle.
- Mark the center of the end of the blank.
- Drill a 23/64" diameter hole, 3/4" deep in the wood.
(You may want to saw off the corners of the blank before turning.)
- **Option: Drill a 5/16 hole and tap a 3/8 x 1/16 tpi thread**
- Mount the wood blank by screwing the exposed thread into the hole you drilled. Hand tighten.
- Secure the blank by engaging the tail stock live center for support. The wood is now ready to turn.

USING A SCREW CHUCK OR 4 PRONG DRIVE CENTER:

- Mark the center of the end of the blank.
- Drill a 3/16" diameter pilot hole 3/4" deep in the wood at the center.

For a screw chuck: Affix the screw chuck to be used on the lathe spindle. Thread the blank on the center screw until it bottoms.

For a drive center: Mark the center of the opposite end of the blank. Affix the drive center by tapping it into the pilot hole you drilled. Mount both into the morse taper in the head stock spindle. Bring in the tail stock until the tip of the live center firmly supports the blank for turning.



TURNING THE WOOD:

Turn the wood to your chosen profile. The end diameter at the base of the wood should match the chuck diameter or turn down to 31/32" diameter to match the Chrome stopper outside diameter. Finish and polish the top to your specifications. Remove the top off the lathe.

ASSEMBLY:

If you used the bottle stopper chuck, spread either CA or 2 part epoxy glue over the extended threads of the stopper. Screw in the wood on to the stopper threads leaving no gap.

If you used either the screw chuck or the drive center, you must enlarge the 3/16" hole.

To do so, you have to set the finished stopper top in a fixture to hold it secure while you re-drill the larger hole.

To do so, you have to set the finished stopper top in a fixture to hold it secure while you re-drill the larger hole. To do this, make a jamb chuck by drilling a large hole in a wood blank (approximately 1" diameter).

Place the top in this hole upside down protecting the finished surface from scratching. Now re-drill a 3/8" diameter hole over the 3/16" pilot hole, 11/16" deep.

Spread glue over the extended thread of the stopper.

Insert and push the thread into the hole in the top to close the gap.

When dry, the bottle stopper is ready to use.