

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.
- Reversible 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.

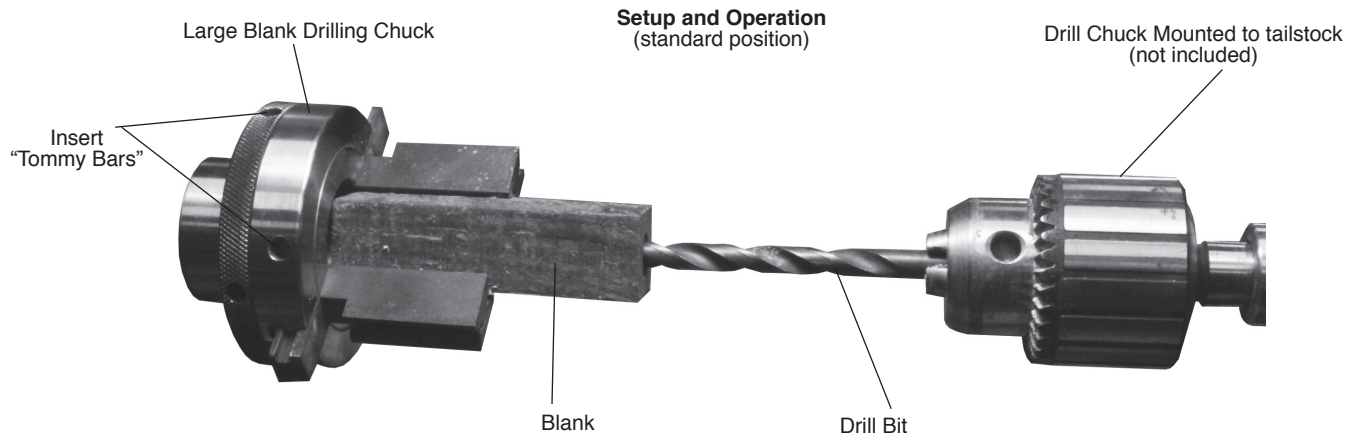
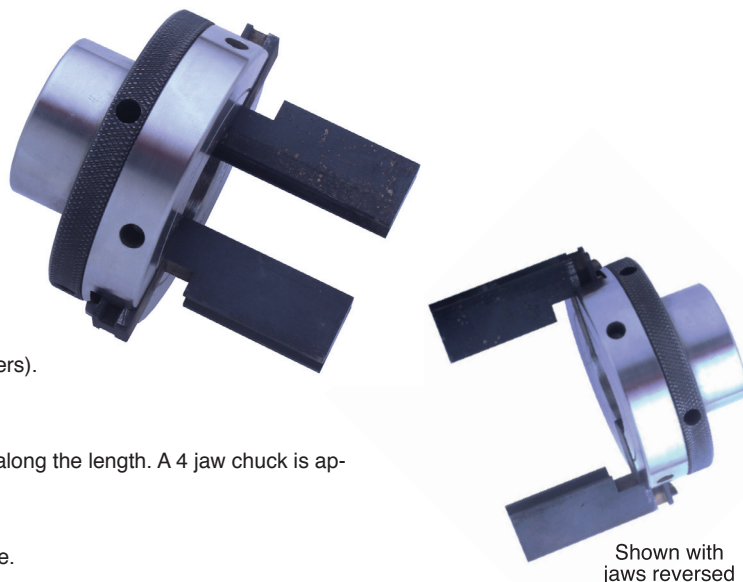
WARNING

- 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.



- If your lathe headstock is not 1" x 8tpi you will require an adapter to mount the chuck onto your headstock. If your headstock spindle is 1" x 8tpi thread the chuck onto your headstock till tight.
- Open the jaws using the 2 "tommy bars" included with the chuck.
- Insert your blanks as far as possible towards the back of the chuck using the grooves in the chuck to grasp the corners of your blanks. (optional: place a small piece of wood behind your blank to avoid "tearout" while drilling.
- Tighten the jaws around your blank.
- Install a drill chuck into the tailstock of your lathe, install the drill bit with the appropriate diameter for drilling the blank. Tighten.
- Re-wind the tailstock quill as far back as possible (without ejecting the drill chuck).
- Advance the tailstock assembly so the drill bit almost touches the blank.
- Turn on your lathe to its slowest speed (or about 600RPM).
- Advance your bit into the blank using the quill handwheel.
- Advance until completely through the blank (note: the chuck is hollow behind the jaws to allow the bit to advance well beyond the end of the blank.
- Back out the bit during drilling as necessary to clear the hole of debris.
- If you have a variable speed lathe, adjust the speed for optimum drilling speed.

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.

