

## Canteen Flip Top Bag with Center Feature:



### Materials:

#### Wood

- 2 discs of wood for body of bag  
6-9" in diameter  
8/4 thickness
- 1 small piece of feature wood – spalted, burl or interesting figure  
1/2 – 1" thick, sufficient for disc with desired diameter
- 4-8 “Biscuits” of feature wood or other contrasting wood (optional)
- 4/4 wood for waste blocks

#### Supplies

- 2 sided turner’s tape
- Masking tape
- Yellow wood glue
- Medium thick CA glue
- Deft Satin Spray Wood Finish
- Bullseye spray Shellac

#### Tools/Accessories:

- Lathe
- Bandsaw
- Drill press and drill bit assortment
- Faceplate
- Biscuit joiner (Optional)
- Wood clamps (3)
- Dividers and calipers
- Flexible straight edge
- Leather punch and rivet set
- 1/4 inch Forstner bit.
- 1/4 inch dowel center
- Gouge, scraper, parting tool

## Hardware/Leather

- Hinges (2)
- ½ to ¾ inch leather strap – 50 inch length
- Strap Loops (2)
- Latch or ¼ inch rare earth magnets (2)
- Rivets
- Screws

## Turning the Bag

Cut two identical discs from 8/4 wood. Mark the center of each disk. Adhere two discs together with two sided turners tape with center markings on outside. Make sure that tape remains approximately one inch from the external edge. Clamp for 20 minutes to activate pressure sensitive tape. Cut circles for waste blocks. Mark center of waste block circles. Drill holes in center of waste blocks. Center waste blocks on discs and glue with CA glue so that you have a waste block glued on the center of the front and back of the taped discs.

When waste block glue is dry, mount the entire assembly on the lathe. Bring the tailstock up and ensure the tailstock is perfectly centered. Rotate the assembly and ensure that the line between the two discs is perfectly centered vertically.

Rough out the external shape of the purse. Decide whether purse will be canteen shaped or more rounded. As you turn, observe the outline at the top of the bag to achieve uniformity between the two halves. When you are satisfied with the shape, sand areas within reach. With a very sharp parting tool, divide the two halves carefully at the seam, inserting the tool one inch or less.

Remove the assembly from the lathe and carefully divide the two discs and remove the turners tape. Remount one of the discs on the lathe. Hollow the disk so that the external shape matches the internal shape and the wall thickness is a uniform ¼ to 3/8 inches. Sand the interior and finish it with spray Deft or Bullseye Shellac. Using a very sharp tool, ensure that the edge of the form is square and perfectly parallel to the headstock. Mount the second disc on the lathe and hollow to identical shape and thickness. Sand and finish interior with Deft. Ensure that the edge is square. Leave the second disc mounted on the late.

Spread yellow glue evenly on the edge of both forms. Match up the edges of the hollowed discs carefully and bring the tailstock up on the wasteblock. Clamp the discs together. Remove the assembly from the lathe and let the glue dry.

## A word about decorative biscuits.

The handbag you have just turned is held together by a very narrow glue joint. A decorative reinforcement can be achieved by using a biscuit across the joint in the style of Jerry Kermode. To do this, trace a biscuit on a piece of thin wood the same thickness as a commercial biscuit. Cut the biscuit in half lengthwise. With the glued bag on the

lathe, mark where the biscuits will go with a pencil. Set the depth of the biscuit joiner blade so that the blade will just cut through the thickness of the vessel wall.

Center the central pin of the biscuit joiner on the seam where you have made your pencil mark. Lock the head of your lathe. Rest the biscuit joiner on the toolrest. **HOLD ON TIGHT.** Turn on the biscuit joiner and plunge the blade carefully ensuring that it does not wander. You want a single clean cut that just pierces through the vessel wall at the center point.

Take one half biscuit, spread CA glue in the slot. Insert one half biscuit with the rounded side down. Using a mallet, hammer the biscuit into the slot. Generously spread Medium thick CA glue around the edges of the biscuit and hit with accelerator. Insert all of the biscuits in this manner. When glue has dried, trim external pieces of biscuits with a carving tool. Cut from the center of the biscuit toward the edge. When the biscuit is nearly flush with the surface, turn on the lathe and trim the biscuits flat. Sand.



