

# Bottle Stopper Kit

## Features

- **#BS8** chrome-plated bottle stopper
- **#BS8TN** Gold TN-plated bottle stopper
- **#BS8BT** Black TN-plated bottle stopper
- Threaded coupler insert

## Required accessories

- Bottle stopper screw chuck kit
- #PK-BS1-M** for 3/4"x16 tpi lathe
- #PK-BS1-MJ** for 1"x 8 tpi lathe
- 23/64" drill bit (included in **#PK-BS1-MJ** kits above)
- 2-part epoxy or insta-cure cyano acrylate (CA) glue.

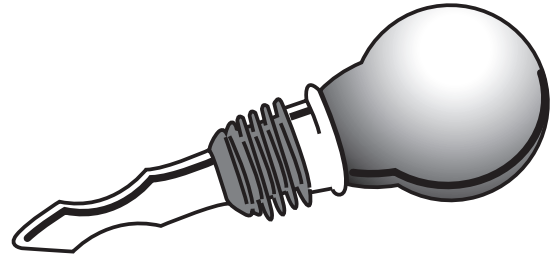
**Note:** For best results and a high production rate, use our bottle stopper screw chuck kit.

## Preparing the blank for turning

The blank size will vary based on your top profile design. Generally, the blank size is 1-1/2" to 2" square x 2 to 2-1/2" long.

## Using PSI bottle stopper screw chuck

- Mount the chuck on the head stock spindle.
- Mark the center of the end of the blank.
- Drill a 23/64" diameter hole 3/4" deep in the wood.  
*(You may want to consider sawing off the corners of the blank before turning.)*
- Mount the wood blank by screwing the exposed thread into the hole you drilled. Hand tighten. Secure the blank by engaging the tail stock live center for support. The wood is now ready to turn.



## Using a screw chuck or 4-prong drive center

- Mark the center of the end of the blank.
- Drill a 3/16" diameter pilot hole 3/4" deep in the wood at the center.

*For a screw chuck:* Affix the screw chuck to be used on the lathe spindle. Thread the blank on the center screw until it bottoms.

*For a drive center:* Mark the center of the opposite end of the blank. Affix the drive center by tapping it into the pilot hole you have drilled. Mount both into the morse taper in the head stock spindle. Bring in the tail stock until the tip of the live center firmly supports the blank for turning.

## Turning the Wood

Turn the wood to your chosen profile. The end diameter at the base of the wood should match the chuck diameter or turn down to 31/32" diameter to match the stopper outside diameter. Finish and polish the turned wood, then remove from the lathe.

## Assembly

Spread either cyano acrylate (CA) or 2 part epoxy glue over the extended threads of the stopper.

1. Screw in the wood on to the stopper threads leaving no gap.

**Note:** If you used either the screw chuck or a drive center, you must enlarge the 3/16" hole. To do so, you have to set the finished stopper top in a fixture to hold it secure while you re-drill the larger hole. To do this, make a fixture by drilling a large hole in a wood blank. Place the top in this hole upside down protecting the finished surface from scratching. Now re-drill a 3/8" diameter hole over the 3/16" pilot hole, 11/16" deep.

2. Spread glue over the threaded end of the stopper.
3. Insert and push the threaded end into the hole in the top to close the gap.
4. When dry, the bottle stopper is ready to use.