

Turning a Train Whistle - Neal Brand

- Start with 2 by 2 blank at least 5 inches long.
- Mount the blank on the drilling jig. Drill four 3/8 inch diameter holes. (4, 3.5, 3 and 2.5 inches long.) Or you can drill on a drill press with each hole centered at $\frac{3}{4}$ inch from two sides.
- Mount on centers and turn to a cylinder approximately 1.5 inches in diameter.
- Mark $\frac{1}{2}$ inch from drilled end and make a V-cut with the edge close to the drilled end perpendicular to the surface. Go at least $\frac{1}{2}$ way through the 3/8 inch holes. Make a clean edge where the V-cut meets the drilled holes by removing fibers that extend out of the edge.
- Reduce diameter of $\frac{1}{2}$ inch end to get very close to the holes.
- Decorate if you wish.
- Cut off end and sand the end. I use a belt sander and simply roll the whistle body on the base of the sander.
- Flatten dowel to make "reeds." Remove about 1/4 of the diameter.
- Insert and adjust each dowel so they sound good. Move them in and out and maybe even rotate them. Cut the dowls flush with the end of the whistle body.
- Make the mouth piece using a 2 by 2 blank 2 $\frac{1}{2}$ inches long.
 - Drill using 3/8 inch bit.
 - Hollow to fit the body.
 - Turn the outside.
 - Part and sand end.
- Glue the body to the mouth piece and try out the whistle!

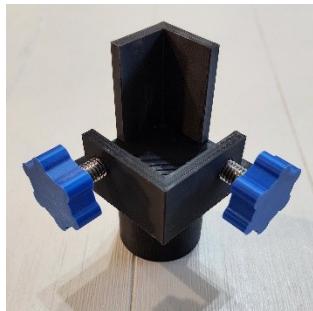
Blanks:

2 by 2 inch blank 5 inches long

2 by 2 blank at least 2 $\frac{1}{2}$ inches long

(4) 3/8 inch dowels, each at least an inch long

Jigs:



This is the drilling jig. You can download a 3D file by searching "train whistle chuck jig" at thingiverse.com. Alternatively, you can make one using wood. Make the platform 2 1/8 inches by 2 1/8 inches (just a bit bigger than 2 by 2 to make it easy to mount a 2 by 2 blank) Thread the base to fit your lathe and attach to the platform so the point on the platform that is $\frac{3}{4}$ inch from the two long sides is centered on the base. Thread the short sides and use bolts to secure the blank.



This is a handy jig for sanding the dowls. To make it, drill a 3/8 inch hole into a blank and then cut or sand the blank to expose the hole.