### **Making and mounting the Feature Disc:**

Decide what size you want your feature circle and cut feature wood into the right size circle. Center and mount the circle on a faceplate with turners tape. Turn a disc.

You have two options. The disc may fit into an opening you will turn on the front of the bag, or it may fit into a recess on the front of the bag.

- If it will fit into a recess you turn on the front of the bag, the disc you turn should be thin and flat on the back. Sand the front and remove from the lathe.
- If you intend the disc to fit into an opening, you should turn it approximately the same thickness as the bag walls. Consider whether to slightly hollow the back of the disc to replicate the inner profile of your bag. On the back, leave a 1/4 to 3/8 inch around the edge flat, thin the center part of the disc so that the finished piece is the same thickness as your bag walls. Sand. Finish the inner side with lacquer or shellac. Remove from lathe.

Remove clamps and remount glued disc assembly on lathe. Plan which side of the bag will be the front and mount with the back facing the headstock, and the front facing the tailstock. With the tailstock engaged, slowly spin the glued discs, correct any irregularities, clean up the glue line, and sand.

Turn wasteblock off the front and sand surface. Measure your feature disc using your dividers.

- If your disc is intended to sit in a recess, scribe the face of the bag with dividers, making a circle the same size as your feature disc. Incise the divider line, and remove material within the line to the appropriate depth to fit your disc carefully testing your fit. Decide what is the top and the bottom of your bag, and the top and bottom of your feature. Glue the disc into the recess, using a generous amount of CA glue and accelerant. Allow the glue to go off. Turn the surface of the disc to achieve the profile you want, clean up the line around the edge and finish sand all portions of the bag that you can reach.
- If your disc is intended to fit into an opening, scribe the face of the bag with dividers, making a circle the same size as your feature disc. . Then scribe a circle  $\frac{1}{4}$  to  $\frac{3}{8}$  inch smaller than your feature disc to form the rim on which your feature disc will sit. Using a very sharp parting tool, cut through the bag on the smaller circle. Using a square scraper, create a recess from the cut edge to the larger circle you have scribed. The feature disc will rest on this recess. Sand the edge smooth. Apply glue to your feature disc and the recess. Decide what is the top and the bottom of your bag, and the top and bottom of your feature. Glue the feature disc being careful not to get excess glue in the interior of your bag. Turn the surface of the disc to achieve the profile you want, clean up the line around the edge and finish sand all portions of the bag that you can reach.

Remove the bag from the lathe. Use a vacuum chuck to remove the wasteblock from back of bag and sand. If you do not have a vacuum chuck, carve the wasteblock off the back of your bag with carving tools, mount a sanding disc in your drill press and finish sand the back of the bag.

### **Cutting the bag.**

Decide how you want to divide the bag to create the top and the body of the bag. Using a flexible straight edge, mark the dividing line with a pencil or chalk. If your bag is relatively flat, cutting the line on the bandsaw is straight forward. If your bag is rounded, you will need to use wedges or props to ensure that the bag remains completely flat as it travels through the bandsaw. You only have one chance to cut the bag, as if you make two cuts, the top and bottom will not line up. Carefully cut the bag along the line you have drawn. Sand the edge to remove the bandsaw blade marks.

### **Applying the Hardware:**

Apply a piece of masking tape to the bottom of your strap loop and use a pencil to punch two holes through the tape on the bottom of the hardware. Place the tape on the side of the bag and use this tape as a template to determine where to drill your holes. Insert the screws from the inside of the bag and screw them into the bottom of the strap loops. If your screws are too long, use a jeweler's saw to cut them down.

When the strap loops are attached, tape the top of the bag and the bottom of the bag together securely and place the bag face down on a towel or other soft surface on your worktable. Place your hinges on the back of the bag and secure them with a drop of CA glue. Drill partial pilot holes and attach hinges with screws.

Canteen bags use rare earth magnets for closure.

To install rare earth magnets, drill holes with ¼ inch Forstner bit on opposite edges of the top and bottom. Holes should be a little deeper than the depth of the magnet. Secure magnets with industrial glue. CA glue tends to be brittle, and not a good choice for magnets.

Remove tape and open bag. Ensure that screws have not come through. If they have, sand down points, and reapply deft.

Finish sanding bag and apply any surface treatment or finish.

### **Other Options for this Form**

