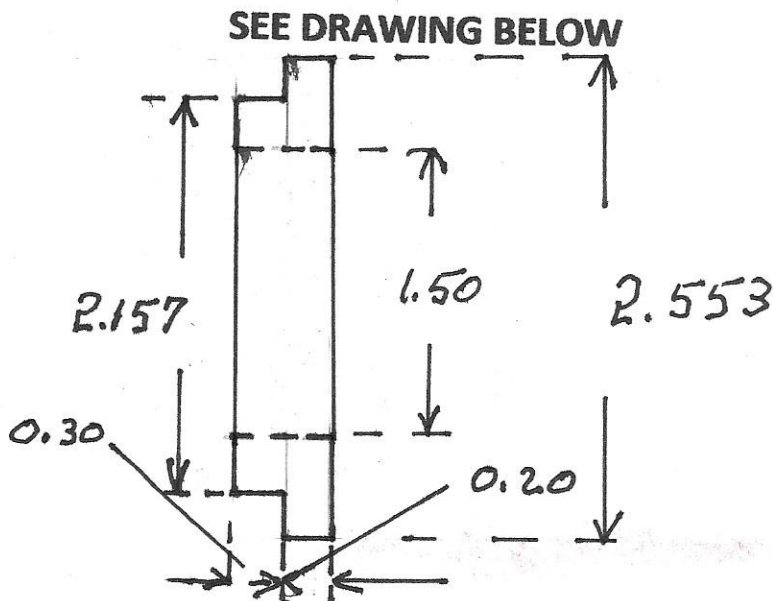


ADAPTING 4 JAW CHUCK TO MILL TURN

Due to a change in design from the chuck manufacturer, the 4 jaw chuck no longer fits over the shoulder of the machine faceplate and now has a narrower bolt pattern and smaller diameter locator hole in the center. Follow these instructions to mount your 4 jaw chuck.

1. Remove the 3 jaw chuck by loosening the 3 bolts. The chuck is a snug fit over a shoulder, so you may need a mallet to tap it loose.
2. Once the chuck is off, measure the diameter of the center hole in the chuck mounting plate.
3. Measure the diameter of the hole in the center of the 4 jaw chuck.
4. You will need to make a stepped sleeve out of tubing or solid bar with 2 diameters- one to fit the mounting plate and the other to fit the chuck. This sleeve will center the chuck on the spindle.



These dimensions are nominal, but to be certain you should measure your individual chuck and mounting plate.

- 5. Once you know your dimensions, replace the 3 jaw chuck and machine your adapter.**
- 6. Once the adapter is finished and is a good fit in both the chuck and mounting plate, remove the mounting plate from the spindle.**
- 7. Place the 4 jaw chuck on the mounting plate using the adaptor to center it. Rotate the chuck so you have a solid place beneath each of the 4 mounting holes and using a transfer punch, mark all 4 places for the mounting holes.**
- 8. Drill the holes out to 9 MM and tap them with a 10 MM X 1.5 tap.**
- 9. Bolt the chuck to the plate and check the bolt length- you may need to trim the bolts so they do not protrude beyond the plate.**
- 10. You can now replace the mounting plate on the spindle and you will be able to change from 3 jaw to 4 jaw easily.**

HINT- you might want to secure the adapter into the 4 jaw permanently using some Loctite bearing seal.