

## **Thermed Bottle Stoppers**

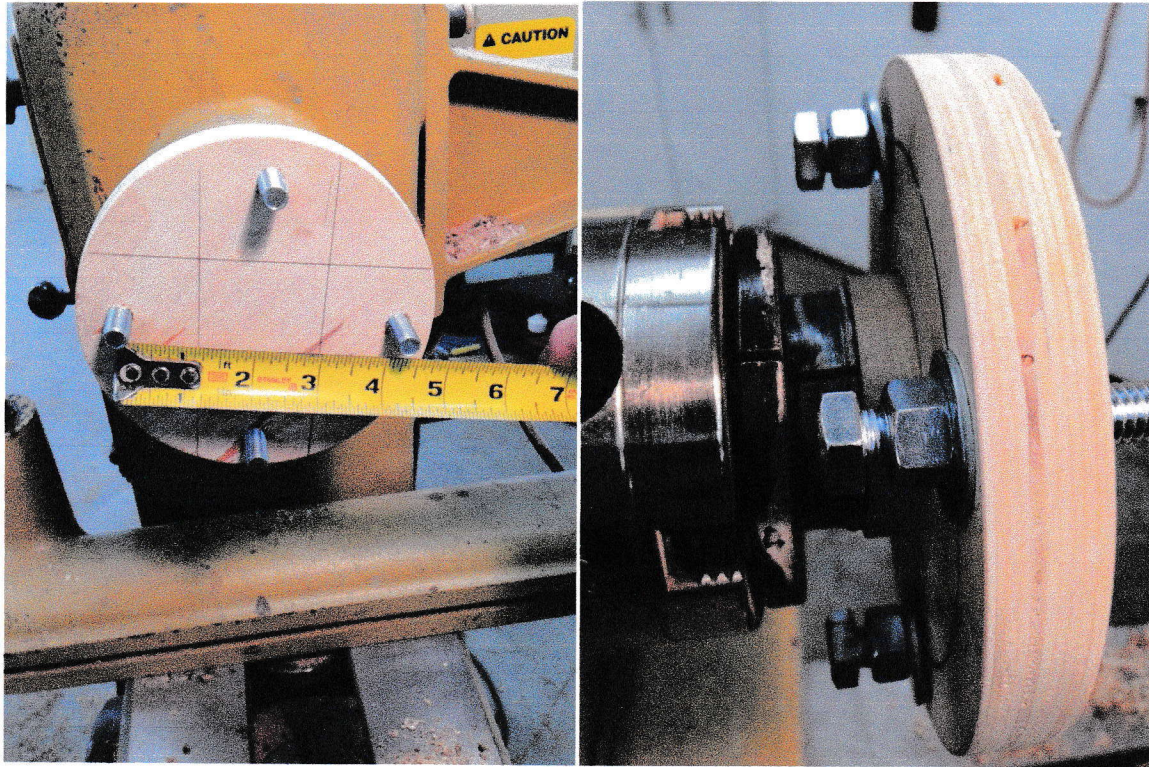
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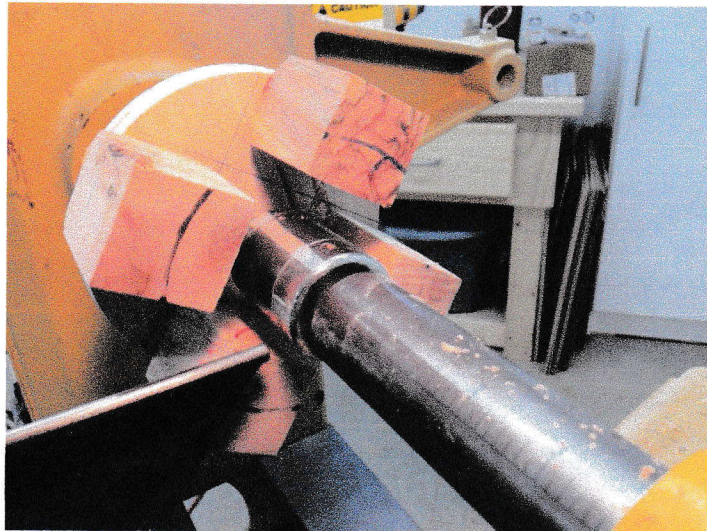
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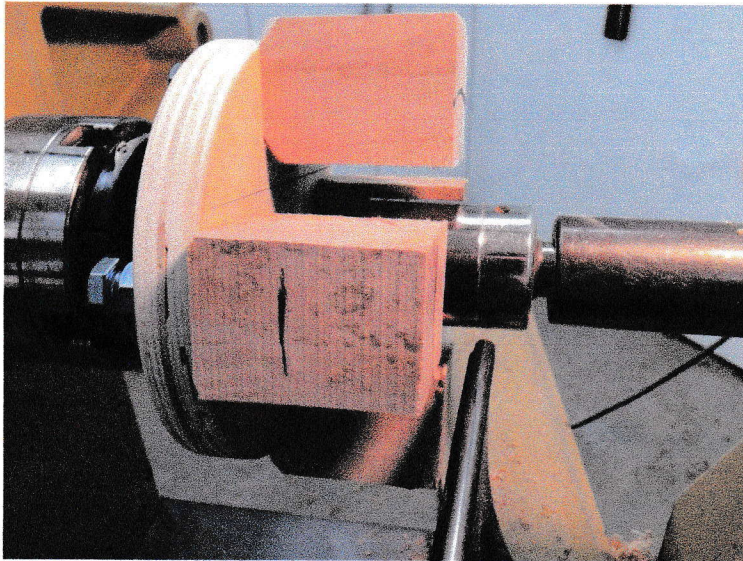
- 1) Select blanks of similar size.
- 2) Drilled and Tapped hole should be perpendicular to the bottom surface of the stopper blank. An easy way to achieve this is drill the hole with the blank in a four jaw chuck on the lathe then face the blank before removing from chuck.
- 3) Using thin CA coat the inside of the drilled hole. This will help cut cleaner threads. Allow abundant time to cure. Gluing the tap in the hole may be considered unpleasant.
- 4) Tap the 3/8 -16 threads in the hole by hand using tap mounted in tap handle.
- 5) Mount the blank on the therming fixture. Screw each bolt in as far as it will go. Use jam nut to pull the blank tight against the fixture.
- 6) Carefully face of the top of the blanks to make them all exactly the same height.
- 7) Find the center of the blanks (on the top) and drawing a line. See Picture 'C'
- 8) Mark a distance from the fixture on the side of the blanks to be turned  $\frac{3}{4}$  or 1 inch are good places to start and will leave enough blank to turn the base. You will develop your own designs to determine this measurement. See Picture 'D'
- 9) Turn a line that connects the mark on the side of the blanks with the center mark in the top of the blanks. See Picture 'E'
- 10) Sand with long strips of paper.
- 11) Loosen jam nut and rotate blanks 90 degrees.
- 12) Repeat finding center and marking sides.
- 13) Turn and Sand.
- 14) Rotate, Turn and Sand but this time you just need to intersect the line create by the first position turned.
- 15) Rotate, Turn and Sand being careful not to damage the tip of the thermed area.
- 16) Dismount. Picture 'F'
- 17) Mount on your typical threaded Bottle Stopper turning jig. Turn base to a shape of your choice. Sand area turned on center. Picture 'G'
- 18) While piece is in fixture do any hand sanding required on the Thermed faces.
- 19) My finish is to dip the turned and sanded piece in Deft wiping lacquer, let dry, buff back with 600 grit or 0000 steel wool then spray with rattle can lacquer. I Beall buff with tripoli and white diamond.
- 20) Drink up!



