



Barracuda

Micro Self Centering Key Chuck System

Product CSC500K

The Ideal Micro Chuck for Mini and Midi Woodworking Lathes

Warranty

Thank you for purchasing one of PSI's growing family of woodworking products. The #CSC500K is engineered and manufactured to the highest quality standards. You will find this product an essential accessory to your workshop.

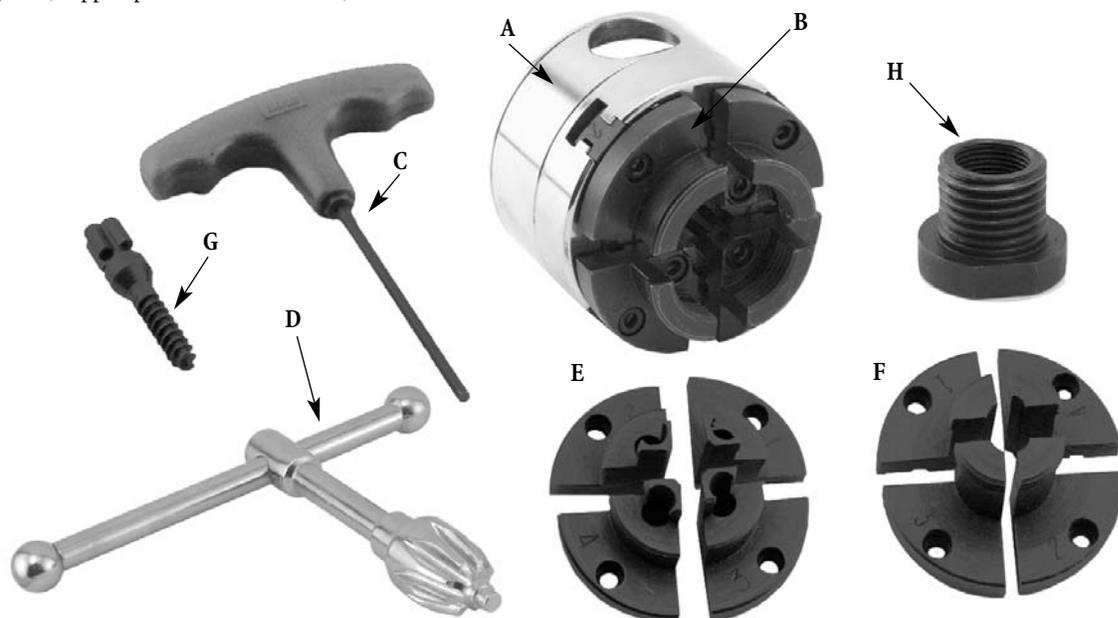
This product is warranted against defects in material and workmanship for a period of two years for all components. This warranty applies to the original purchaser of the product and is limited to the repair and/or replacement of the product, or its parts at the discretion of PSI Woodworking Products. 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 #CSC500K

1. Do not wear gloves or loose clothing while turning
2. Do not wrap any strip sandpaper or clothing around your hands or fingers when sanding or turning.
3. Always 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 these instructions.
9. Always turn work on lathe with sharp lathe chisels.
10. Capture fine particles from the air with a dust collector.
11. Keep clean and lubricate with at light oil as needed.

Package Contents

- A. CSC500K Barracuda chuck (prethreaded for 1" x 8tpi)
- B. 1 set (4 pieces) of #2 round jaws (shipped pre-mounted to chuck)
- C. Hex wrench
- D. Tightening Key
- E. #1 step jaws
- F. Extended pin jaws
- G. Screw chuck
- H. 3/4"x 16tpi adapter

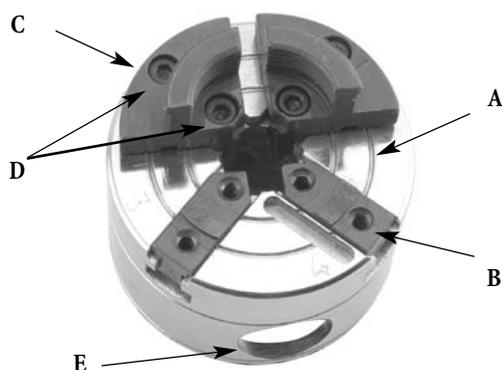


Jaw Capacity Chart

Jaw Style	Gripping Dowel Outside Diameter	Gripping in Hole Inside Diameter
#1 Step Jaws	1/16" to 13/16"	Step 1: 5/8" to 1-5/16" Step 2: 1 3/16" to 1-7/8"
#2 Round Jaws	7/8" to 1-1/2"	1-1/4" to 2"
Pin Jaws	1/4" to 1"	7/8" to 1-5/8"

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. (#4 jaw has tongue which must mate with groove)
- C. Jaws: attached to the carrier, used for gripping the wood piece to be turned.
- D. Socket hex screws: attach jaws to chuck (2 per jaw/ 1per pin jaw).
- E. Key tightening hole: insert and turn tightening 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, firmly tighten the jaw down onto the surface of the carrier with the hex screws. Repeat this step for for the remaining three jaws.

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.

Do not allow wood chips to become compacted in the teeth of the gear mechanism. CAUTION: Gear mechanism should be cleaned in between uses. Excessively dirty gear teeth may lead to mechanical failure.

Mounting the Adapter

1. Wipe the inside of the threads and the outside of the adapter to insure both surfaces are clean.
2. Use the furnished 3/4"x 16tpi adapter if necessary..
3. Hold the chuck in your hand, screw and tighten the adapter into the bottom threaded portion of the chuck.



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.

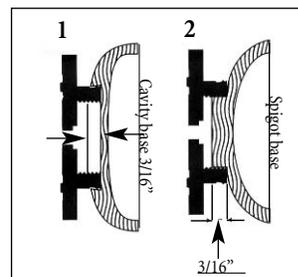
Operating the Chuck

The tightening key aligns with a pivot hole inside your chuck. The tightening key has gear teeth which index with the scroll mechanism inside the micro key chuck. Clockwise tightens, counter-clockwise loosens the jaws.

Chuck Gripping Depth

When turning 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.

