The "Handy" One Handed Pepper Grinder Kit

KIT FEATURES:
- Stainless Steel components
- Reliable, one handed grinding function
- Simple refill feature for peppercorns
- Easy to turn with single size internal hole
- Overall Length: 6”

REQUIRED ACCESSORIES:
- Mandrel Jam Chuck System: #PKMJAM -includes jam chucks for both ends (Requires lathe with #2 Morse Taper)
- 60° Live Tailstock Center: #LCENTLTx or Mandrel Saver #PKMSTS2
- 1” Forstner Bit: #FB1
- Forstener Bit Extension: #FEX
- 2 Part Epoxy Glue
- Blank Minimum Size: 1-1/2”x1-1/2”x3-13/16”

Optional accessories:
- Lathe chuck equipped with jaws closing smaller than 1/4”
- 1” Jam Chuck: #CJAM1 or shop made jam chuck
- Large Blank Lathe Drilling Chuck: #CSCPENCHK2

DIAGRAM A / PARTS LAYOUT

PREPARING THE BLANK:
- Cut a single blank 3-13/16” long
- Install the 1” Forstner bit in the Bit extension. This will allow you to bore through the entire length of the blank.
- Drill a 1” hole lengthwise through the center.
TURNING THE BLANK:
- Mount your chuck onto the headstock of your lathe.
- Install 60° live center in tailstock.
- Insert 1” Jam Chuck into the chuck and tighten the chuck jaws. Leave enough room to access the nut the shaft of the jam chuck.
- Slide blank onto Jam Chuck and slide tailstock so that the tailstock center is inside the blank.
- Hold the chuck steady and tighten the nut on the Jam Chuck until it starts to grip the inside of the blank.
- Advance the Tailstock until the blank aligns itself onto the tailstock center and finish tightening the Jam Chuck until it firmly grips the blank.
- Lock Tailstock and advance the quill until the blank is firmly held. Do not overtighten as it can split the blank.
- Turn the blank to the profile of your choice. Make sure ends are straight to help ensure an even fit with parts.
- If you wish to turn the profile to match the grinder parts, the ends should be turned down to 1.08” (Use digital calipers to check sizing).
- Sand the blank, gradually increasing sandpaper grits.
- Finish the barrel using your choice of polish. Allow sufficient time for the polish to cure—refer to polish instructions.

ASSEMBLY:
- Arrange parts according to Diagram A.
- Mix a small amount of epoxy and apply to the inside opening of your preferred upper end of the Barrel.
- Slide the Plunger Guide into the glued opening, twisting slightly to spread epoxy evenly.
- Mix a second, small batch of epoxy and apply inside the lower end of the barrel.
- Slide the Grind Chamber into the lower opening, twisting to spread epoxy evenly. Stop inserting when bottom of Grinder Chamber is just barely inside the opening.
- Set aside the glued barrel and allow the epoxy to cure.
- Once epoxy has dried, insert Spring into the wider end of Spring Cover. It should stay in place.
- Insert Plunger Cap into Narrower side of Spring Cover and into Spring opening. It should stay in place.
- Place Shaft Washer over threaded side of Shaft – slide down to Stop Notch.
- Insert Shaft, threaded side first, through the bottom of the Grind Chamber. Push up until it cannot go further.
- Insert assembled Plunger, spring side first, into Plunger Guide. You may have to push to reach Shaft and thread it on. Hold the Shaft on other side accomplish this.
- Insert Grinder Base into bottom of Grind Chamber, using Plunger to guide the Shaft into the opening.
- Thread Grinder Base into Grind Chamber.
- To add peppercorns, unscrew Base from Grinder. When full, re-install Base as described above.