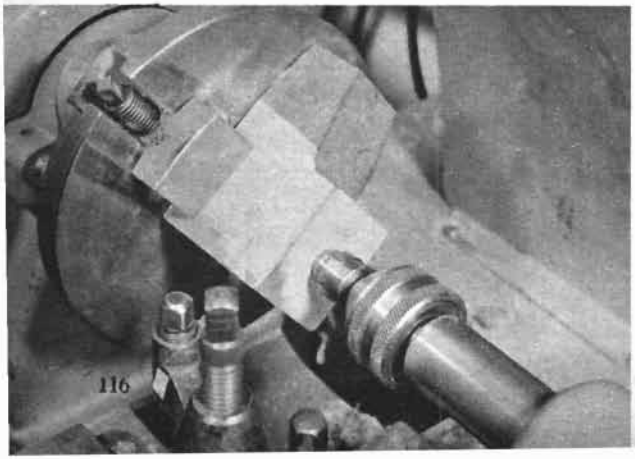
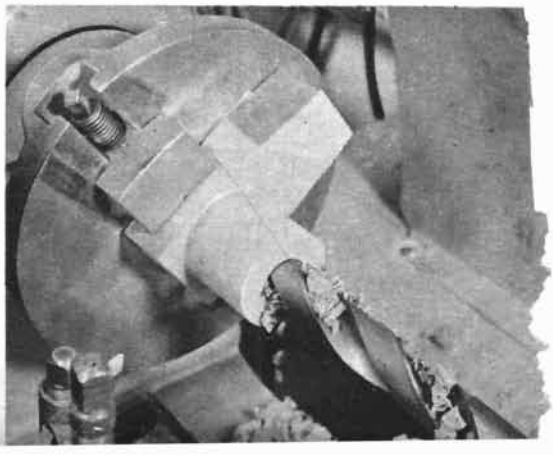
SO YOU WANT

Stop dreaming of that pipe you would like to own. With a little skill and know-how you can make one yourself.

SANDED BRIARWOOD BLOCK is chucked with a tapered wedge between block and face plate and held fast by the tail stock.



PIPE BOWL IS ROUGH-TURNED to 1½-in. diameter. Drill the tobacco hole ½-in. deeper than the length of the bowl's cylinder.

