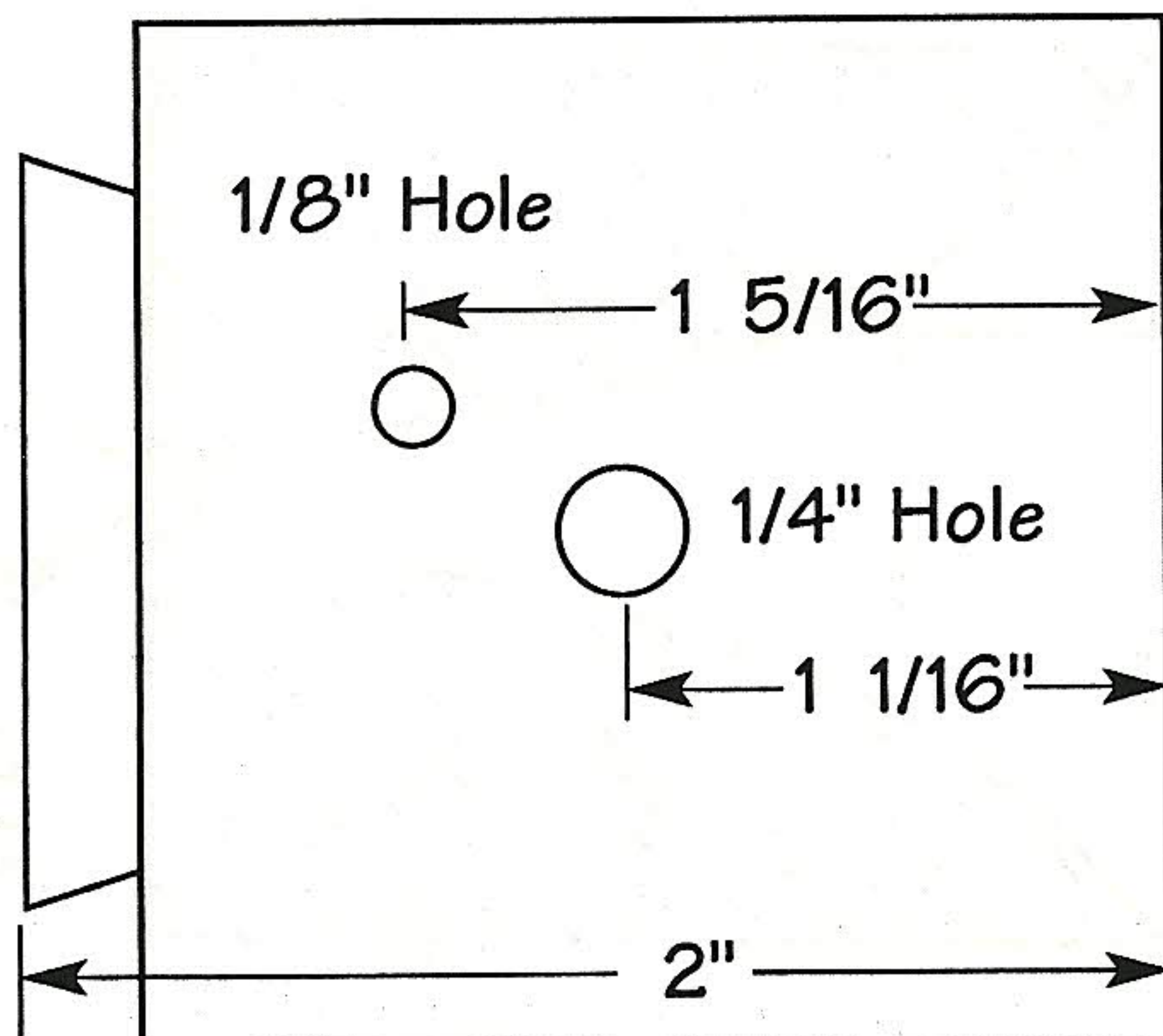


Birdhouse Ornament #2

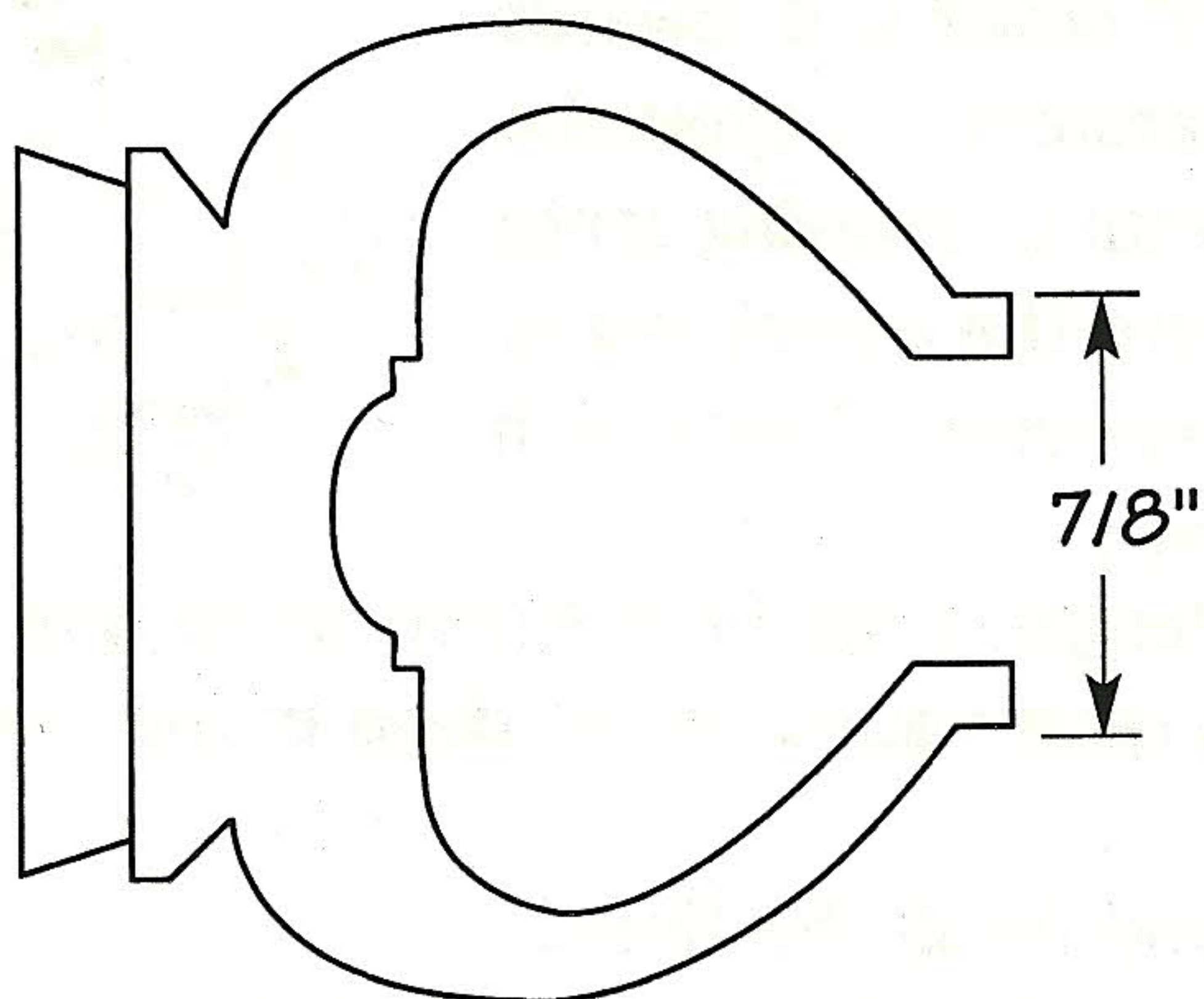
Craft Supplies USA

Turning the Body

