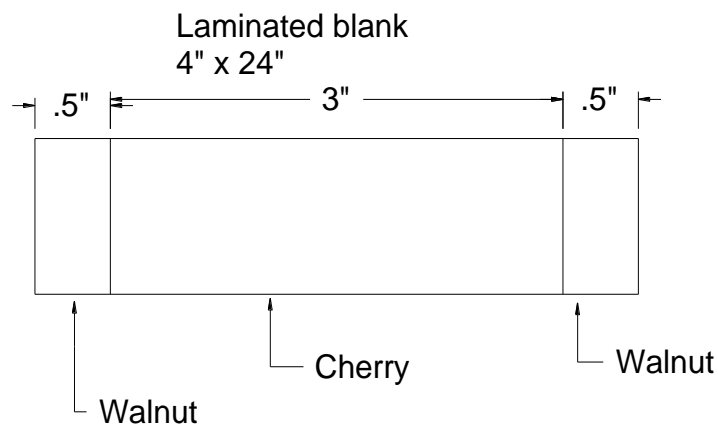


Staved Lamination Workshop

Frank Ditomaso

TASK A

1. Prepare 1" x 3" x 24" Cherry blank, joint edges
 - Glue two 1/2" x 1" x 24" Walnut blanks to each edge of Cherry Blank, wait 24 hours
 - Flatten with jointer and planer, square ends, this assembly is the **LAMINATED BLANK**
2. Prepare 6" square x 1/2" Cherry blank for **BOTTOM**, planed flat on one side
3. Prepare 8" round x 2" pine blank for **BOWL GLUE CHUCK**, planed flat on one side
4. Prepare 3 1/2" x 2" pine blank for **BOTTOM GLUE CHUCK**, planed flat on one side
5. Prepare 8" **MDF GLUE PLATENS** (2 req'd), drill holes for 1/2" carriage bolt, remove corners



