

BONNIE KLEIN'S SPIN TOP BOX WITH THREADED LID



1. Start with a cylinder of material approximately 2 1/2" diameter and 1 1/2" long for the base.
2. Attach to a faceplate glue block (or use a chuck) with the grain parallel to the lathe bed.
3. Shape the top of the base and create a recess about 3/4" deep and about 1" diameter.
4. Prepare the 1/4" straight, interior wall for the threads.
5. The clearance cut where they will start needs to be the depth and width of one thread with a bevel for the first thread.
6. All sanding and finishing should be done before cutting threads.
7. Cut about 3-4 rows of threads at about .025" deep. Flow the very thinnest CA glue sparingly only into the cut to provide strength to the threaded area.
8. Cut again to full depth creating threads that have no flats on the tips. Could be another .010-.015" for 16tpi.
9. Clean up the threads if needed with light sanding.
10. Shape the top surface and around the corner, leaving enough support for chatterwork.
11. Decorate the top surface with chatterwork and color, and around the corner with color. No chatterwork on the underside at this time.
12. Roughly shape the bottom of the spin top and part off. If using a chuck, shape as much as you can at this time.
13. For the handle, you will need material about 1 1/2" diameter and 3" long.
14. Attach it to a faceplate glue block or use a chuck.
15. True the sides and face and on the end, cut a 1/4" long tenon, leaving a shoulder. The diameter of this tenon is determined by measuring across the female threads and adding 3/64". (Max is 3/64", min is 2/64")
16. Cut a bevel across the corner where the threads will start.
17. Turn a shallow recess on the end for added interior capacity.
18. Sand and finish the area before cutting threads.
19. Cut threads up to the shoulder, about .025 deep and try the fit. Apply the thin CA glue again and cut deeper if needed. Sneak up on a good fit – not too tight.
20. Screw the bottom of the spin top onto the handle to finish the final shaping, chattering and coloring of this part.
21. Shape the handle to include a larger diameter section (a knob) to make it easier to unscrew the parts. Adjust the diameter of the shoulder where it joins the bottom. Sand and color.
22. Turn a couple of tiny spin tops to be kept inside.
23. Apply carnauba wax with a buffing wheel to finish.