

Kilian Tool Bar Handle

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Recommended Supplies:

Min. blank size: 2" x 2" x 10"

Drill bit 1/2" if using epoxy OR 31/64" for friction fit (see step 3)

2-part epoxy

Ferrule (optional)

Drive center or chuck

60-degree live center

Making the handle:

1. Select a blank for the handle with a minimum size of 2" x 2" x 10". Adjust this sizing if you'd prefer a larger handle.
2. Mark the center on one end of the blank.
3. Drilling options:
 - a) Drill a 1/2" hole, 3" deep. After the handle is turned you'll use epoxy to glue the bar into the handle.
 - b) Alternatively, drill a 31/64" hole, 3" deep for a friction fit with no glue required.
4. Mount the blank on the lathe according to the diagram below, with the drilled end at the tailstock.
5. Turn the handle to your desired profile, leaving 1" of waste material at the headstock to be parted off later.
6. If attaching a ferrule, cut a tenon at the tailstock end, 0.85" in diameter x 1/2" long. Remove small amounts of material at a time and test fit often until the ferrule fits snugly on the tenon.
7. Sand and finish the handle.
8. Part off the handle and remove it from the lathe.
9. If attaching a ferrule, spread a small amount of epoxy inside the ferrule and slide it onto the tenon with a twisting motion to distribute the epoxy evenly. Be careful not to get epoxy on the outside of the handle.
10. Then, either epoxy or friction fit the tool bar into the drilled hole.
11. Set the tool aside to let the epoxy cure.

