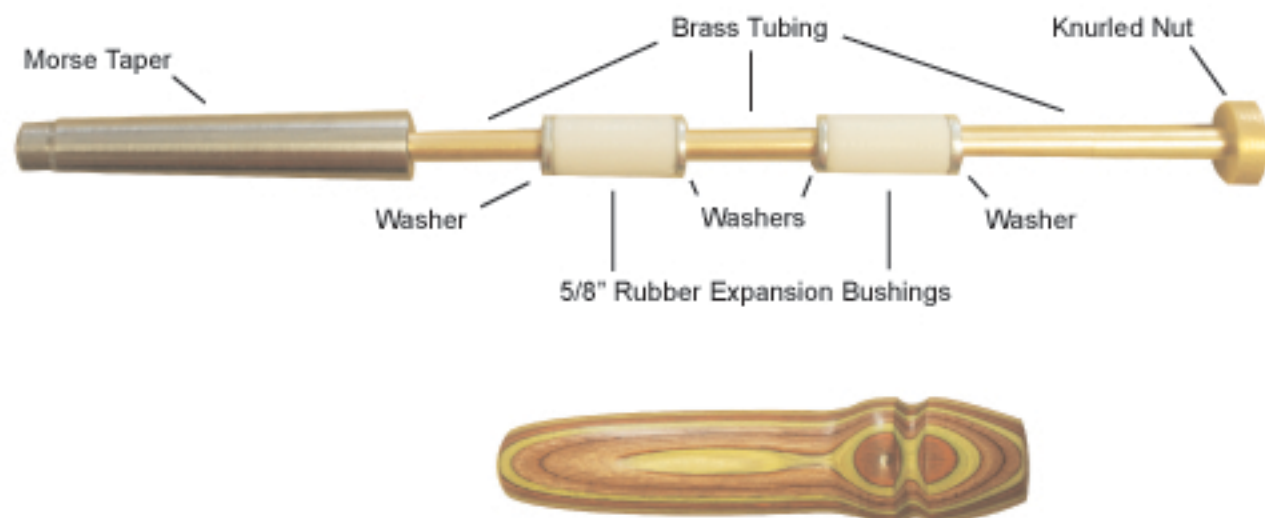


Barrel (Tone Chamber) Mandrel Set Up



Materials:

- 1) STAT Turning Kit 3600
- 2) STAT Insert
- 3) 5/8" Predrilled Wood Blank
- 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 5/8" OD rubber expansion bushings, washers and brass tubes as depicted.
- 2) If possible corners of blanks should be removed using a band saw or similar tool to aid in turning.
- 3) Place predrilled barrel on mandrel and center over rubber 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. We have included drawing of some of the more popular designs.
- 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

Assembly:

- 1) **OPTIONAL**- If the O-ring is used in the groove on the STAT insert. When doing this you may need to open up the hole in the barrel with some sandpaper or a slightly larger drill bit.
- 2) Press STAT insert into barrel and you are now ready to call ducks!

