# Turning a Pioneer Duck Call

Supplies Needed

- 1 1/2" x 1 1/2" x 6" Blank
- Duck Call Reed Assembly
- 3/4" WoodMaster Mandrel
- 1/2" WoodMaster Mandrel
- Glue (Thick CA or Epoxy)
- Sandpaper/Finish
- Drill or Drill Press
- Eye and Ear Protection
- 1/2" Drill Bit
- 3/4" Drill Bit

Wood Preparation

1. Select a blank 1-1/2" x 1-1/2" x 6".

2. Cut the blank to the sizes shown below.

3. Mark and drill the blanks as shown below. 3/4" diameter hole for the barrel. 1/2" diameter hole for the stopper.
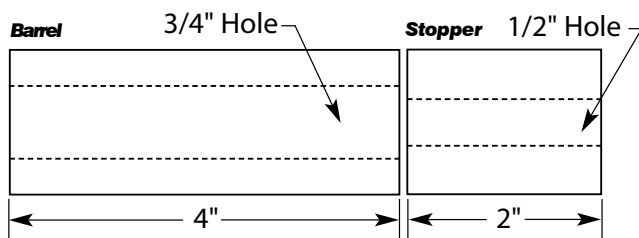

Turning the Barrel

1. Mount the 3/4" WoodMaster mandrel into a drill chuck or collet chuck.

2. Slide the blank onto the mandrel and tighten the expansion screw so the blank will not slip while turning. **Do not overtighten.**

3. Turn the blank to the desired shape. Note: make a 3/16" wide groove for the lanyard if so desired.

4. Sand and finish all exposed surfaces of the barrel. We recommend a durable waterproof finish.
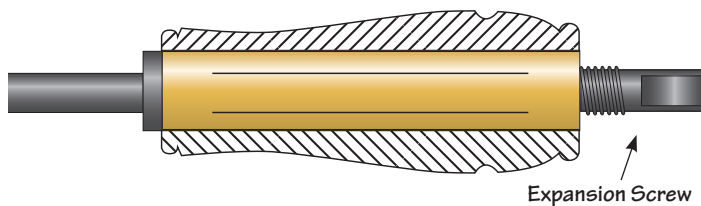
Expansion Screw

Turning the Stopper

1. Mount the 1/2" WoodMaster mandrel into a drill chuck or collet chuck.

2. Slide the blank onto the mandrel and tighten the expansion screw so the blank will not slip while turning. **Do not overtighten.**

3. Turn a 3/4" dia. tenon that will fit into the barrel. Use a set of calipers to size the tenon. Test the fit of the stopper tenon by stopping the lathe, and sliding the barrel over the end of the mandrel and onto the stopper tenon. This step may need to be repeated several times. **Do not to remove the stopper from the mandrel, as this may alter the alignment.**

4. Cut two grooves in the tenon using the point of a skew to accept the o-rings. The o-rings should be slightly proud of the tenon and no larger or this will cause fitment issues.

5. Sand and finish all exposed surfaces of the turned stopper. We recommend a durable waterproof finish.

Expansion Screw
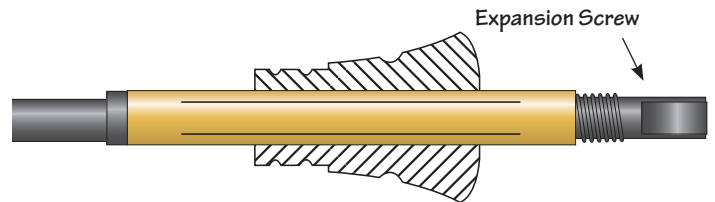
Assembly

1. Install the o-rings into the grooves cut on the stopper.

2. Apply a small bead of glue to the shoulder of the call and insert the end of the call into the stopper.

3. Insert the complete stopper assembly into the barrel to complete the call.

O-Rings