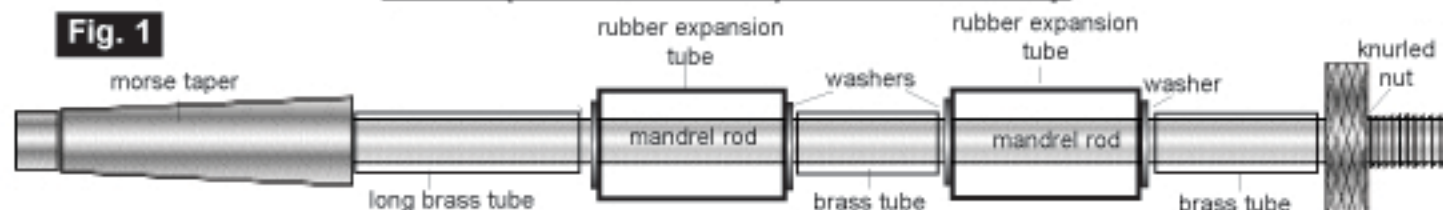


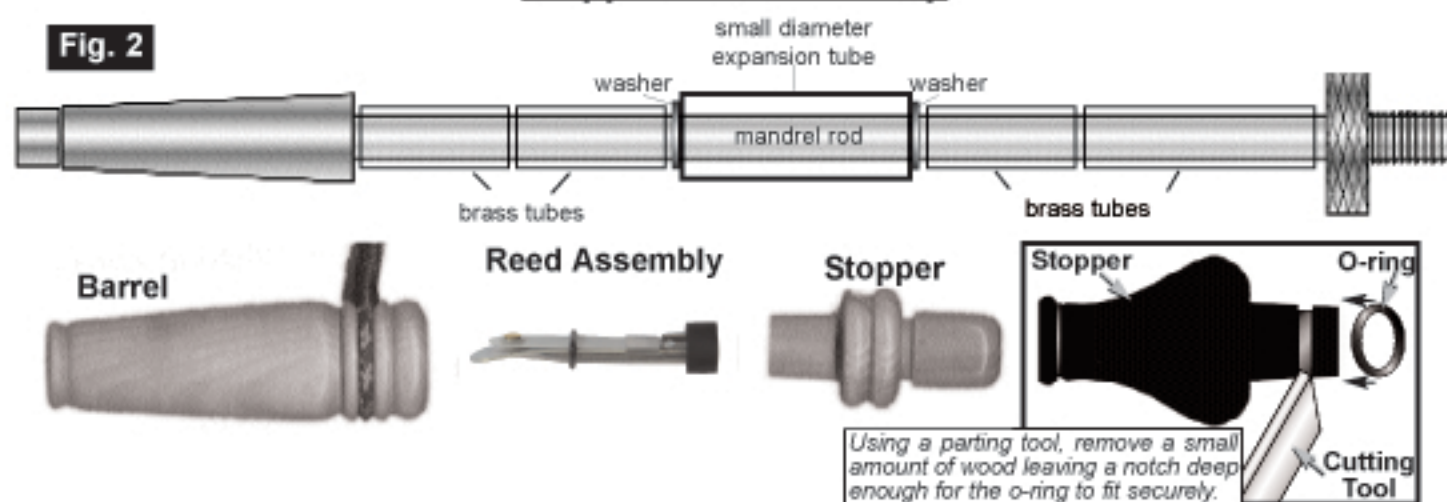
Barrel (Tone Chamber) Mandrel Set Up

Fig. 1



Stopper Mandrel Set Up

Fig. 2



Materials:

- 1) Call Turning Kit 3000
- 2) Metal Buck Deer Call Kit 3058
- 3) Predrilled Wood Blank* or Drill the Barrel with a 3/4" Drill bit and the Stopper with a 31/64" Drill bit.
**Typical Barrel length is 4" and the Stopper is 2"
- 4) Small set turning tools
- 5) 7mm mandrel with appropriate Morse taper
- 6) Sanding rolls, 4 pk. 1120
- 7) HUT PPP™ combo 109, Crystal Coat™ 104, or finish of your choice.*

Mandrel Setup (Barrel):

- 1) Load large 3/4" OD rubber expansion 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) Duck call 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, 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 tailstock.
- 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) Sand and finish with HUT PPP™ combo, Crystal Coat™, or a finish of your choice.

Assembly:

- 1) Place round end of reed assembly into insert end of stopper. You may need to sand the hole for a proper fit. The shoulder of the call should stick out from the stopper.
- 2) Insert completed stopper into barrel and you are now ready to call ducks!

Note:

If you desire to use a Deer expansion hose P3021E, turn the outside end of the Stopper down to accommodate the Deer expansion hose. An additional O-ring may be used for a snug fit