

TURNING FANCY BOXES WITH FINIALS



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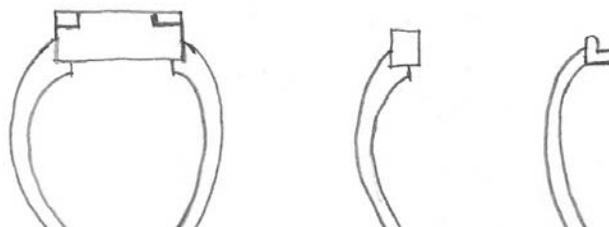
TURNING THE BOX:

1. Turn the blank round (using a roughing gouge, spindle gouge, etc.) then turn a 2" tenon on each end of the box blank.
2. Use a narrow parting tool (if available) to remove the lid section (about $\frac{3}{4}$ ")
3. True up the top edge of the box
4. Mark where the insert will go in the top of the box
5. Use a 1 $\frac{1}{2}$ " Forstner's bit to create a stepped recess about $\frac{1}{4}$ " deep (Note: This can also be done free hand with a parting tool, skew on its side, bedan, etc.)
6. Using a spindle gouge, begin shaping the exterior of the box
7. Once the general exterior shape of the box is completed, use a $\frac{1}{4}$ " to $\frac{3}{8}$ " drill bit to drill a hole down the center to within about $\frac{3}{8}$ " of the bottom
8. Hollow out the area just beneath the stepped recess down to about $\frac{1}{3}$ the total depth of the box



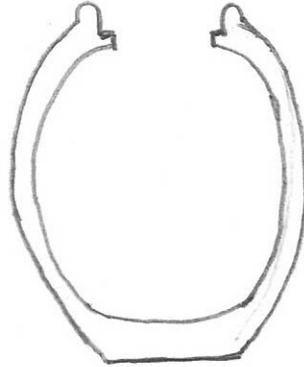
INSERT:

1. Pressure mount the contrasting insert disk on a flat wooden jam chuck attached to a face plate. Mark the center and bring up the tail stock.
2. Using a spring caliper, carefully measure and turn the insert disk to the proper diameter to fit into the box opening. Do not cut away the excess depth of the insert.
3. Glue the insert into place (Wood glue if you're not in a hurry, CA if you are in a hurry)
4. Use a pencil to make a cut line approximately $\frac{1}{4}$ " from the outside edge of the disk
5. Turn away excess material around the outer $\frac{1}{4}$ " of the disk. Don't be too aggressive as you are only trying to thin the disk somewhat around the outer edge to make it easier to part off the interior section of the disk.
6. Use a narrow parting tool to cut away the center of the disk (This is possible having hollowed out the box part way)
7. Shape the insert to a desired height (about $\frac{1}{8}$ " above the surface of the top of the box). Leave a small stepped ledge (about $\frac{1}{8}$ " wide) for the lid to sit on.
8. Round over the top edge of the insert (make a bead)



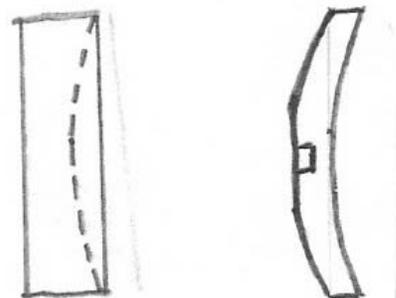
HOLLOWING THE BOX:

1. Finish hollowing the box, checking wall thickness often. Remove wall material in about three stages.
2. Shape the lower exterior of the box
3. Sand the box
4. Part off the box. The cut should be flat. (I like to use a skew to mark where the parting cut will be made. The skew cuts the wood fibers and prevents any tear-out. If you are not used to using a skew, beware, it can “run” or “skate” if not careful)



LID:

1. Mount the lid tenon into the chuck. Use calipers often to measure the diameter of the lid.
2. When the lid is almost the correct size, shape the inside of the lid, slightly concaved. Sand.
3. Using an accurate measurement, carefully decrease the size of the lid until it fits the box opening. (Not too snug for this style of box)
4. Part off the lid, leaving enough wood to shape the top side of the lid
5. Make a very shallow (about 1/16”) jam chuck from the tenon section still on the lathe and place the lid in it. Bring up the tail stock and carefully make cuts to form the top profile of the lid. The center 5/8” to 3/4” will glue to the finial, so cut that section flat.
6. Sand.
7. Using a 1/8” drill bit, drill a very shallow hole in the top center of the lid. This will help to center the finial. (Note: if you drill all the way through the lid, don’t panic. You can cover the damage from the inside with a rhine stone)



FINIAL:

1. Mount the finial stock into small jaws in the chuck.
2. Determine the length the finial should be and turn a long cone to that length.
3. Use a 3/8" detail gouge and skew to execute the finial cuts. Work slowly and move from the tip toward the head stock about 1/2" at a time. (Caution: Resist the urge to put a lot of beads, coves and V's into the finial. Simple and elegant is better than cluttered and bulky.)
4. Sand as you go, supporting the back of the delicate finial with your finger.
5. Measure the bottom of the finial that will glue to the box lid carefully
6. Part off the finial with an undercut, leaving a 1/8" diameter tenon that is only about 1/8 inch long (just long enough to protrude past the base of the finial).
7. Glue the finial to the lid.



FINISH:

1. Several choices of finishes are possible. Some are:
 - a. Minwax 209
 - b. Tung oil
 - c. Waterlox
 - d. Wipe-on lacquer
 - e. Wipe-on poly

(Apply about 3-4 coats of each of the above finishes, with a light sanding between coats. Sand the second coat of finish with 320 grit, the next coat with 400 grit and the last coat with 500 grit, etc.)
2. Lightly sand the box with 600 grit paper when the final coat of finish is dry and apply wax, using your favorite waxing system.
 - a. Beall buffing system
 - b. EEE paste, followed by a wax

(You can buff the finial if you apply very light pressure against the buffing pad and support the finial with your fingers as you lightly press it against the pad.)
3. Apply light pressure when using any buffing system.