

Instructions for making bases for PKPCx - Stem clips

Project Requirements

- PKCP9 Base Stud Insert (optional)
- PKCP1,2,3,4,... Stem Clip Project Component
- Bottle Stopper Chuck PK-BS1-M for 3/4" x 16tpi lathe
- Bottle Stopper Chuck PK-BS1-MJ for 1" x 8tpi lathe
- Tap & Drill Set BSTAPSET9 (optional)
- 1/16" drill bit #PKDB116 for stem clip with 1/16" shaft
- 3/32" drill bit #PKDB332 for stem clip with 3/32" shaft
- Select a wood blank 1-1/2" square (or larger) x 1-1/4" long (or larger)
- Thin CA glue

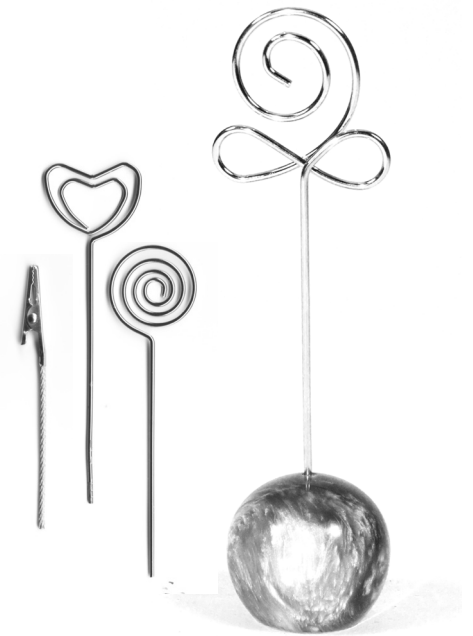
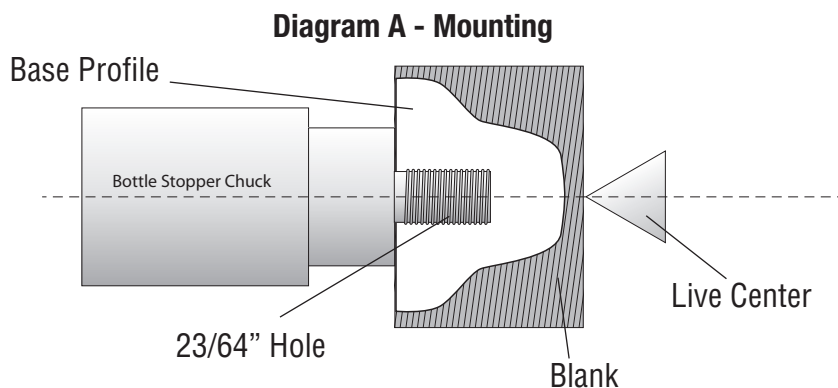


Diagram B - Assembly

Mounting (Dia. A)

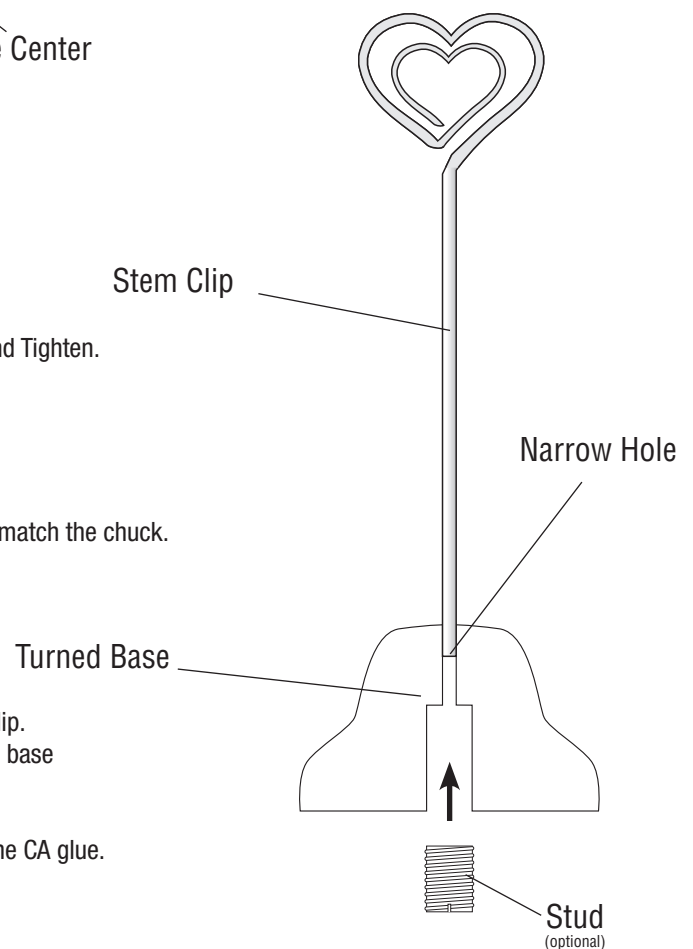
- Mount the chuck on the head stock spindle.
- Mark the center of the end of the blank.
- Drill a 23/64" diameter hole 3/4" deep into the blank.
- Option: Drill a 5/16" hole and tap a 3/8" x 1/16 tpi thread.
- Mount the wood blank by screwing the chuck thread into the drilled hole. Hand Tighten.
- Secure the blank by engaging the tail stock live center for support.

Turning:

- Turn the wood to a small base profile.
Note that the base can be as wide as you require or down to the diameter to match the chuck.
- Finish and polish the wood top.
- Remove the blank from the lathe

Assembly (Dia. B)

- Drill a 1/16" or 3/32" hole into the top of the base to match the stem of the clip.
- Drill through to the larger hole at the base. Put a small amount of CA into the base to feed into the small hole.
- Thread the Base Stud into the exposed hole at the bottom of the base.
- Press the stem into the hole at the top of the base. It should be secured by the CA glue.
- The stud acts as a weight to stabilize the assembly.



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Philadelphia, PA 19115