

Shotgun Bottle Stopper Kit

Inserted Cartridge Style • Slip-On Style

Kit Features:

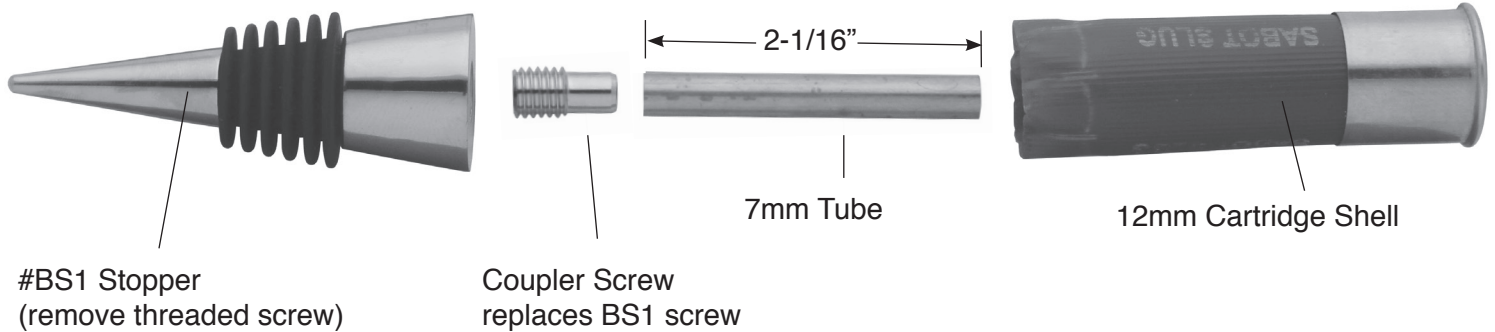
- Bottle Stopper accepts 12ga Shotgun Shells
- Turn on a mandrel
- 2 style stoppers from the same kit

Required Accessories:

- 7mm Pen Mandrel
- Drill Bit: 7mm #PK-7MM
- 13/16" Forstner Bit: #KSEG-DB
- #BS12GABU Bushing set (2 pc)
- Live Tailstock Center
- 2 Part Epoxy Glue or Insta Cure (Cyanoacrylate) Glue
- Pen Blank: Minimum Size: Style A - 1-1/2" x 1-1/2" x 2"
Style B - 1-1/4" x 1-1/4" x 2"



PARTS LAYOUT DIAGRAM



Preparing the Blank:

Inserted Style

- Cut 1 blank to 1-1/2" square to the length of the tube.
- Drill a 13/16" hole, 5/16" deep.

Slip-On Style

- Cut 1 blank to 1-1/4" to 2" square to the length of the tube

Both Styles

- Drill a 7mm hole lengthwise through the center of the blank.
- Spread glue over the tube, insert the blank with a twisting motion to spread the glue evenly inside. Center the tubes lengthwise inside the blanks.
- When the glue is dry, square the ends of the blanks.

Preparing the Cartridge:

Use a band saw to cut cartridge to size

- For inserted style A, cut to about 13/16".
- For slip-on style B, cut to about 5/8".
- Cut a 1/4" ring as shown as a sizing sleeve. (Used when turning)

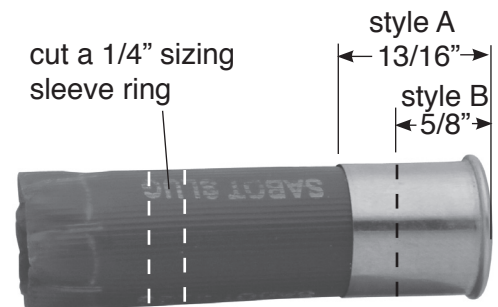
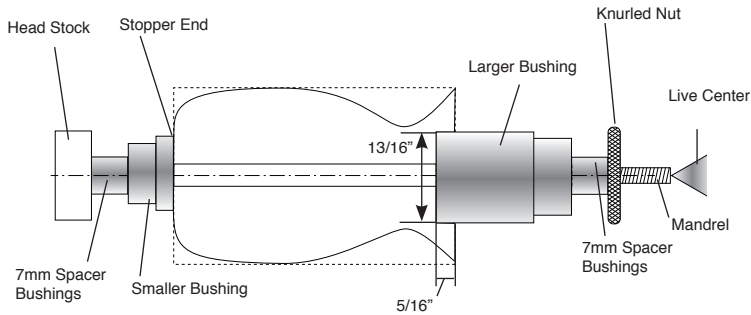


DIAGRAM A / Inserted Cartridge Style A



Turning the Inserted Style A Blank

- Mount the bushings and blank over the mandrel as shown in Diagram A. The larger end of the larger bushing should fit inside the drilled 13/16" hole. Turn the blank to your design.
- Sand and finish the blank.