Fixture is simple enough. Bolts must be fully threaded. I think they call them 'stove bolts'. Good  $\frac{3}{4}$  plywood is fine for this purpose. This fixture has blanks fixed on a 4.25" diameter. They must have room to index and you need clearance to your chuck.

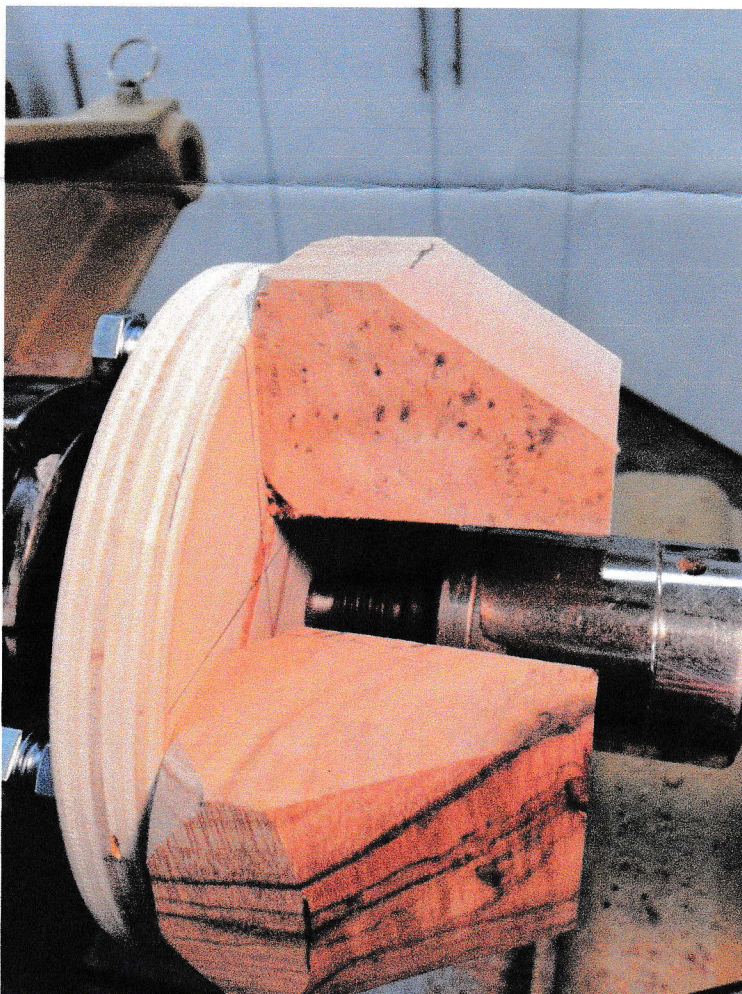


Picture 'C' – do your best to find the center of the blanks but accuracy is not important. You are only creating a target to cut to. Note the tailstock in position for added safety.

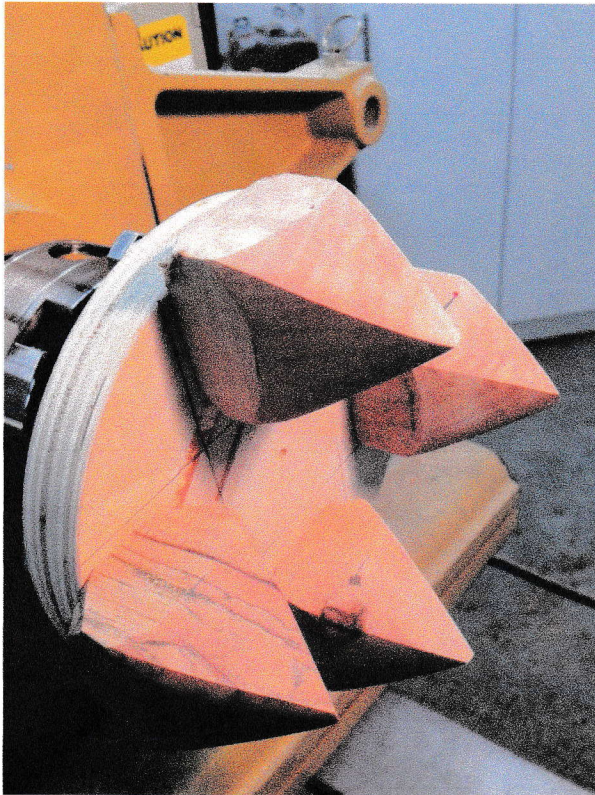


blanks again creating a target to cut to.

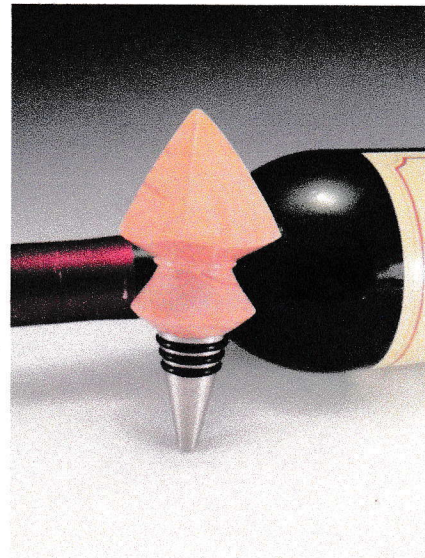
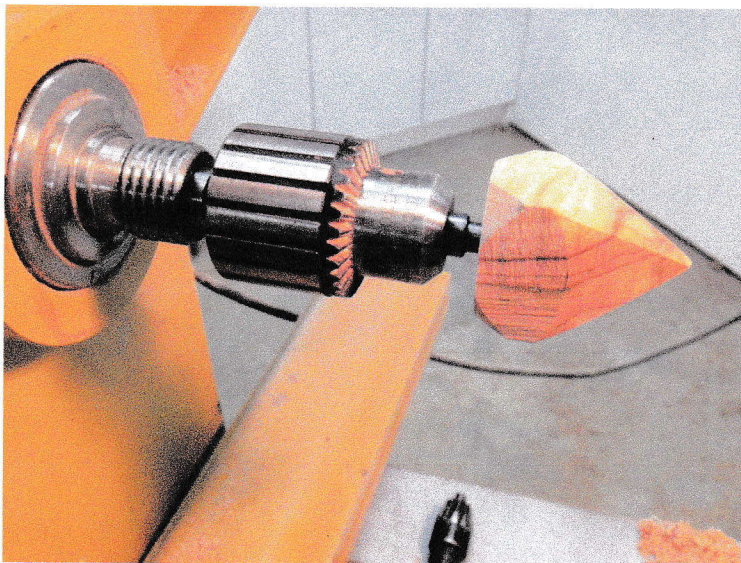
Picture 'D' – mark the sides of the



Picture 'E' after turning first side.



Picture 'F' - All four sides are turned (thermed0 and sanded. Ready for dismount.



Picture 'G' – Ready for turning the base, sanding and finishing.