

Duck Calls

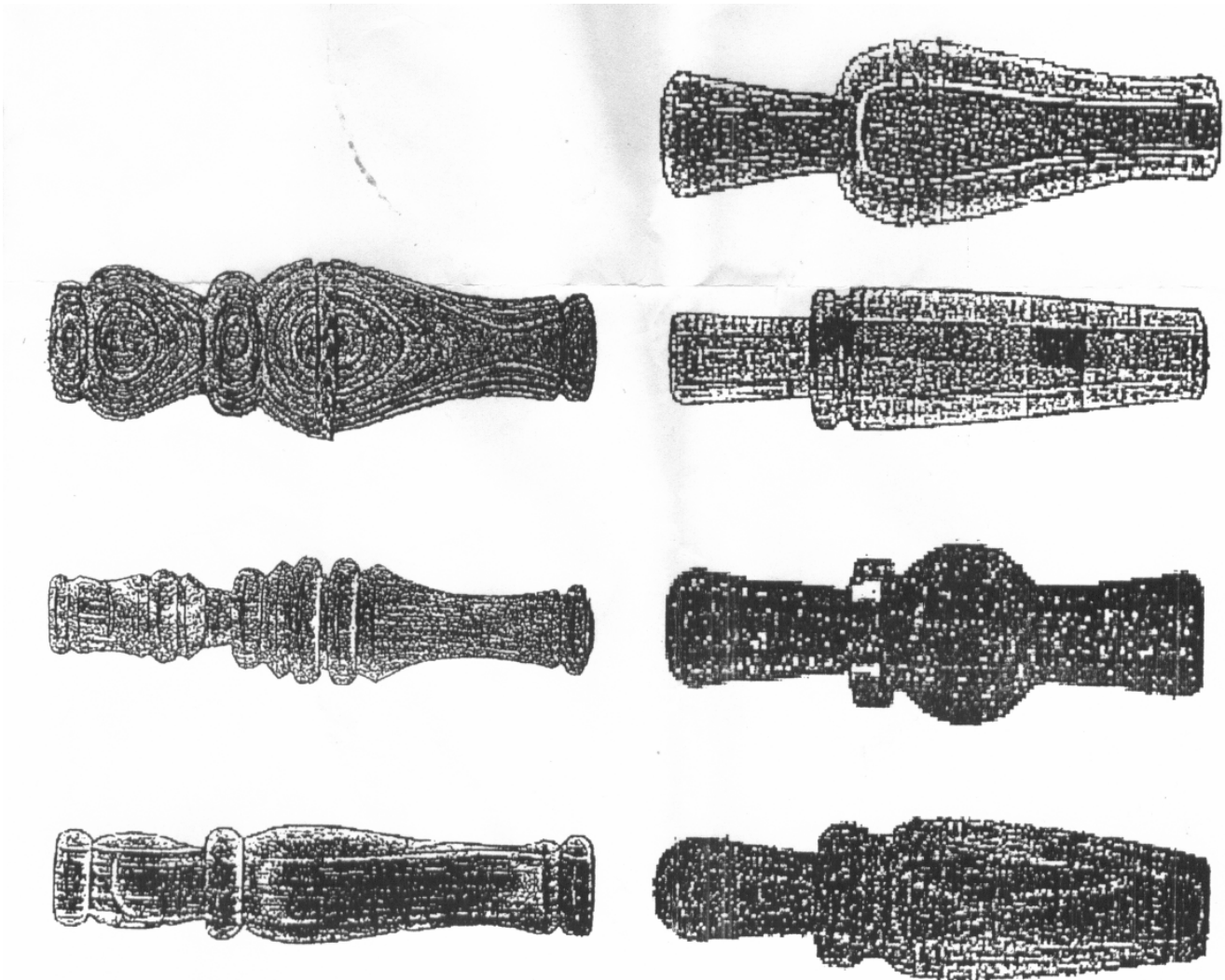
a 7mm pen mandrel. Making a duck call is truly a unique experience. Until recently, a closely guarded secret, you can now make highly functional, custom duck calls easily and quickly.

You will need a 7 mm pen mandrel and the #3000 Game Turning Kit.

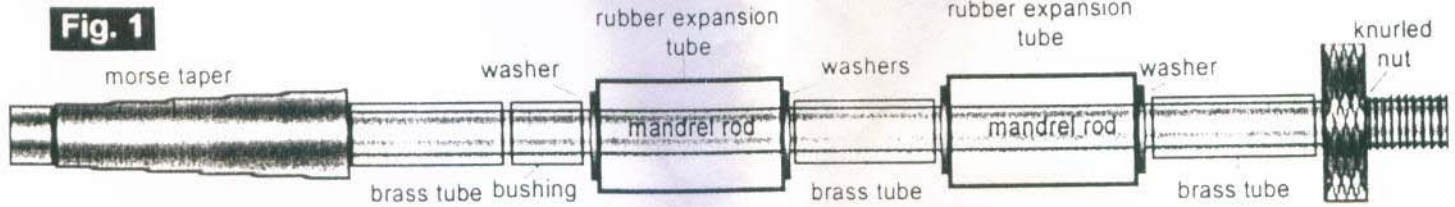
There are three basic parts to this style of call: The barrel (tone chamber), the stopper and the reed assembly. The reed inserts into the stopper and the stopper into the barrel. Regardless of what you call these pieces they are always the same. The material you choose for the barrel can drastically effect the tonal quality of the call.