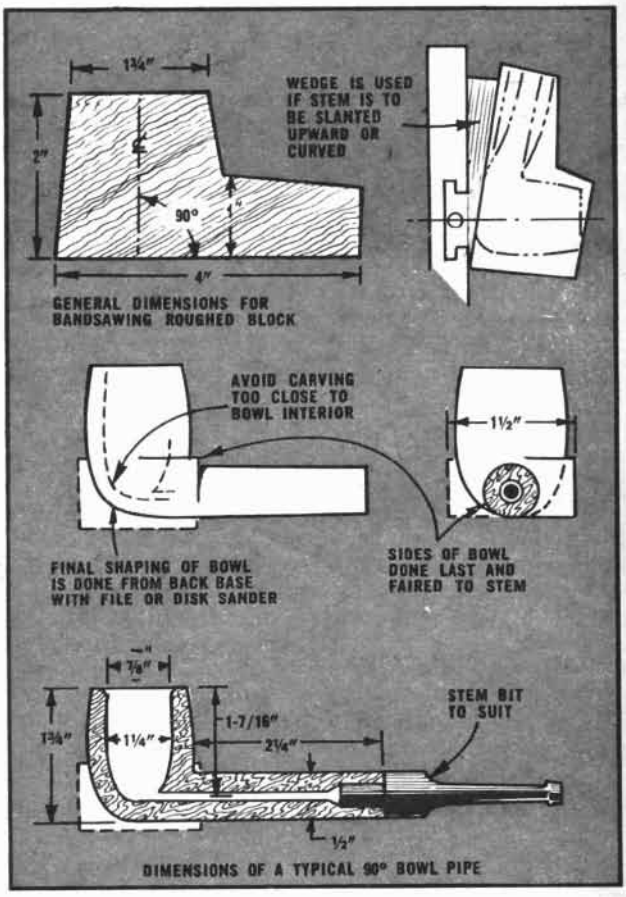


TO MAKE A PIPE? By James Sunnucks

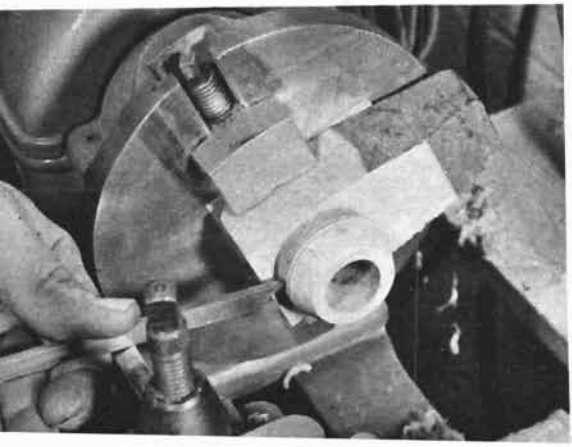
BRIAR root has been used for centuries in the art of pipe making because of its durability, close texture, burled grain and beauty; its ability to withstand years of hard use and hold a natural polish. The best briarwood is found along the Mediterranean coastal areas, Algeria, Greece, Sicily and Italy. The roots are used for pipe bowls and it takes anywhere from 100 to 175 years growth for the root to develop into a large enough piece from which small blocks can be cut. After the roots have been dug, dried and cut, they are sorted into sizes and grades. It always pays to select the best grade for a really good pipe.

To start your pipe, before chucking the block in the lathe, sand the bottom and back square. Cut several wedges, ½-in. wide, equal to the angle the bowl will be in relation to the shank. This will determine whether you have a straight or bent stem.

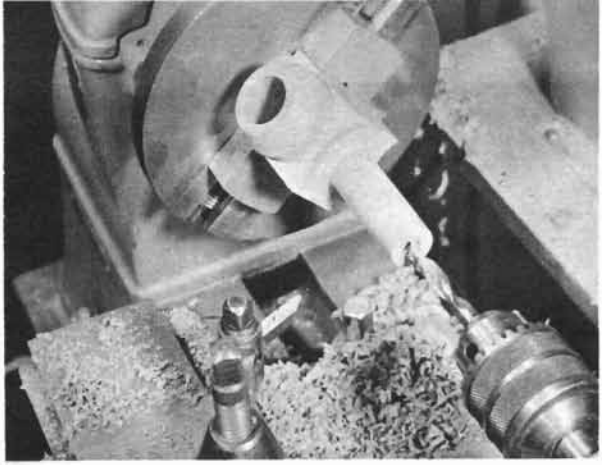
Hold the briar block with the wedge on the bottom against your lathe's face plate and run up the tail stock until you can tighten the chuck jaws. The bowl's center



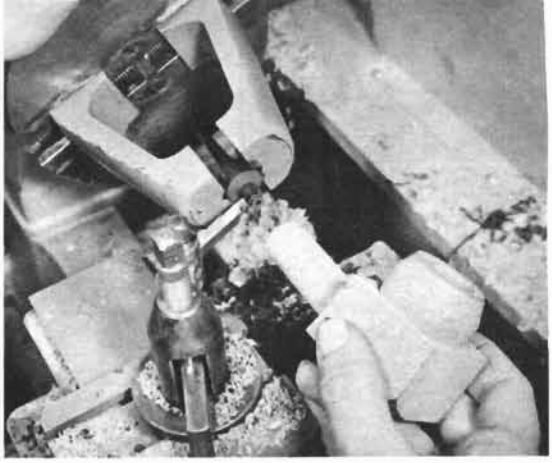
SHAPING AND TRIMMING of bowl is done with a spearpoint wood chisel. Examine several pipes to get most pleasing design.



TO CUT THE STEM, rechuck pipe with bowl clamped to face plate. Use ball bearing center and slide rest to turn down shank.



HOLE FOR STANDARD STEM TENON is drilled with 5/16-in. drill to a depth of ⅝ in. Use a 3/32-in. drill for long smoke hole.



COMMERCIAL STEM TENON has to be cut down to fit into the shank. Nylon or Vulcanite black rubber bits are most commonly used.

