

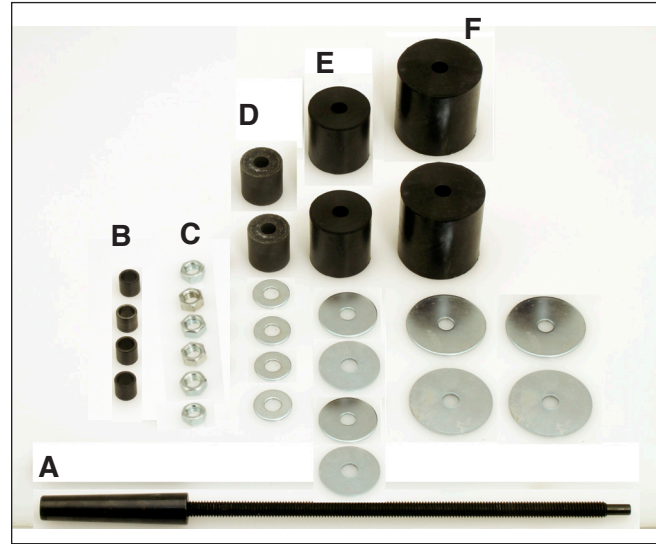
# Mandrel Jam Chuck System w/#MT2

The system is recommended to use in mounting and fastening wooden spindles for turning outer surfaces of items such as pepper mills and others.

## THE PACKAGE INCLUDES:

- A) 9" Threaded mandrel shaft (3/8 x 16 tpi)
- B) 4 spacer bushings
- C) (6) lock nuts (3/8 x 16 tpi)
- D) 3 sets 1" expanding collets w/ washers\*
- E) 3 sets 1-1/2" expanding collets w/ washers
- F) 3 sets 2" expanding collets w/ washers

\***NOTE:** Collets are made to slide inside 1", 1-1/2" and 2" drilled holes



## USING THE SYSTEM:

- Drill the required hole lengthwise through the blank. Drill with a Forstner bit and Forstner bit extension if necessary.
- Arrange the chuck accessories on the mandrel as illustrated in dia. (A)
- Space the collets with the washers to the outer edges of the wooden spindle and wedge with (2) backup nuts at each end.
- Slide the wooden spindle over and center between the collets. dia. (B)
- Mount this assembly onto the lathe drive and lock the tail stock in place for support with a 60° live center.
- Center the wooden spindle between the collets. Use a wrench to turn the lock nuts on each end to expand the collets and lock the spindle in place. Tighten sufficiently to prevent the wood from spinning in the turning process.
- The wood is ready for turning.

