

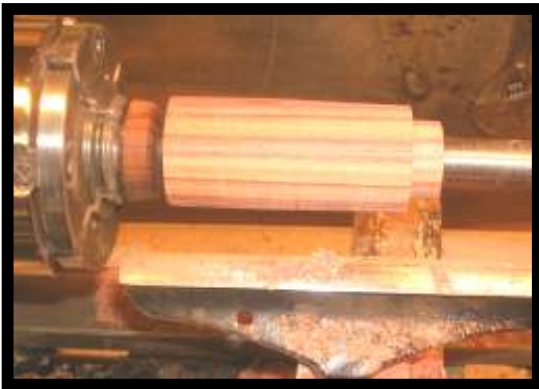
Attaching Metal Bands To Calls

It sometimes seems that there are as many ways to do make calls as there are call makers, and that's a good thing. We can learn new ideas and try different things to see what works best for us.

So it is with the way I attach metal bands to my calls.

I have tried several different way, including pinning and press fit and just gluing. What I now use is a combination of a press fit with a glue back up. I find this method works best for me and the calls I make.

Once I have the blank turned to round, I start taking wood down where the band is going to fit.



Next, I take the band I am going to use and measure the inside diameter of the band with a digital caliper. If you don't have one of these tools, I would suggest you get one. They run around 25 bucks



and are an invaluable aid in the shop.

The band I am using in this article is going to on one of my Classic Style Predator calls and is 7/8" Outside Diameter.

But it is the inside diameter that we are concerned with.

Just a tip, when you make or get your bands, check to be sure there is not a "ridge" left on the very inside lip of the band from the cutting and polishing process. This will skew your measurements and make you band too loose. If there is a "ridge" there, a bit if sandpaper will take it off.

Take an initial measurement of your blank.



As you can see, I have a ways to go. But it's better to have too much than too little. I've never found a good way of putting wood back on a blank.

It's now time to start turning the band tennon down bit by bit, taking measurements as we go, and the closer we get to the size we are looking for, the more frequently we stop and measure.



Getting there.

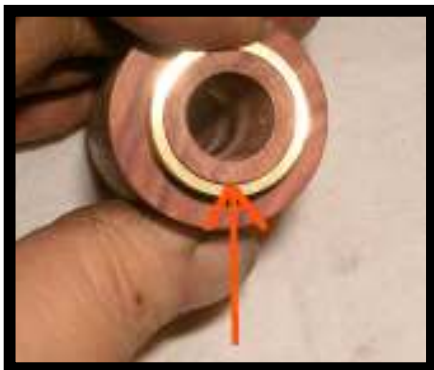
At this point, when turning a wood blank, when I am about a few 100th's off, I stop turning and set the blank in the drying rack for a few days.

If you don't do this, even with "dry" wood, there is a chance your tenon will shrink a bit and the band could pop off.

So set the blank aside for a couple days, at least 24 hours.

You do not have to do this with acrylic or stabilized woods, or dymondwood.

Here is a picture of a band that was press fit onto a piece of dry wood, with no glue, just to show what can happen.



You can see the gap that formed when the wood dried even more after pressing the band on.

Even a good glue joint will pop if the wood shrinks.

When you set the blank aside to dry. Put the band you are going to use with it. Bands may have a different inside diameter from band to band.

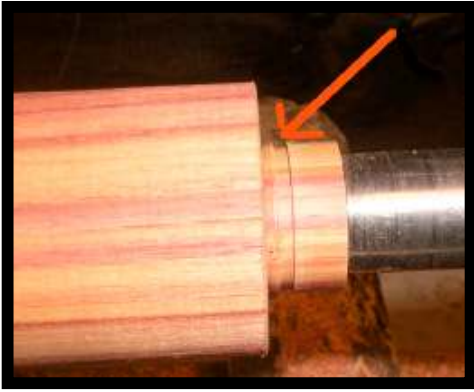
Once the blank has sat and stabilized for a couple days, I put it back on the lathe and start turning it down to just a few thousands over the inside diameter of the band. Take your time and measure twice as much as you think you should.



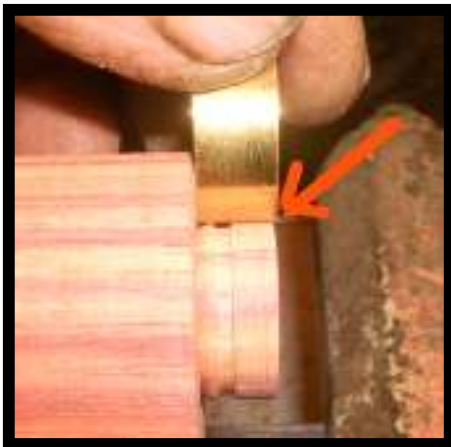
We are getting close at this point. Just a tad more and we will be ready to attach the band. But before we do, there are a couple other things we need to do to the blank and the band.

The first, is to cut a glue band in the tenon. I use a Polyurethane Glue to attach my bands. Gorilla Glue is one brand. The glue expands as it dries, and it fills in the glue groove.

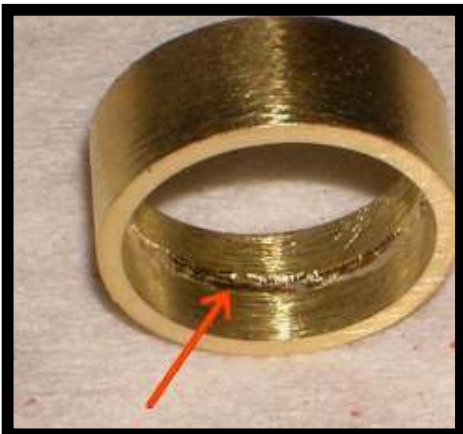
You can see the groove in the picture below.



At the same time, set your band on the edge of the tennon. I like to make sure the wood tennon is just a bit shy of covering the entire band so I get a good fit when I press the band on. The excess can be filed or sanded off in the turning process.



Then, I take the band I am going to use and cut a groove inside it with a carbide bit in a Dremel Tool.



When the poly glue expands, it will fill both the glue groove in the blank tennon and the groove in the band. Now if anything happens, and the blank should shrink just a bit, the glue bond MAY break, but with the glue filling the two grooves, it forms a “lock” and the band will not fall off.

Usually.

Wipe the inside of the band down with some Acetone, and on wood blanks, I wipe them too. For acrylics and stabilized woods, I use a degreaser like 409.

Dampen the wood tennon or the acrylic with some water, and apply a bead of poly glue around the entire tennon, making sure to get it in the glue groove.

Set your band on top of the tennon, and gently tap it with a small hammer to get it started on the blank.



Once you get the band started on the blank, you can use a small press, a drill press vice or a block of wood and the hammer to force the band completely on the blank.

Wipe off as much excess glue as you can and then clamp the band and blank up and let them sit for at least 24 hours.



If you do not have clamps or don't want to spend a lot of money on clamps, you can buy a few bolts about 1/8" smaller than the inside diameter of the bore of your blanks, and using large fender washers make inexpensive clamps that work just as well.

After 24 hours, or at least over night, take the blank out of the clamp and turn your call. The band is on there, and chances are, it won't ever come off.

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