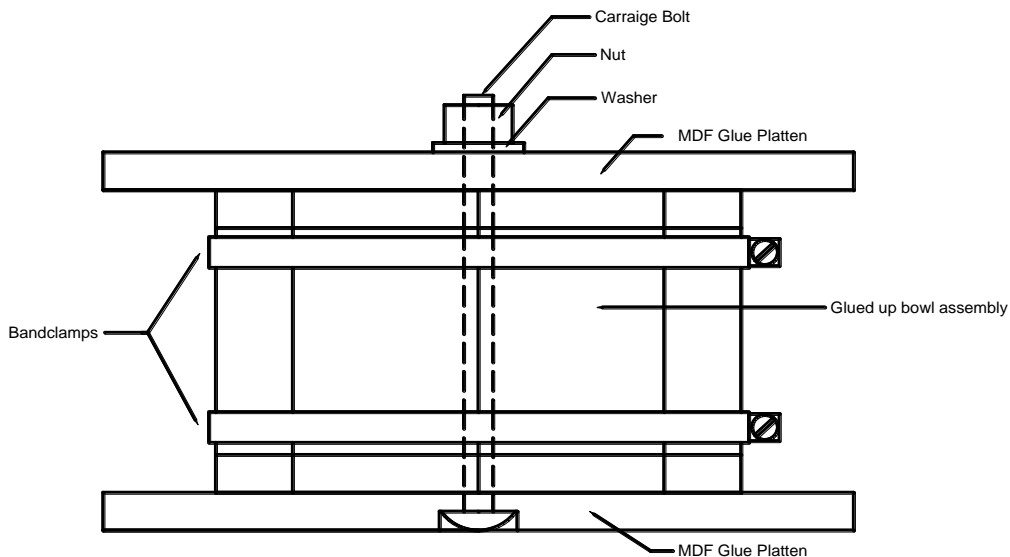
TASK B

1. Build **CROSSCUT SLED** sled from MDF

TASK C

Cut LAMINATED BLANK into 8 bevelled pieces for glue up

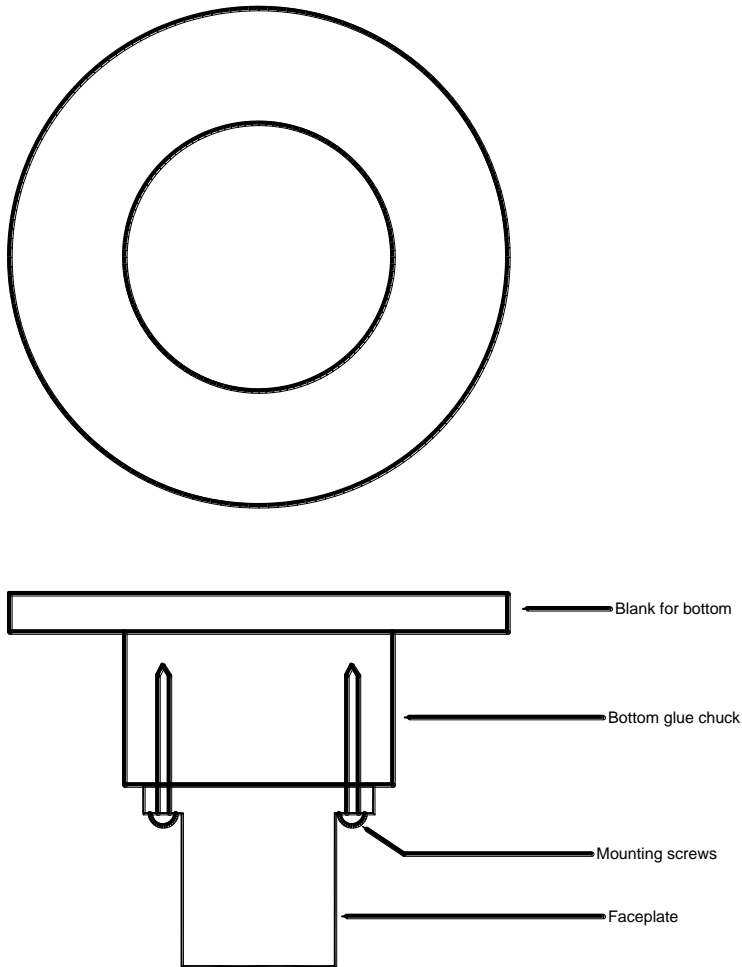
1. Verify accuracy of crosscut sled using MDF blanks for 90 deg cut and 22.5 deg bevel cut, adjust until correct
2. Mark one side of **LAMINATED BLANK** with a diagonal line, this will allow you to get a close grain match when assembling the bowl blanks
3. Cut 8 bevelled sections from **LAMINATED BLANK**
4. Tape sections together on outside with non stretch tape
5. Roll taped assembly into cylinder, verify joint tightness by eye
6. Unroll taped assembly, glue bevels thoroughly, reroll keeping edges aligned, make sure there is glue squeeze out. (Sometimes it is worthwhile to allow the glue to set for about 60 seconds on the exposed edges, then apply a second layer to ensure full coverage.)
7. Place cylinder assembly on one **MDF GLUE PLATEN** (covered with wax paper)
8. Slide two 7" band clamps on assembly, each spaced about 1" from outside edges, snug up but do not tighten yet
9. Place second **MDF GLUE PLATEN** (again with wax paper) on top, insert bolt and snug up nut, do not tighten , make sure cylinder is roughly centered.
10. Hammer assembly with dead blow hammer to get sections to slide into alignment, tighten nut and pipe clamps going back and forth until both are very tight.
11. Visually check bowl assembly from side, make sure sections are in alignment.
12. Leave clamped for 24 hours



TASK D

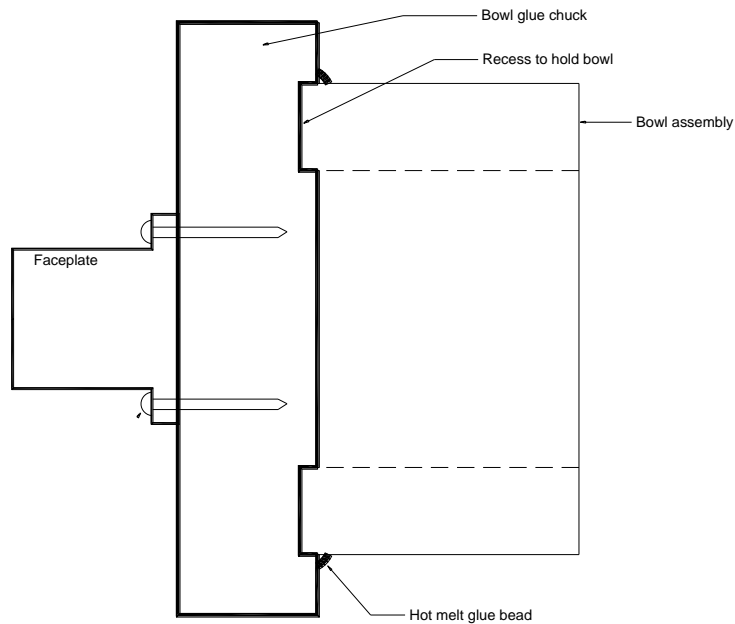
Prepare **BOTTOM** by band sawing $\frac{1}{2}$ " thick, 6" cherry blank round and gluing to a pine chuck for subsequent turning