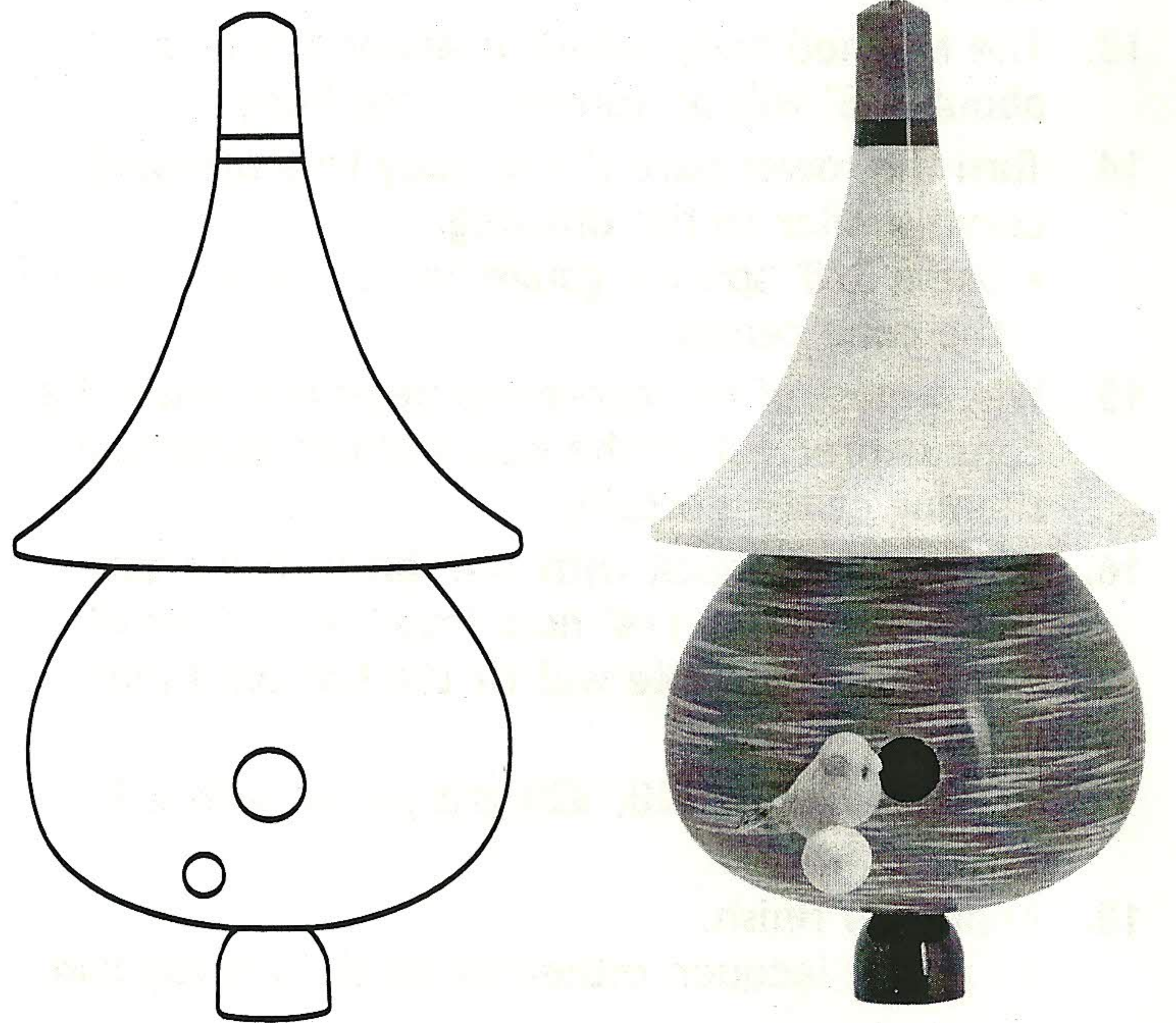
1. Turn a cylinder to 2" diameter and 2" long.
2. Square the ends with a parting tool and cut a 5° shoulder on the bottom end for holding the cylinder in a chuck.
3. Decide on the front of the body and mark the entrance hole.
 - Center punch the hole point.