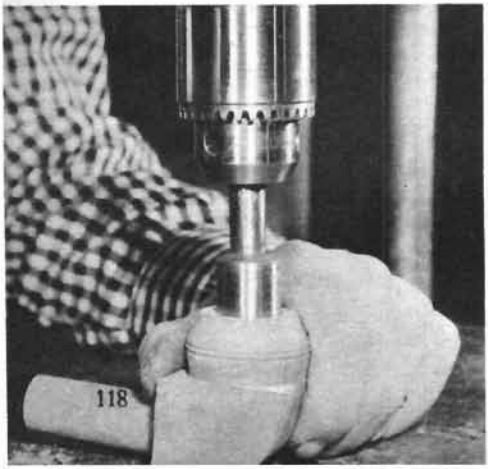
should be measured on the heel and two outside surfaces. Turn a cylinder, removing the two rear corners but leaving enough wood for turning the shank when you rechuck later. After cutting the cylinder, determine what size tobacco hole you want. The hole can be drilled with a round pointed ¾- to ⅞-in. drill or boring tool on the cross feed of your lathe.

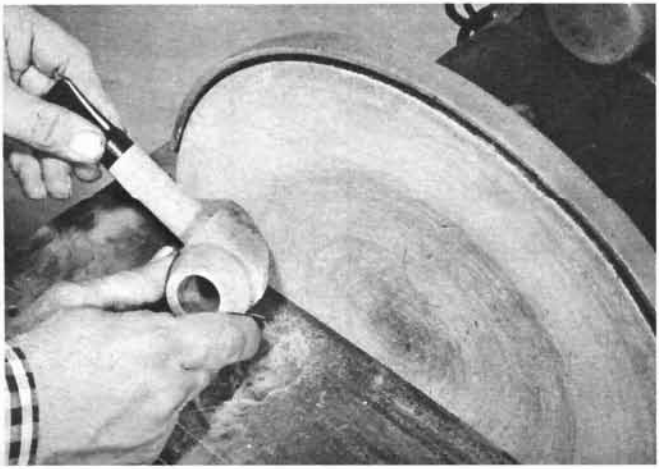
The bowl can now be shaped, using gauges and right- or left-hand skews. Imperfections may appear and disappear with a few cuts. If you have a large bowl with no flaws leave it that way since flaws may appear when going deeper.

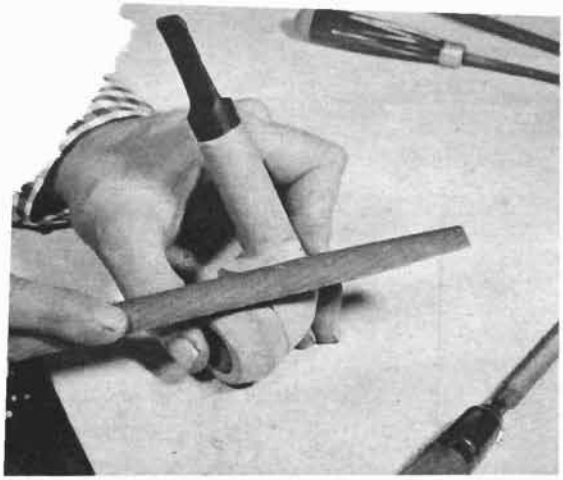
You can remove the block now and rechuck for turning the shank. Make sure that you have enough stock to turn the shank round up to ⅛-in. from the bowl. Use a ball bearing center at the tail stock to assist in the turning of a long shank. Square off the end of the shank, then bore a $\frac{5}{16}$- to ⅜-in. diameter hole, depending on the thickness of the material around the sides; this should be strong enough for holding the stem tenon without cracking. Drill the smoke hole with a 3/32- to 5/32-in. diameter, six-inch long drill. Drill from the end of the shank to the center of the tobacco hole. If these holes do not meet on sight at the bottom of the tobacco hole, drill

EXTEND TOBACCO HOLE to depth of the smoke hole with round ended drill. Line up tobacco hole bottom with smoke hole.

ALL EXCESS BRIAR is removed with a band saw, belt or disk sander. Be careful not to cut into the pipe's final dimensions.





