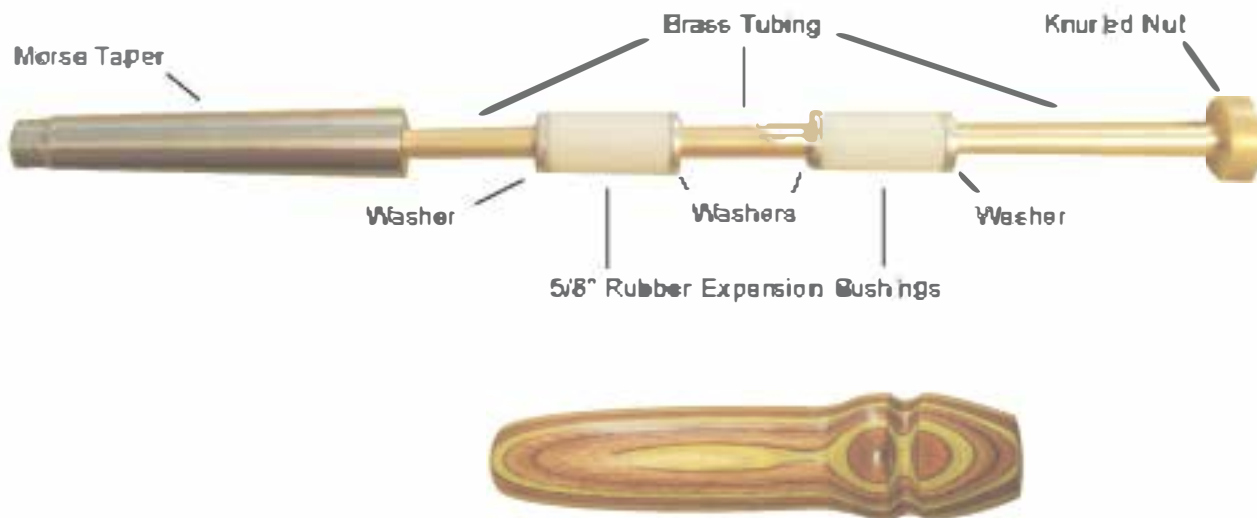


Echo Inserts

Barrel (Tone Chamber) Mandrel Set Up



Materials:

1.5x 4" Blank
drilled with 5/8" Bit

Bushings 5/8" Hole
- Duck Call Barrel
Turning

7mm Mandrel

Sandpaper & Finish

Mandrel Set Up:

- 1) Load 5/8" OD rubber expansion bushings, washers and brass tubes as depicted above.
- 2) Place pre-drilled barrel blank on mandrel and center over rubber bushings. Tighten knurled nut until blank will not slide on rubber bushings. Extra bushings may be required and some mandrels vary in length.
- 3) Make sure your live center is properly placed in the end of the mandrel.
- 4) Turn barrel to desired shape.
- 5) If a lanyard is desired be sure to cut a 3/16" deep cove to hold the lanyard in place.
- 6) On each end of the barrel you will need to round over the openings. One end for comfort and the other end to assist in inserting the mouth piece inset.

Assembly:

Insert mouth piece insert into the barrel and start Calling

