Dedicated Large Blank Drilling Chuck

Features and Components:
- Instant Setup and self Centering - Drill Spindles to 2-1/2” wide.
- Vary the headstock drilling speed to accommodate your blank and bit.
- Reversable Jaws.
- No “travel” limitations of a drill press quill.
- It is not necessary to have a square blank to drill the center of the blanks.
- Fits 1” x 8tpi Headstock thread (will fit other headstocks with proper adapters).
- Includes 2 “tommy bars” to tighten the chuck.

WARNING
- This chuck is designed to drill the end of a blank. Do not use it for turning along the length. A 4 jaw chuck is appropriate for spindle turning applications.
- Do not drill blanks longer than 6” in length.
- Jaws are designed to grab spindle at the corners only.
- Make sure work is secure and balanced in jaws prior to turning on the lathe.

Capacity - (6” max length)
- Standard Jaws 1/4” to 1-1/2” square.
- Reversed Jaws 1” to 2-1/2” square.

Required - Tailstock drill chuck For 1” x 8tpi: #TM22, #TM32.

To Reverse jaws:
- Reversing jaws allows holding blanks up to 2-1/2” square.
- Open jaws until jaws can be removed from chuck.
- Reverse jaws and re-insert into chuck in same channels.
- Keep pressure on both jaws as you close.
- Make sure jaws are evenly centered.