1. Find center of $\frac{1}{2}$ " x 6" Cherry **BOTTOM** blank
2. Mark circumference at maximum diameter, and band saw round
3. Mark 3.5" circle for **BOTTOM GLUE CHUCK**, add a few extra circles smaller and larger than 3.5"
4. Mount faceplate to $3\frac{1}{2}$ " x 2" Pine blank for **BOTTOM GLUE CHUCK**
5. Mount on lathe and turn round, flatten face
6. Remove from faceplate and glue flat face to Cherry **BOTTOM** blank
7. Clamp for 24 hours



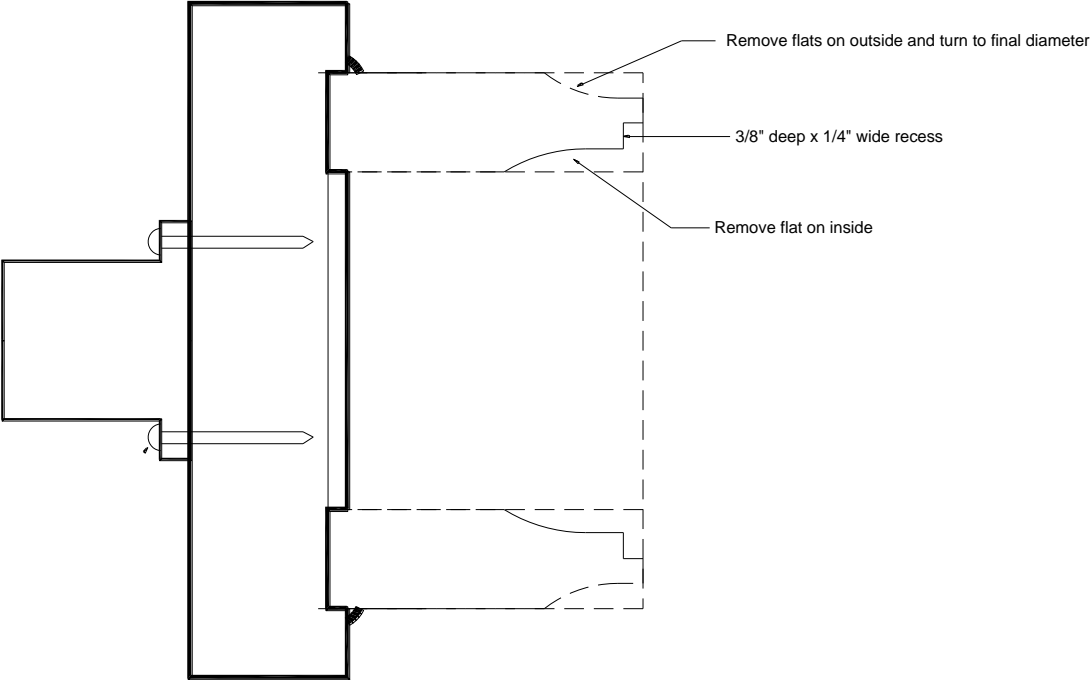
TASK E

1. Cleanup bowl assembly, remove any glue squeeze-out that might interfere with mounting on lathe
2. Mount faceplate to **BOWL GLUE CHUCK** (8" round, 2" thick pine blank)
3. Mount on lathe and cut recess to allow for a tight fit of top, inside of bowl assembly, this will ensure assembly is centered on platen, **accuracy is required here, be sure to get a snug fit on inside of bowl**
4. Remove from lathe and attach bowl assembly to chuck with hot melt glue, wait about 10 minutes for glue to harden