Turning the Slip-On Style B Blank

- Mount the bushings and blank over the mandrel as shown in Diagram B. Turn the blank with a bead or similar design (profile). Turn the blank to the large bushing diameter. Next turn the larger bushing around (Diagram C). Cut a tenon 5/16" deep to match the smaller diameter of the bushing. Use the sizing sleeve (cut from the cartridge) to size the outside diameter of the tenon. Tape the sleeve to the bushing while turning the tenon.
- If a cylinder profile is preferred, turn the smaller bushing on the stopper end around and reverse the cartridge bushing to cut the tenon.
- Sand and finish the blank.

DIAGRAM B / Slip-On Cartridge Style B

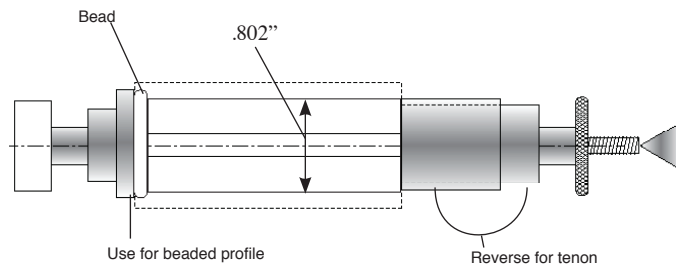
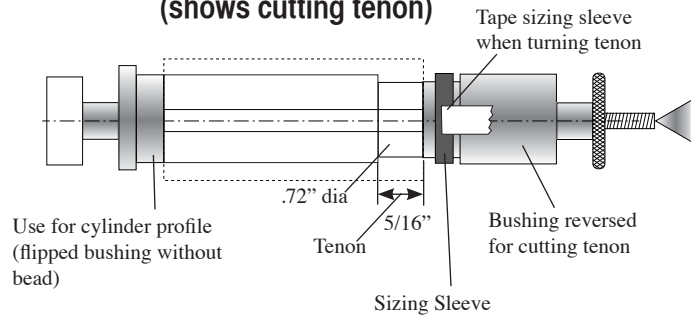


DIAGRAM C / Slip-On Cartridge (shows cutting tenon)



Assembly

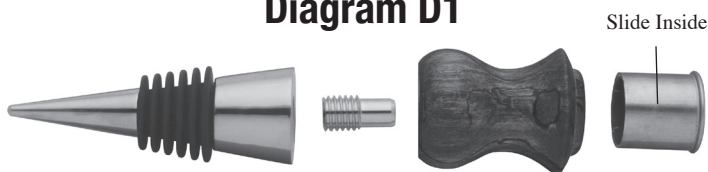
Inserted Style A (Diagram D1):

- Press the coupler screw into the stopper end of the blank. Remove the screw off the original stopper.
- Squeeze 2 drops of glue into the hole. Seat the cut-off cartridge inside the glued hole. Let dry.
- Screw the assembly into the #BS1 stopper.

Slip-On Style B (Diagram D2):

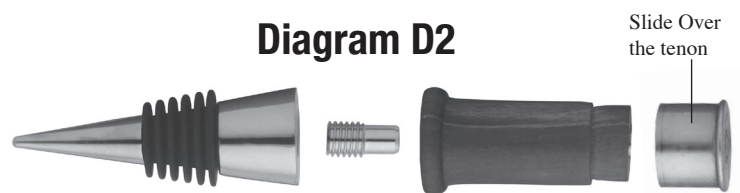
- Press the coupler screw into the stopper end of the blank. Remove the screw off the original stopper.
- Squeeze 2 drops of glue onto the tenon. Install cut-off cartridge over the tenon. Let dry.
- Screw the assembly into the #BS1 stopper.

Diagram D1



**Style A Assembly
Inserted**

Diagram D2



**Style B Assembly
Slip-On**

Diagram E / Bushings #BS12GABU

