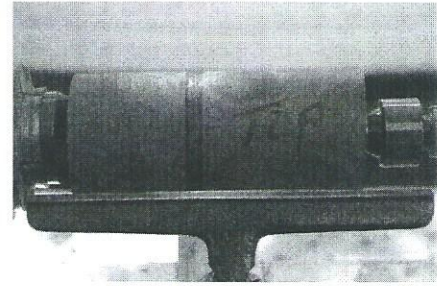


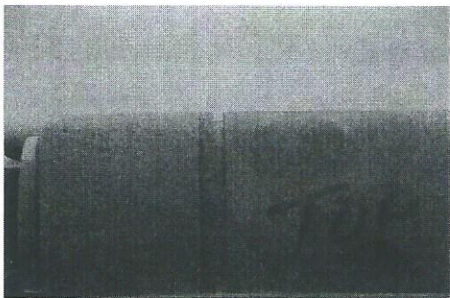
these operations between centers, this will leave a very nice center mark for your use later.

Next determine where the part between the top and the bottom will be and mark it with a pencil.

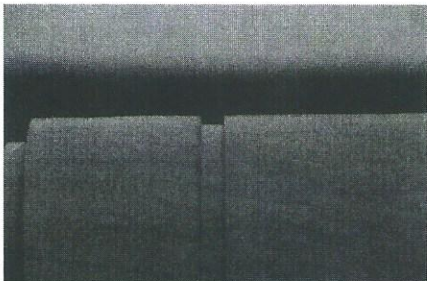
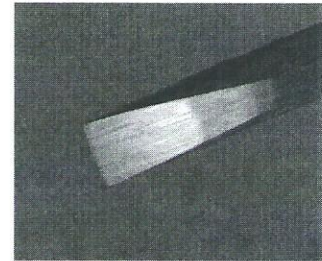
Put the blank into the chuck. I usually use the center mark from the live center or drive center to help register the blank into the jaws of the chuck by using the live center to put pressure on the blank prior to tightening the chuck jaws. This will ensure that the front faces of the chuck jaws are tightly registered against the wood shoulder that you took so much time to clean up earlier. If you had any burs on this front face you would embed them into the wood and therefore have a good fitting blank.



Ok, now roughly shape your project on the end that is in the chuck. If you remove the line marked earlier, you may just have to make that mark again or remember where it was. Now use a sharp parting tool, here I am talking about a diamond cross section parting tool that is 1/8" wide and sharpened straight



across so that the cutting edge is 90° to the side of the tool, to part a groove about 1/8" deep leaving that part of your blank that is in the chuck the proper size. This depth is controlled by the design of your project. If your project is to have 1" wall thickness and you want the slip joint in the middle of the wall thickness you will need to cut this groove 1/2" deep.



Next make another parting tool cut adjacent to the first cut and to the same depth, thus making the groove 1/4" wide. Then do this again making the groove 3/8" wide. Then make another cut to make the groove just a little over 3/8" wide (25/64")

Next you should pay attention to the quality of the cut which forms the sides of the groove. You can make an almost invisible joint if these two sides are cut clean. Caution you may need to sharpen the skew to achieve the quality of cut that you want! Now look at the bottom of the groove, is it exactly flat and exactly the same diameter at both sides? It has to be so that the rest of the operation will work. This is not hard to do, just make sure that the parting tool is 90° to the axis of rotation and move it back and forth lightly on the bottom of the groove.