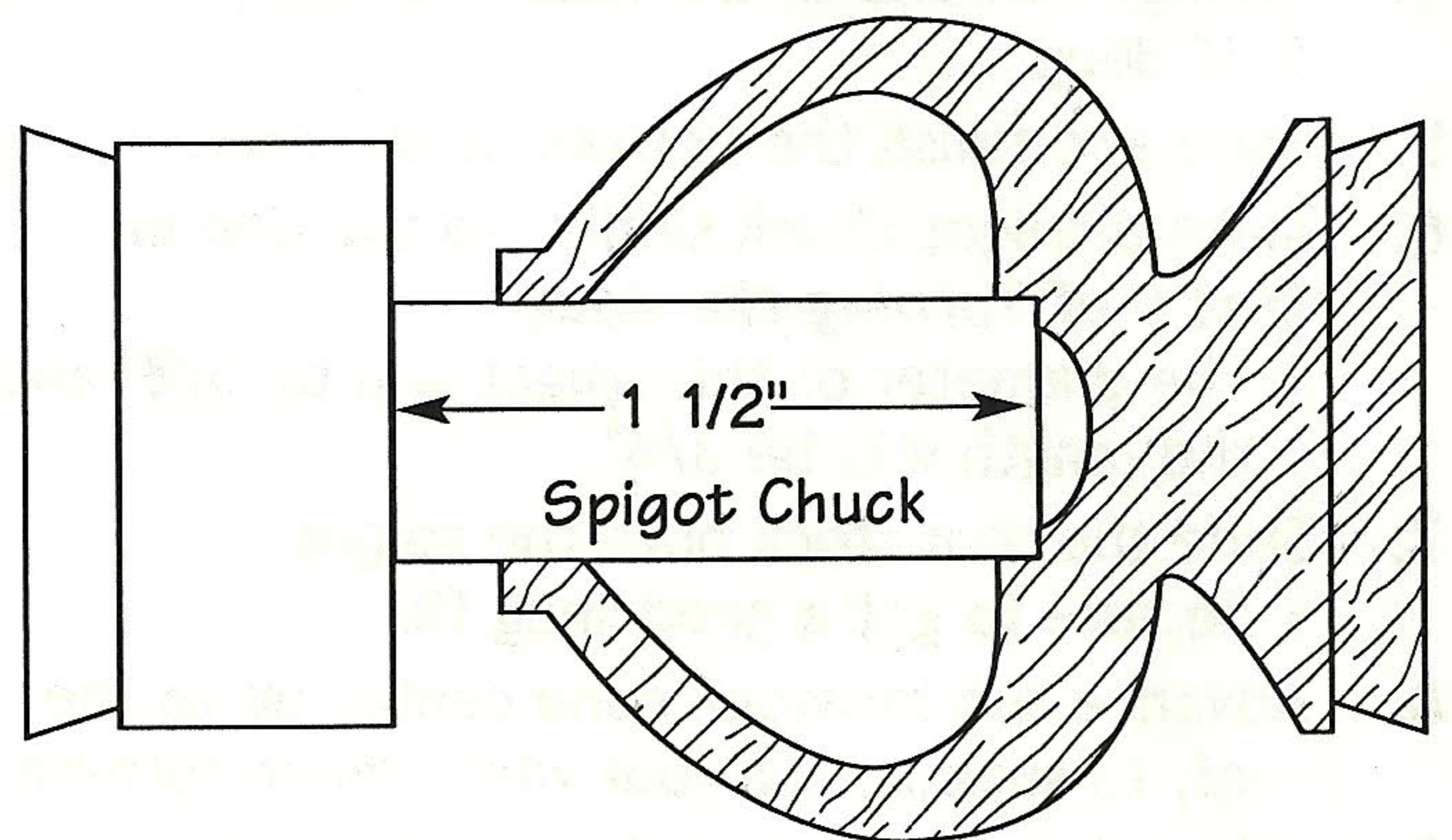
4. Drill the 1/4" entrance hole 1/4" or so deep.
 - Use a V-Block.
5. Place the body in a chuck.
 - Use the skew point to make a small entry hole so the drill bit will be on center.
6. Drill a 5/8" hole to a depth of 1 1/4".
 - Don't go too deep.
7. Turn the outside to shape, as much as you can without hitting the chuck jaws.
 - Leave a 1/8" shoulder at the outside of the opening, with a diameter of 7/8".
 - This shoulder will fit into the top.



8. Hollow out the body to remove wood and make the ornament feel lighter.
 - Leave a wall thickness of 1/8" or so.
 - Be sure to leave part of the drill hole in the bottom and don't turn away any of the drill hole at the opening. These areas are used to hold the body in place on a spigot chuck while the bottom of the body is completed.



9. Prepare the stock and turn a spigot chuck to the following dimensions. Check plan #1, step 14 through 17 for details.
 - The spigot will be 5/8" diameter by 1 1/2" long.
 - Check the diameter with a 5/8" wrench.



10. Slide the body onto the spigot. The fit should be snug but not too tight, or the body may crack if forced over the spigot.
 - If it is too loose, use masking tape or paper tissue to obtain the desired fit.
11. Rotate the assembly by hand to be sure it is running true.
 - If it is out a 1/16" or so, this shouldn't be a problem.
 - If it is out too much, make the necessary adjustments.

