



OPERATION AND MAINTENANCE MODEL D1089 FOUR JAW CHUCK

WARNING

Always disconnect / unplug power from lathe before installing, removing or adjusting chuck. Failure to observe this may result in serious personal injury.

WARNING

Never leave the chuck key in the chuck for any reason. Should the machine be turned on while the chuck key is engaged, it could be propelled into the air and cause serious personal injury.

Assembly and General Use

The STEELEX® Model D1089 Four Jaw Chuck has independently adjustable jaws to hold square or odd shaped stock. It is equipped with reversible jaws for clamping larger pieces. The following instructions will help you use and maintain your new chuck, and with proper care, the chuck will provide years of trouble-free operation.

1. **UNPLUG / DISCONNECT POWER FROM THE LATHE!**
2. Ensure the threaded insert contains the proper threads for the spindle in your lathe. Install the insert in the counterbore in the rear of the chuck. Use the three 10-24 cap screws provided to attach the insert to the chuck.
3. Remove any chuck or spur center on your lathe. Thread the Model D1089 chuck onto your spindle. Screw the chuck on until it seats firmly on the shoulder of the spindle. DO NOT over-tighten.
4. Your Model D1089 Four Jaw Chuck is now ready for use. Open the jaws by inserting the chuck key into each jaw adjusting socket. Open each jaw by turning the chuck key counterclockwise. Insert the workpiece fully into the chuck and tighten the jaws accordingly by turning the chuck key clockwise until the stock is held firmly in the chuck. DO NOT allow the jaws to protrude along the edge of the chuck more than half their length as this could cause the chuck to fracture. For material over 2 1/4" in diameter, reverse the jaws. Maximum capacity of the chuck, with the jaws reversed, is 5 1/4".

Reversing the Jaws

Each jaw is adjusted independently and is equipped with a jack screw assembly. Depending on the shape of the stock, one or all four jaws can be reversed so they can hold odd shaped stock.

To reverse the jaws, do these steps:

1. At the back side of the chuck, remove the nut and washer that hold the jaw jack screw assembly in the slot.
2. Lift the jaw and jack screw assembly from the chuck.
3. Rotate the jack screw assembly 180° degrees so when the jaw is reversed and inserted back into the chuck, the chuck key can adjust the jack screw and move the jaw.
4. Reverse and reinstall the jaw.
5. Install the flat washer and the nut, and tighten the nut until it is snug enough to allow the jaw to slide when the jack screw is adjusted.
6. Repeat steps 1-5 for the remaining jaws.

To remove the chuck from the lathe, do these steps:

1. To remove the chuck, slightly open the jaws and insert a pry bar or large spanner wrench between two of the jaws across the face of the chuck.
2. With the spindle held firmly in place, use the pry bar or spanner wrench to unscrew the chuck from the spindle. DO NOT insert the chuck key in a socket and strike with a hammer. Socket fracture may result.

To maintain chuck operation and prevent rust, do these steps:

1. Spray a lightweight lubricant on the outside of the chuck periodically.
2. Occasionally, remove the four jaws, disassemble the jack screw assemblies, and clean and lightly oil the assemblies and threads.
3. Use a clean rag to remove any excess lubricant.

IF YOU NEED ASSISTANCE

Should you have any question about this product or its use, please contact the dealer where you purchased it, or you can contact Woodstock International Technical Support at 360-734-3482 between the hours of 7:00 am to 5:00 pm PST, or send e-mail to: tech-support@shopfox.biz.

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