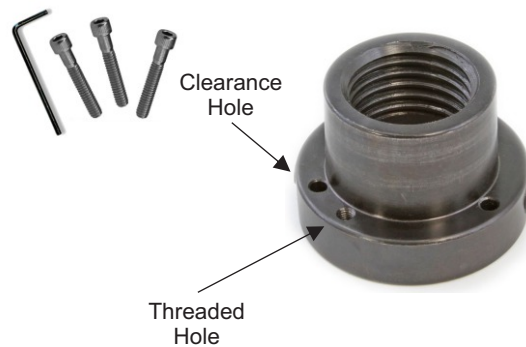


Installing or Changing The Threaded Spindle Insert

Your chuck is capable of fitting on many different models of lathe by installing the appropriate threaded spindle insert to match the spindle thread on your lathe. The adapter is a precision fit and must be installed properly to maintain the excellent accuracy of this chuck. Installing or changing the adapter is easy if you follow the instructions below. NEVER remove the adapter with pliers or by prying it off.

Each adapter has five holes in the outer rim. The THREE clearance holes are used when INSTALLING the adapter onto the chuck. The TWO threaded holes are used when REMOVING the adapter from your chuck.



To INSTALL the insert:

Insert the three M3 socket head cap screws through the clearance holes in the insert and line up the screws with the threaded holes in the chuck. Using the 3mm Allen wrench provided, tighten the three screws in small increments, alternating screws until all are tight. This will pull the insert into the chuck evenly, providing the best concentricity to your lathe spindle. Continue until the three screws are tight.

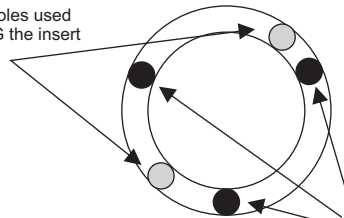
To REMOVE the insert:

While the insert is still in the chuck, completely remove the three M3 socket head cap screws holding the insert into the chuck. Take TWO of the screws, and insert them in the THREADED holes in the insert. Turn each screw a slight amount, alternating between screws, this will provide even pressure against the chuck body and after a few turns, the insert will come out easily. NEVER pry the insert out of the chuck as this may damage the insert and/or chuck.

Remove the two screws from the insert and they can be used again for installing a different insert.

If you have any questions, call us at (631) 489-9000

2 THREADED holes used
when REMOVING the insert



3 CLEARANCE holes used
when INSTALLING the insert

Visit our website at:

www.thewoodturningstore.com

Call us at (631) 421-8665 or email at sales@thewoodturningstore.com

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Installation Instructions



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