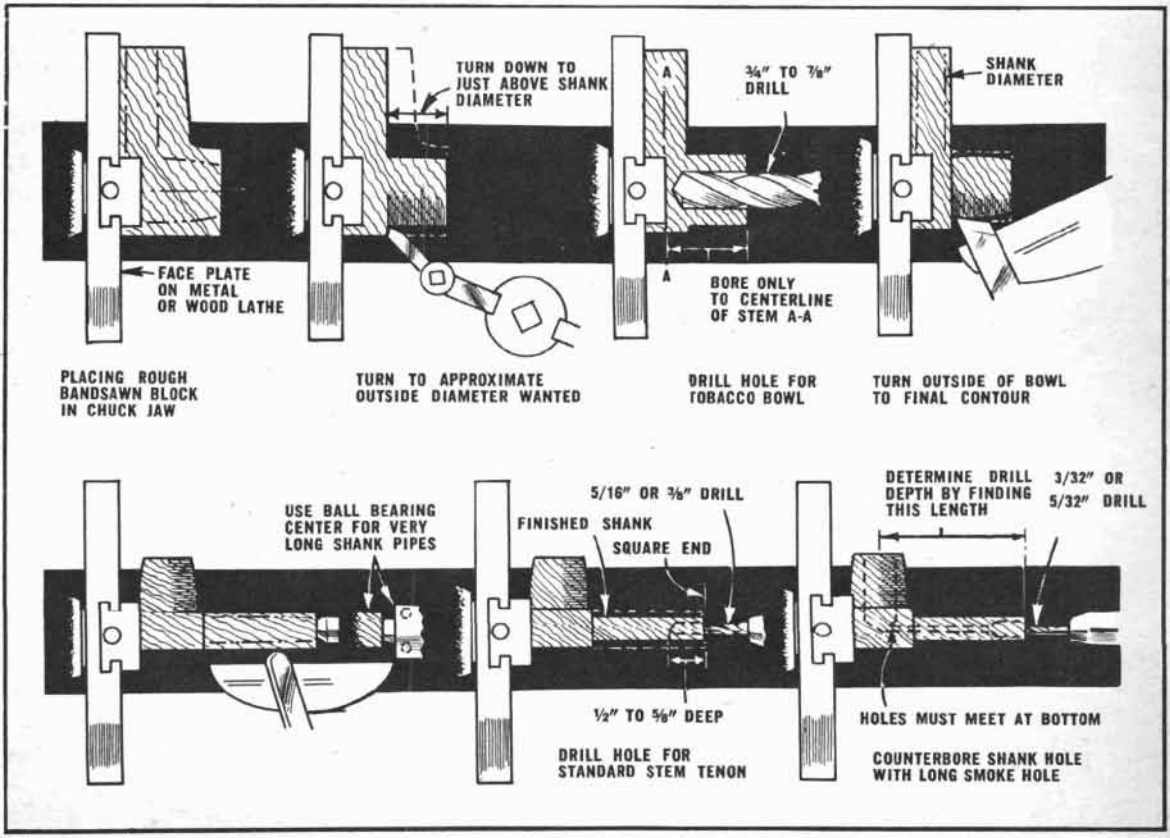


BOWL AND SHANK are given final form with a file and smoothed with aluminum oxide before staining to desired color.

USE BUFFING WHEEL to obtain smooth finish after staining. Apply Carnaube wax, after buffing, for professional high sheen.

the short distance on the drill press. It is very important to have the smoke hole at the *bottom* of the tobacco hole, not above or below.

The commercial pipe stem can be chucked now and turned down to fit the shank. Pipe stems are sold in the molded state with flash on the dividing halves. Nylon is the best but more difficult to get than the more common Vulcanite black rubber bits. Pipe stems come in [*Continued on page* 165]



Want To Make A Pipe?

[*Continued from page* 119]

various lengths and shapes—round, oval and square. The tenon length is not included as part of the length when ordering.

When the stem is properly fitted remove the excess briar block without destroying the final shape of the pipe by taking off too much material. Using band saw, belt or disk sander, lay the piece on its side and cut along the contour edge of the bowl where you stopped turning. Continue to remove excess briar in this method, being careful not to get within the outline of the finished pipe contour.

Next, on your workbench, file and rasp the final shape; then, sand with a medium grit aluminum oxide cloth and finish with a fine grit.

