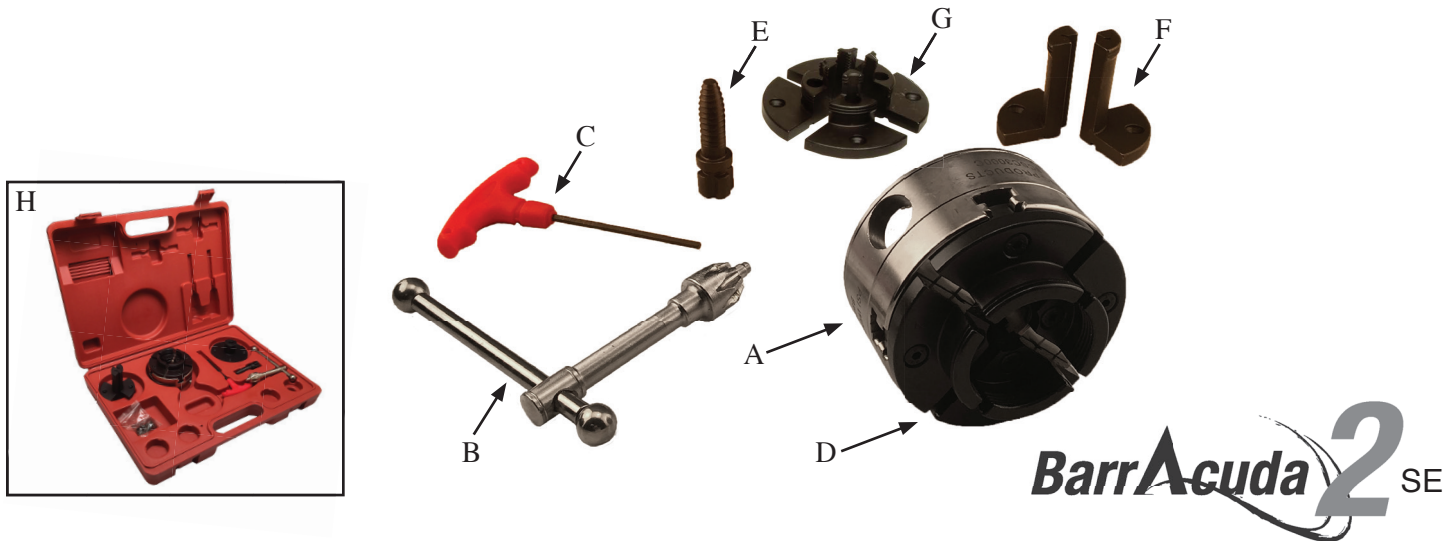


# 4-Jaw Self-Centering Key Chuck System

Product CSC3500SE *The Ideal Chuck for Midi and Full Size Woodworking Lathes*



## Package Contents

- |   |                            |
|---|----------------------------|
| A. CSC3000C Chuck Body                                      | F. Pen Blank drilling jaws |
| B. Key tightening wrench                                    | G. Step Jaws               |
| C. Hex wrench (removes jaws)                                | H. Blow-molded case        |
| D. 1 set (4 pieces) of #2 round jaws (pre-mounted to chuck) |                            |
| E. Screw chuck  |                            |

## Safety Instructions

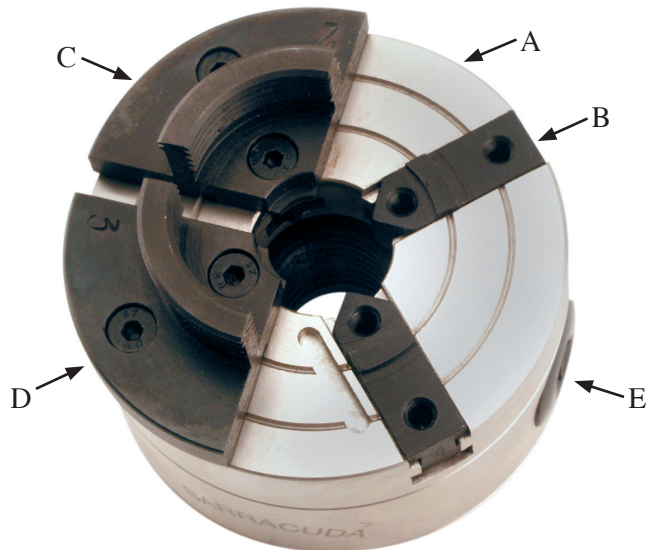
- Do not wear gloves, neck ties, long sleeves, loose clothing, or loose jewelry when turning. Long hair should always be tied back.
- Wear safety goggles or a face shield when turning.
- Wear sturdy shoes or boots with non-slip soles. Avoid open-toed shoes.
- Check your wood for splits, weakness, voids or cracking prior to mounting on the chuck. Avoid using wood with knots, splits, or other defects.
- Confirm that the wood is tightly gripped in the chuck before starting your lathe. Use a tailstock center for additional support when necessary. Never run the lathe without a workpiece in the chuck.
- Rotate the chuck and workpiece manually prior to starting your lathe to ensure proper clearance.
- Always check and re-tighten the workpiece to the chuck after any loosening or tool catch.
- Use appropriate speeds.
- Do not wrap sandpaper or finishing cloths around your hands or fingers when turning.
- Always turn with sharp lathe chisels and gouges. Avoid dull tools.
- Feed a woodturning tool slowly and steadily into the stock being turned. Never jam or stab the tool's blade into the work piece.
- Capture fine particles from the air with a dust collector. Use a quality respirator or dust mask when turning.
- Remove the tool rest before sanding or finishing your turning.
- Chuck should be properly tightened onto Spindle.
- Never stop the lathe from spinning by grabbing the tailstock flywheel.

### Jaw Capacity Chart

Jaw Style	Gripping Dowel Outside Diameter	Gripping in Hole Inside Diameter
#2 Round Jaws	1-1/2" to 2-5/8"	2" to 3-3/8"

### 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 below).
- D. Socket hex screws: attach jaws to chuck (2 per jaw).
- E. Wrench tightening holes: insert and turn key to secure grip.



(Shown with two #2 round jaws installed)

### 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.

### Maintenance

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

### Mounting the Chuck to Your Lathe

The chuck is supplied with an internal 1" x 8tpi thread. This size fits the spindles of most modern mini/midi lathes. If your lathe has a different spindle size it will be necessary for you to purchase an adaptor that connects from your spindle to 1" x 8tpi. Screw the chuck onto your lathe. The chuck should go on effortlessly with no binding. Screw the chuck all the way until the chuck or 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.

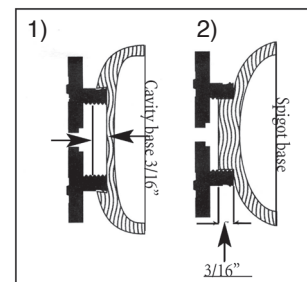
### Operating the Chuck

Always support your wood piece with a tailstock live center for safety. Select the jaws that provide the best internal or external gap for the work being turned. Use the chuck key to securely tighten your work.

### Chuck Gripping Depth

When turning a bowl, for safety reasons, allow a minimum of 3/16" 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.