The profile you choose to use to turn can vary greatly and allow you to vary your designs considerably.

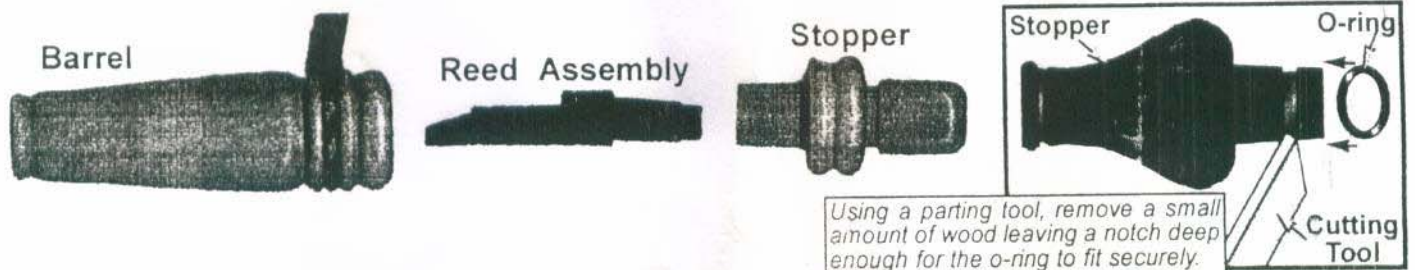
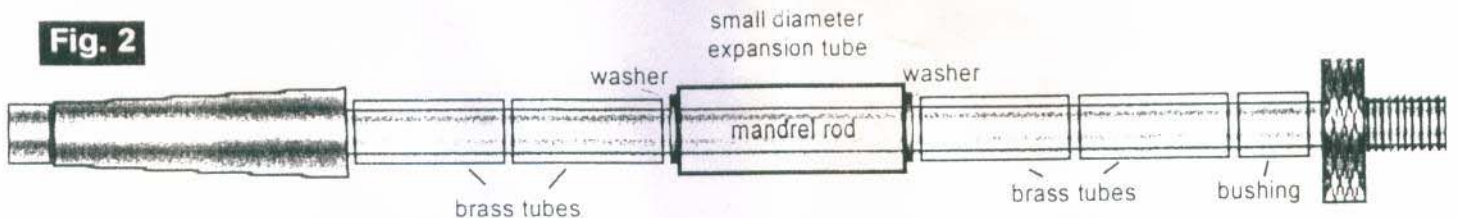
For more information—check out our web site for the types of calls available, including deer grunts, Elk Grunts, predator calls, etc. All based on the duck call kits.



Barrel (Tone Chamber) Mandrel Set Up



Stopper Mandrel Set Up



Using a parting tool, remove a small amount of wood leaving a notch deep enough for the o-ring to fit securely.

Materials:

- 1) Duck Call Mandrel Kit 3000
- 2) Predril Blank (see catalog)
- 3) small set turning tools
- 4) 7mm mandrel with appropriate Morse taper
- 5) Sanding rolls, 4 pk.
- 6) Use finish of your choice.

**When turning keep grain the same as wood was cut.*

Mandrel Setup (Barrel):

- 1) Load large 3/4" OD rubber expansion bushings, metal bushings, washers and brass tubes as depicted. (Fig. 1)
- 2) If possible corners of blanks should be removed using a band saw or similar tool to aid in turning.
- 3) Place Large predrilled barrel on mandrel and center over bushings. Tighten knurled nut until blank will not slide on rubber bushings. Extra bushings may be necessary, some 7mm mandrels vary in length.
- 4) Make sure your live center is properly placed in the end of the mandrel.
- 5) Duck call designs can vary just as the people who turn them. We have included drawing of some of the more popular designs.
- 6) If a lanyard is to be used remember to cut a small cove (groove) approximately 3/16" deep for the cord to rest in.
- 7) On each end of the barrel you will need to round over the openings; The mouth end for comfort and the stopper end for easy insertion of the stopper

Mandrel Setup (Stopper):

- 1) Load bushings, brass tubes, washers and 1/2" rubber expansion bushing onto mandrel as as shown. (Fig. 2)
- 2) Noting grain orientation place short blank on mandrel so that insert portion of stopper will be turned on tail stock end. Center over rubber expansion bushings. Tighten knurled nut until blank will not slide.
- 3) Turn as you did in the first setup, however turn so that stopper insert points toward tailstock.
- 4) Inside end of stopper must be turned down to a diameter that will fit inside the core of the barrel. Using your metal taper gage turn the end to be inserted to a point where the gage just fits over the wood. Note that this size will be slightly over size. Very carefully sand the stopper down to the point where it fits perfectly into the barrel. You will need to remove the brass nut from the mandrel and slide the completed barrel onto the stopper insert a few times to get the ideal fit. Do not remove the stopper, it will alter your alignment.
- 5) Sand and finish with Finish of your choice.

Assembly:

- 1) Place round end of reed assembly into insert end of stopper.
- 2) Insert completed stopper into barrel and you are now ready to call ducks!

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