If you want to carve the pipe, do this during the bench work after sanding has been completed. Use a high speed, 22,000 rpm flexible shaft type drill, having a collet chuck that will hold ⅛-in. diameter shanks. You can use various shapes of rotary files to get many types of grooves.

When the pipe has its final shape, is smooth and shows no scratches, it is ready for staining. Stains can be various colors, black, walnut, light or dark, depending on amount of powder used.

You are now ready to buff the pipe and stem with Tripoli. At this time a few light scratches will appear. Use Green Bar Tripoli for heavy buffing to take out deep scratches and Brown Tripoli for light scratches, then polish, using Blue Buffing Tripoli on the stem.

The bowl can be polished with Carnube Wax or with a specially prepared polish. Wipe a little polish on the wheel and buff with an even pressure all around, using a clean flannel buff.

When smoking, don't load your new pipe full the first few days. Have several pipes rotating each week and keep them clean inside and out.

Some of the materials mentioned in this article can be obtained from the following: J. H. Lowe, Box 78, Wantagh, N. Y., for chucks, stems, wax, aluminum fittings, Tripoli, polish, etc. Highlands Briar Inc., Box 72, Kew Gardens, N. Y., for first grade Algerian or Italian Briar. National Briar Pipe Co., Inc., 44 Montgomery St., Jersey City 2, N. J., for first grade briar. •

Golden Hammer Awards

[*Continued from page* 133]

Elizabeth, S. Africa . . . G. Bratt, Birmingham, Eng. . . . Richard W. Warren, St. Joseph, Mich. . . . Harry Petrover, Haifa, Israel . . . Charles Stafford, Bangor, Mich. . . . Lowell E. McMeeken, Shelby, Ohio . . . Sam Ingala, Chicago, Ill. . . . Arthur Ridgeway, Pendleton, Ind. . . . S. Machrone, Roselle, N. J. . . . Charles B. DeWalt, Paxton, Mass. . . . Robert D. Trautman, Rapid City, S. D. . . . Henry P. Stremmel, Hanover, Pa. . . . Roger P. Dunn, New Albany, Ind. . . . Harry G. Mills, Independence, Mo. . . . Joe C. Forbis, Irving, Tex. . . . Herbert H. Eller, Bel Air, Md. . . . A. W. DeNovellis, Lafayette, Colo. . . . Charles R. Goudy, Newport, Del. . . . Joe W. Brown, Decatur, Ga. . . . William O. Blanch, Baltimore, Md. . . . James R. Moorhead, Beaver, Pa. . . . Gordon G. Pratt, Pierre, S. D. . . . H. R. Murdoch, Vancouver, Can. . . . Robert V. LeDuc, Clark, N. J. . . . William Berg, Leipsic, Ohio . . . LaMar Scadden, Ogden, Utah . . . Thomas P. Richards, Elyria, Ohio . . . Albert S. Salonen, Lubbock, Tex. . . . Gerard Breslin, County Donegal, Ireland . . . Pierre Vezina, County Labelle, Quebec, Can. . . . Carl E. Hanson, So. Easton, Mass. . . . George O. Tapping, Newmarket, Ontario, Can. . . . Charles A. Schuster, Menomonie, Wis.

Air-Condition Your Car

[*Continued from page* 160]

idling fast (about 20 mph). Remember to keep all windows closed during operation of the system.

If problems are encountered during installation of your air conditioner, it's a good idea to check with your local refrigeration expert. He can help you over the rough spots and suggest innovations applicable to your particular make of car.

The cost of air conditioning your car in terms of time and money will be repaid many times over in the coin of pleasant, comfortable motoring and in the reduction of driver fatigue. •

PARTS LIST

Part	*New*		*Used*
Compressor	$ 55.00		$ 8.00
Evaporator	15.00		3.00
Condenser	23.00		4.00
Dehydrator	3.94		1.00
Neoprene hoses	10.50	(new)	10.50
Bracket	4.55		4.55
Blower	15.00		4.00
Evaporator enclosure	3.00	(hand made)	3.00
Insulation	.20		.20
Expansion valve	12.07		1.50
Tubing, 8 feet	.80	(new)	.80
	$143.06		$40.55
Belt	1.85		1.85
	$144.91		$42.40

Freon gas about $2.