Whistle Order of Operations

3 1/8"

3/4

Cut 3/4" dia aluminum
x 3 1/8" long in HBS

End Face one end

3

Scribe 3" mark and
center punch

3

End face second end to 3"

Center drill one end
to 1/4" dia

1/4

5/8

Hold by approx. 1/2" in chuck
and parallel turn to 5/8 dia.

Parallel turn remaining length to 5/8"

5/8

Drill 1/4" dia pilot hole
x 2 1/4" deep

1/4

2 1/4

Drill 27/64" dia hole
x 2 1/4" deep

27/64

2 1/4

Radius

Chamfer

Hold work by 1/3 of length
and lathe file exterior
Turn work around and
repeat for second end
Lathe file a small chamfer
and/or radius at each end

3/16"⌀ drilled hole

Scribe mark 1/4" from end
center punch and drill 3/16" dia

1/4

3/4

Mill 45 degree groove
3/4" from end with hole

7/8"

7/16

Cut 7/16" dia aluminum
x 7/8" long in HBS

End face one end

3/4

Scribe 3/4" mark
and center punch

3/4

End face second end to 3/4"

File one side flat
until work is 5/16" thick

5/16

Hot Glue

Remove all burrs
Hot glue plug into place
with flat of plug level
with 45 degree groove