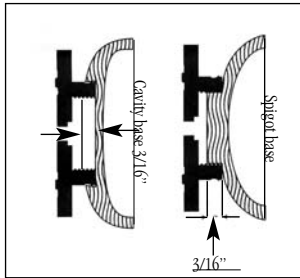


Chuck Gripping Depth

When turning a large piece such as a bowl, for safety reasons, allow a minimum amount of wood for the chuck to grab while turning.

1. Cavity base (inside grip) – for a 2" diameter base, minimum hole depth is 3/16".
2. Spigot base (outside grip) – for a 2" diameter base, minimum grip is 3/16".



Lathe Speeds

Turning: 500-1500rpm

Sanding & Polishing: 1500-2500rpm

Make sure your wood is properly aligned and balanced when mounted or re-mounted. Use slower speeds for larger work.

Maintenance

Brushing is all that is needed to clean your chuck. If the chuck becomes sticky, soak in varsol or mineral spirits with 10% oil added. Soak for thirty minutes and blow dry.

Accessories

LATHE SPINDLE CONVERTERS

- #LABAR418 - 1-1/2" x 8tpi to 1" x 8tpi
- #LABAR4114 - 1-1/2" x 8tpi to 1-1/4" x 8tpi
- #LABAR4M33 - 1-1/2" x 8tpi to M33 x 3.5

EXTRA JAWS

- #BARR4FJ3 - 8-1/2" Jumbo Flat Jaws

4-Jaw Self-Centering Key Chuck System

The Ideal Chuck for Midi and Full Size Woodworking Lathes



Product CSCBARR4

BarrAcuda 4



Warranty

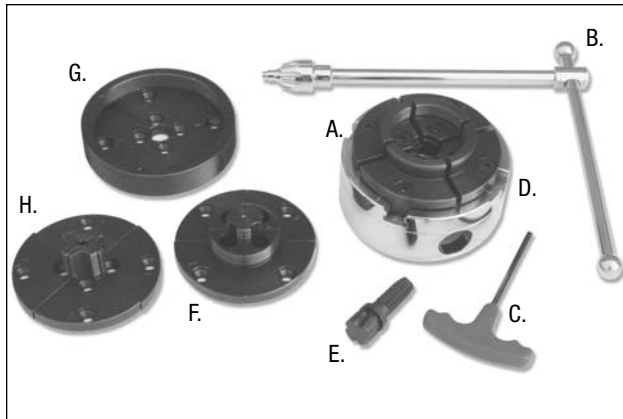
Thank you for purchasing one of PSI's growing family of woodworking products. The #CSCBARR4 is engineered and manufactured to the highest standards of quality. You will find this lathe chuck an essential accessory to your workshop.

This product is warranted against defects in material and workmanship for a period of two years for all components. This warranty applies to the original purchaser of the product and is limited to the repair and/or replacement of the product, or its parts at the discretion of PSI Woodworking Products. Excluded are parts which have been misused, abused, altered, or consumed by normal operation of the chuck. Also excluded are direct or consequential damages to persons, properties, or materials. Your invoice serves as proof of purchase and must be referenced to authorize any warranty repair. Call your PSI dealer for proper authorization.

Safety Instructions for Chuck System #CSCBARR4

1. Do not wear gloves or loose clothing when turning
2. Do not wrap any strip sandpaper or clothing around your hands or fingers when sanding or turning.
3. Use proper eye protection when turning.
4. Check your wood for splits, weakness or cracking prior to mounting on the chuck.
5. Confirm that the wood is tightly gripped before turning your chuck under power.
6. Rotate the chuck manually prior to starting your lathe to confirm proper clearance.
7. Always check and re-tighten after any problem or catch.
8. Use appropriate speeds as referenced in instructions.
9. Always turn with sharp lathe chisels.
10. Capture fine particles from the air with a dust collector.

Package Contents



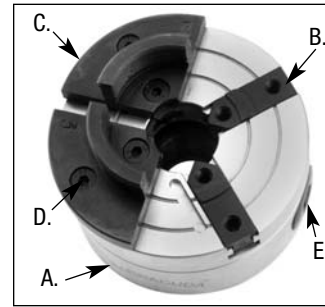
- A. CSCBARR4 Barracuda 4 Key Chuck (pre-threaded to 1-1/2" x 8tpi)
- B. Gear tightening wrench
- C. Hex wrench (removes jaws)
- D. 1 set (4 pieces) of #2 round jaws (pre-mounted to chuck)
- E. Screw chuck
- F. #1 step jaws
- G. #3 wide jaws
- H. Extended pin jaws
- I. Wooden Carrying Case (unshown)

Jaw Capacity Chart

Jaw Style	Gripping Dowel Outside Diameter	Gripping in Hole Inside Diameter
#1 Step Jaws	3/16" to 2-1/4"	15/16" to 3"
#2 Round Jaws	1-3/4" to 3-11/16"	2-3/8" to 4-1/2"
#3 Wide Jaws	3-11/16" to 5-9/16"	4-3/8" to 6-1/2"
Pin Jaws	1/4" to 2"	1-1/8" to 2-7/16"

PSI CSCBARR4 Barracuda 4 Key Chuck

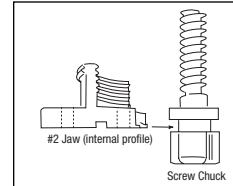
Chuck System Description



- A. Main body: designed to hold all jaws as an assembly.
- B. Carrier: to which the top jaws are each attached with one or two hex screws.
- C. Jaws: attached to the carrier, used for gripping the wood piece to be turned (#2 round jaws are shown in the photograph on left).
- D. Socket hex screws: attach jaws to chuck (2 per jaw).
- E. (2) Wrench tightening holes: insert and turn key to secure grip

Installing the Jaws

Select the appropriate jaw for your project. Place the selected jaw on top of the carrier, matching the number stamped on the main body to the number on each individual jaw. Using the provided hex wrench and the hex set screws, firmly tighten the jaw down onto the surface of the carrier. Repeat this step for the remaining three jaws.



Installing Screw Chuck

This screw chuck mounts directly into the #2 round jaws. To safely secure the chuck, insert into the recess of the spindle at the base of the chuck; on the sides of the jaws (see illustration). Then proceed to close and tighten the jaws to secure into place.

Mounting the Adapter



1. This chuck is supplied pre-cut with 1-1/2" x 8tpi threads. If your lathe's spindle threads are different than that size, check the Penn State Industries' catalog for the appropriate adapter for your lathe.
1. Wipe the inside of the threads and the outside to insure that both surfaces are clean prior to mounting.
2. Hold the chuck in your hand, screw and tighten the adapter into the bottom threaded portion of the chuck.
3. Use the same procedure when using any adapter.

Mounting the Chuck to Your Lathe

Screw the completed assembly onto your lathe. The chuck should go on effortlessly with no binding. Screw the chuck all the way until the adapter face contacts the shoulder of the lathe spindle. Lock the spindle, slightly unscrew the chuck and give it a firm spin. This will snap the chuck firmly in place.

Operating the Chuck

Mount chuck onto the lathe headstock. Insert key wrench into a square key hole on the side of the chuck. Rotate key wrench to open and close jaws.

PSI CSCBARR4 Barracuda 4 Key Chuck