



OPERATION AND MAINTENANCE MODEL D1090 THREE 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 D1090 Three Jaw Chuck is self-centering type, and 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 D1090 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 D1090 Three Jaw Chuck is now ready for use. Insert the chuck key into one of the adjusting sockets, and turn counterclockwise to open the jaws. Insert the workpiece fully into the chuck and tighten the jaws by turning the chuck key clockwise until the stock is held firmly in the chuck. There is no need to tighten more than one adjuster as the chuck will center round workpieces automatically. **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 3½" in diameter, reverse the jaws. Maximum capacity of the chuck, with the jaws reversed, is 6".

Reversing the Jaws

Observe the numbers stamped on both sides of each of the jaws, and numbers stamped in the face of the chuck next to each chuck slot. On each jaw, one side will have a single number: 1, 2 or 3. The other side will have a single digit number with a hyphen and four other numbers (i.e. 1-1444). In the normal jaw position, the numbers containing the hyphen will be next to the corresponding numbers on the chuck. In the reverse stepped-jaw position, the single numbers on the jaw will be next to the corresponding numbers on the chuck.

To reverse the jaws, do these steps:

1. Remove all three jaws from the chuck body and position the scroll lead to the right of slot one. (The lead is the outer lip of the part that turns, when turning the adjusting socket on the face of the chuck body. Also known as the scroll).
2. Insert the jaws in the slots with the corresponding numbers starting with slot #1.
3. Turn the chuck key to advance the scroll $\frac{1}{3}$ of a revolution while maintaining inward pressure on the jaw to ensure that it engages with the scroll.
4. Position the lead of the scroll so it is just to the right of the #2 slot and insert the #2 jaw. Turn the chuck key to advance the scroll $\frac{1}{3}$ of a revolution while maintaining inward pressure on the jaw to ensure that it engages with the scroll.
5. Position the lead of the scroll so it is just to the right of the #3 slot and insert the #3 jaw. Turn the chuck key to advance the scroll $\frac{1}{3}$ of a revolution while maintaining inward pressure on the jaw to ensure that it engages with the scroll.
6. Now test to see that each jaw is properly engaged with the scroll. Tug each jaw; if you can pull the jaw out in this way, repeat steps 1-5. If the jaws do not move, check the jaws to make sure they all fit into the chuck body evenly. Close the jaws together by rotating the adjusting socket with the chuck key in a clockwise fashion. The jaws should come together, evenly, near the center. If they DO NOT, repeat steps 1-5. If the jaws are evenly centered, the chuck is ready for use.

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

1. 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 three jaws, and blow the wood chips out of the threads of the scroll.
3. Remove the back cover of the chuck and the three locking screws.
4. Remove the sockets (pinion), the ring gear, and the scrolls.
5. Clean and grease the ring and pinion gears, and all internal parts. Reassemble the chuck.

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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