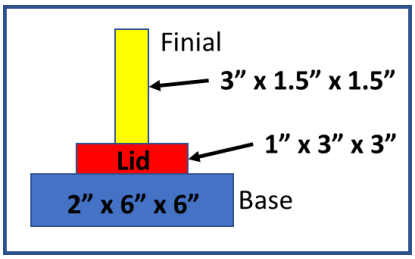
Turn a 3 Piece Lidded Box

Materials Needed for Project



The Base 6” x 6” x 2”

1. **Drill a Pilot hole for the Screw Chuck and mount on lathe**
2. **Turn a spigot on the bottom using a square end scraper to fit either the outside of a #2 set of jaws or expand into the inside of the spigot**
3. **Turn the bottom radius of the base using a 3/8 bowl gouge or a square end scraper**
4. **Reverse the base and secure using the spigot turned in step #2**
5. **Using a square end scraper turn a 3/16” step on the top 2 7/8” in dia.**
6. **Turn the top radius of the base using a 3/8 bowl gouge or a square end scraper**
7. **Using a hollowing tool turn the inside of the base out to match the outside radius and leave a ¼ “ rim for the top to sit on**
8. **Sand and finish with a pad lacquer or rattle can lacquer**
    a. **Note when sanding use a wax to lubricate the sand paper and prevent heat checks**
9. **Reverse the base and expand into the opening , finish sand the bottom and again use pad lacquer or rattle can lacquer**

The Base should be complete and ready to buff

The Lid 3” x 3” x 1”

1. **Drill pilot for screw chuck and mount on lathe**
2. **Using a square end scraper turn a spigot for a #2 set of jaws**
3. **Reverse the top and secure with the spigot you turned in step #2**
4. **Using a square end scraper turn a tenon to fit into the opening of the base**
5. **Using a square end scraper turn a dovetail recess into the tenon you just turned in step #4 .**
6. **Using the tail stock and a Jacobs chuck drill a 1” all the way through the top**

Leave the top in the chuck and set aside

The Finial 1 ½” x 1 ½” x 3”

1. **Mount between centers using a safety drive on the headstock if you have one**
2. **Turn round keeping it as large as you can = 1 ½ diameter ideally , try using a skew to keep it flat**
3. **On the head stock end measure 3/8” and mark with a pencil , the 3/8” section will remain 1 ½” radius**
4. **From the 3/8” line make another line 1” from there , or 1 3/8” from the end of the blank**
5. **From the 1” line turn a taper all the way to the live center on the tail stock. This taper will end up being small enough so that it will slip into the #2 mores taper on the head stock**
6. **Starting back at the 1 “ line the space between the 3/8” line and the 1” line will need to be turned to a 1” diameter so it can fit into the 1” hole in the top.**

7. **Remove the finial blank from the lathe and remount the chuck with the top**

Glue the finial blank into the top using a 5-minute epoxy and use the tail stock as a clamp

1. **Once the glue is dry, finish turn and sand the bottom/inside of the top – again use wax as a lubricant when sanding and finish with pad lacquer**
2. **Reverse the top/finial assembly and expand into the dovetail recess**
3. **Finish turn the top/finial assembly , sand , and finish with the pad lacquer**

The Top is now ready to buff and the Lidded box is complete .