



MATERIAL:

BRASS NAME = (SPECIAL SHAPES Co.)

1) BODY = (FS-16) .016 X 1.50 X 4.00

OR (TT-840) 1 1/4 TUBING

2) LIPS = (F-1-4) 1/32 X 1/8 X 4.31

1) SIDE SEAM = (F-1X-4) 1/64 X 1/8 X 1.25

2) EARS = (F-1-4) 1/32 X 1/8 X .31

1) HANDLE = (R-45) .045 X 2.63

1) TILT = (R-3) .032 X 1.56 - OPTIONAL

1) BOTTOM = (FS-16) .016 X .0131

- OPTIONAL IF BOTTOM IS VISIBLE

RIVETS = (GRANT LINE PRODUCTS)

1) #154 (Ø.043)

1. WRAP BRASS BODY AROUND 1 1/4 WOOD DOWEL, CLAMPING WITH A HOSE CLAMP. AT 4.00 THE BRASS WILL OVERLAP ITSELF. SHORTEN TO 3.93 TO ELIMINATE LAP JOINT. TACK SOLDER JOINT.
2. SOLDER LIPS TO TOP AND BOTTOM OF THIS CYLINDER. TOP LIP SEAM 90° FROM BODY SEAM.
3. PLACE SIDE SEAM UNDER HOSE CLAMP AND OVER BODY JOINT, OR LINE UP WITH LAP JOINT.
4. SOLDER ON A BOTTOM IF REQUIRED.
5. CUT OUT RIVET PATTERN.
6. USE SPRAY ADHESIVE ON BACK OF PATTERN AND GLUE TO COAL BUCKET. CENTER PUNCH FOR RIVET HOLES (WITH 1-1/4 DOWEL STILL INSIDE THE COAL BUCKET TO PREVENT "OIL CANNING" WHEN HAMMERING.)

7. DRILL 2Ø 1/32 HOLES HOLDING COAL BUCKET IN A 90° 'V' BLOCK.
8. REMOVE 1 1/4 DOWEL.
9. DRILL 2) 1/32 & 2) 3/64 HOLES IN EARS
10. ALIGN ONE EAR OVER LIP JOINT AND OTHER 180° ON OTHER SIDE AND SOLDER.
11. PUDDLE CA MEDIUM VISCOSITY GEL ADHESIVE, USING TWEEZERS PLACE RIVET STEM IN CA AND INSERT INTO HOLES.
12. CLEAN UP STEMS INSIDE OF COAL BUCKET.
13. BEND A LONG LENGTH OF Ø.045 WIRE OVER 1-1/4 DOWEL. LAY ON THIS PATTERN AND BEND ENDS WITH A FLAY NOSE PLIERS. THEN CUT OFF TABS AFTER INSERTING INTO BUCKET.
14. PAINT HANDLE AND COAL BUCKET WITH FLOQUIL ENGINE BLACK. SPRITS SPARINGLY WITH VALSPAR TERRACOTTA AND TAMIYA RED BROWN REPRESENTING RUST. ADD SOME GRAY CHALK FOR SOOT.
15. ADD COAL. (REPLACE DOWEL TO REDUCE THE AMOUNT OF COAL REQUIRED TO FILL BUCKET.)