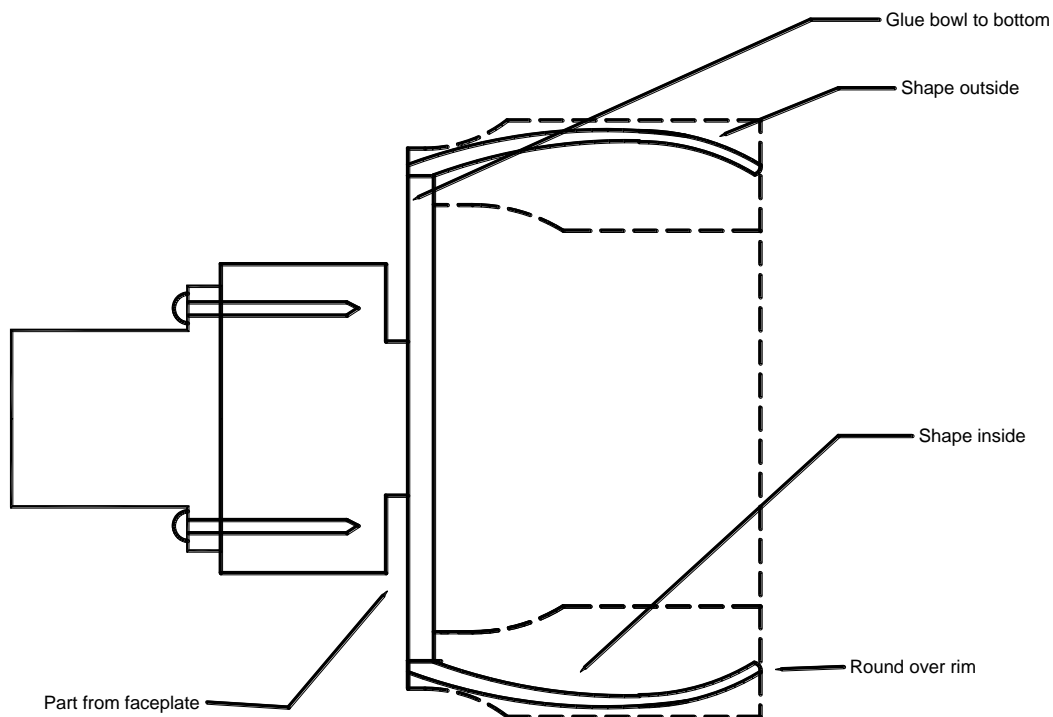


5. Remount on lathe and flatten bottom, cut recess for bottom. The recess should be toward the smallest radius of the bowl to give a taper to the shape.

6. Smooth inside of bowl assembly near bottom in area that might be difficult to reach later



7. Remove bowl assembly from pine blank (with hot air gun if necessary), remove faceplate
8. Mount faceplate on **BOTTOM GLUE CHUCK** assembly using previous holes, **BOTTOM** is already glued to it
9. Mount on lathe, flatten face side, and turn outside diameter for a tight fit on bowl assembly, **accuracy is required here. Make sure it is square.**
10. Remove from lathe, spray Cyanoacrylate accelerator on bowl assembly, apply Cyanoacrylate glue to bottom rim, join two together and apply moderate pressure for about 10 minutes.
11. Remount on lathe, turn inside and outside to a smooth cylinder to remove corners of sections
12. Mark line approx 2/3 up from bottom of bowl and use this as maximum diameter
13. Shape upper and lower sections of bowl to a graceful curve, leave approx 1/4" wall thickness at top and bottom.
14. Shape inside of bowl to get uniform thickness
15. Round over rim
16. Sand inside and outside with 80/120/180/240 grit sandpaper
17. Finish (optional)



18. Part bowl from glue-block
19. Mount faceplate to **BOTTOM GLUE CHUCK** (8" pine blank), turn rabbet for rim of bowl, **accuracy is required here**
20. Hold finished bowl with rim on faceplate with pressure from tailstock, the center portion that cannot be reached can be finished by hand
21. Clean up bottom, sign and date
22. Fill with potato chips and enjoy your favourite DVD