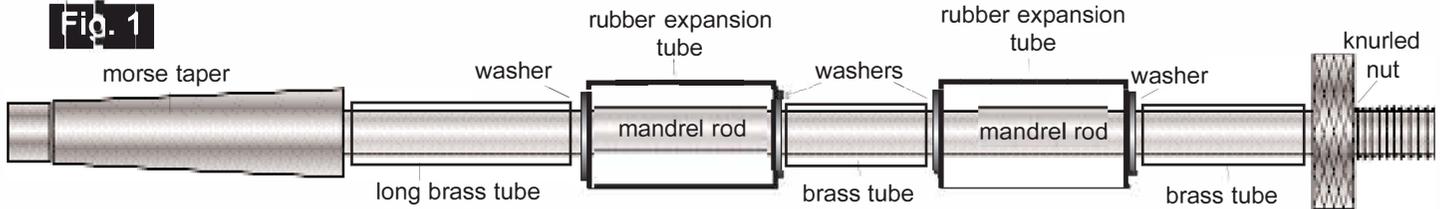




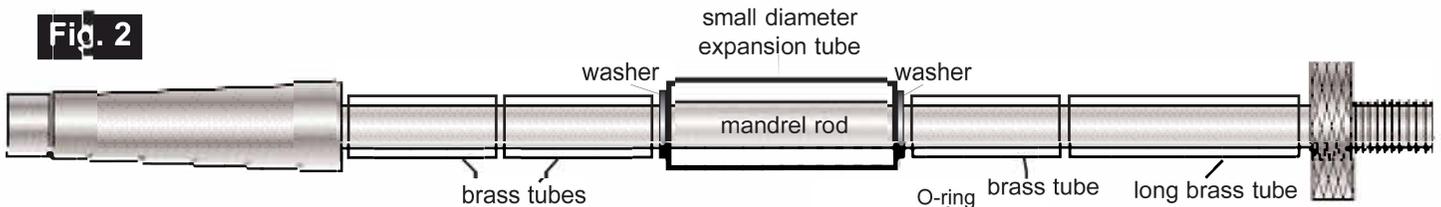
### Barrel (Tone Chamber) Mandrel Set Up

Fig. 1

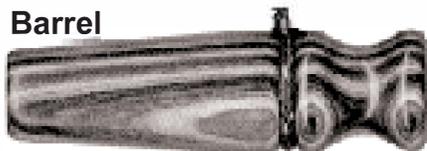


### Stopper Mandrel Set Up

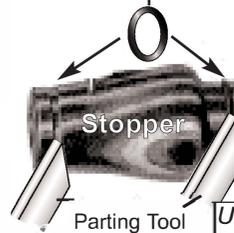
Fig. 2



Barrel



Reed Assembly



Expansion Tube



Using a parting tool, remove a small amount of wood leaving a notch deep enough for the o-ring to fit securely.

#### Materials: Mandrel Setup (Barrel):

- 1) Bushings 3/4" & 31/64" Hole - Game Call Barrel Turning. #3000
- 2) Elk Call Reed Kit #3022.
- 3) 1.5x1.5x6" Blank. Barrel Blank 1.5x4" with a .75" hole and a Stopper Blank (1.5 X 2") drilled with a 31/64" drill bit.
- 4) 7mm Mandrel.
- 5) Sandpaper and Finish of your choice.

- 1) Load large 3/4" OD rubber expansion bushings, metal bushings, washers and brass tubes as depicted. (Fig. 1)
- 2) If possible corners of blanks should be removed using a band saw or similar tool to aid in turning.
- 3) Place Large predrilled barrel on mandrel and center over bushings. Tighten knurled nut until blank will not slide on rubber bushings. Extra bushings may be necessary, some 7mm mandrels vary in length.
- 4) Make sure your live center is properly placed in the end of the mandrel.
- 5) Elk call bugle designs can vary just as the people who turn them.
- 6) If a lanyard is to be used remember to cut a small cove (groove) approximately 3/16" deep for the cord to rest in.
- 7) On each end of the barrel you will need to round over the openings; The mouth end for comfort and the stopper end for easy insertion of the stopper

\* When turning keep grain the same as wood was cut.

#### Mandrel Setup (Stopper):

- 1) Load bushings, brass tubes, washers and 1/2" rubber expansion bushing onto mandrel as shown. (Fig. 2)
- 2) Noting grain orientation place short blank on mandrel so that insert portion of stopper will be turned on tail stock end. Center over rubber expansion bushings. Tighten knurled nut until blank will not slide.
- 3) Turn as you did in the first setup, however turn so that stopper insert points toward tail-stock.
- 4) Inside end of stopper must be turned down to a diameter that will fit inside the core of the barrel. Using your metal taper gage turn the end to be inserted to a point where the gage just fits over the wood. Note that this size will be slightly over size. Very carefully sand the stopper down to the point where it fits perfectly into the barrel. You will need to remove the brass nut from the mandrel and slide the completed barrel onto the stopper insert a few times to get the ideal fit. Do not remove the stopper, it will alter your alignment.
- 5) To fit expansion tube, cut back side of stopper down to 7/8" and sand. Use rubber O-rings included to make a perfect fit.
- 6) Sand and finish with HUT PPP™ combo, Crystal Coat™ or finish of your choice.

#### Assembly:

- 1) Place round end of reed assembly into insert end of stopper.
- 2) Insert completed stopper into barrel and you are now ready.