

5. Draw two circles for the flanged insert;

A. 1 3/4" circle represents the 1 3/4 hole for the cup

B. 2" circle represents the inset for the flange

C. If you are not using a flanged insert skip this step just marking the center is sufficient or if you feel confident that you will remember which side is intended to be the top

6. Use a band saw to rough cut the blank to a circle

7. If using a screw chuck, drill a 3/8" hole if using an Oneway chuck (or the size that fits your screw chuck) in the center of the top where the frog (flower arranger insert) will be inserted later. If turning between centers, use a mallet to insert the two prong spur drive in the top. The bark side should face the head stock as that is usually the preferred top side. **Tip:** *I have started pre drilling the hole for the insert on my drill press for two reasons one to save time when doing a production run and the other to make it possible to mount directly on the chuck. If using this method, I mount the blank onto the chuck using the chucks #1 jaws. If pre-drilling the hole remember to drill it a tad deeper as the top has not been faced off. When using a screw chuck the top must be fairly flat for the piece to seat properly on the chuck to minimize vibration.*

8. Rough out the bottom shape. Leave a large foot for mounting in a chuck. Your foot can be designed to be gripped either externally or internally. I now prefer to grip my foot internally (I expand the jaws into the foot) so that I can always remount the vase if I need to work on it at a later date. Occasionally it may get damaged at some point and need some touch

up work The foot needs to fit the jaws of your chuck but should be approximately 1/3 of the diameter of the vase plus or minus as your design permits as this is a functional piece.

9. If using an internal grip foot you can go ahead and sand the bottom. This is another reason why, I now prefer to use an internal (or expansion) grip design on my feet as it saves having to reverse turn the vase.

10. Mount in the chuck. Next, using a Jacobs chuck with a 1 3/4" forstner bit, drill the hole for the frog to the depth of the frog (flower arranger insert) plus the flange adding a bit of depth to compensate for shaping and sanding. **Tip:** *If you have predrilled the hole, for the insert skip this step.*

11. I use a 3/8" beading and parting tool or a flat nosed scraper to make the recess to accept the flange on the frog (flower arranger insert). I sneak up on the final size of the recess stopping the lathe often and testing the fit with the flanged vase insert reversed. Leave a little space between the edge of the flange and the edge of the wood on the top to accommodate any wood movement due to changes in humidity. With some frogs you may need to round over the edge where the hole meets the flange recess to accommodate the welded joint where the flange attaches to the cup.

12. Shape the top and final sand it.

13. If you need to reverse turn the vase? You can expand a set of #1 jaws into the hole that was drilled for the insert.

14. Finish with your preferred finish. On dark woods I use Watco Danish oil, let it sit for a week or more and then apply Watco gloss wipe on poly or spray it with lacquer.

15. I use a dab of clear silicone caulk on the bottom of the frog to keep it from dropping out when customers invariably turn the vase upside down to look at the bottom.

16. Find three exotic flowers, cut them to different lengths, add water and step back to admire your beautiful work