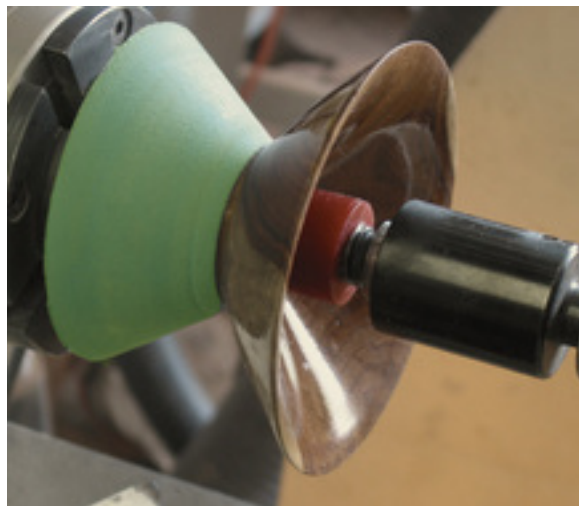
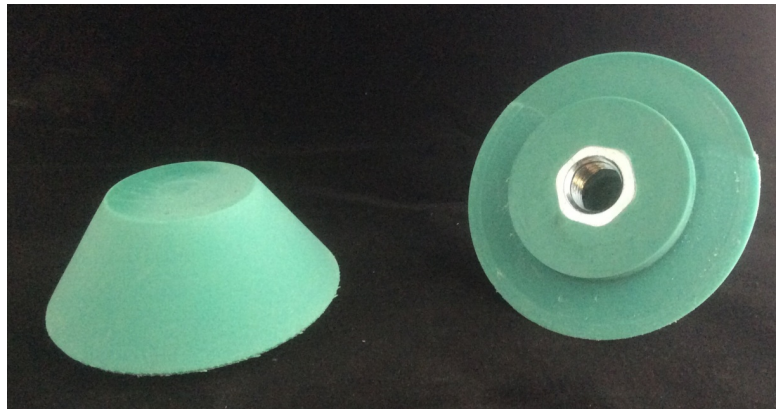
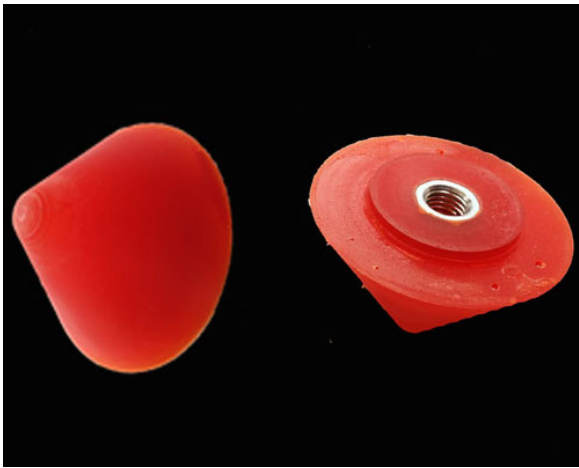


Rubber Chucky Info & Guide

Original 4" & No Nose Chucky:

The Original Chucky was designed to be used in a chuck for hollow forms, but may also be used with the 3" arbor in the headstock. May also be mounted on a Live Center with a removable cone.

The No Nose Chucky allows you to mount an item with a flat surface from the inside or from the tenon side of the work-piece by using a chuck or the 3" arbor. May also be mounted on a Live Center with a removable cone.



Mini 3" & No Nose Chucky:

Same purpose & use as described for the Original 4" & No Nose Chucky above. May also be used simultaneously from headstock (chuck or arbor) & tailstock for use in final sanding and/or finishing.



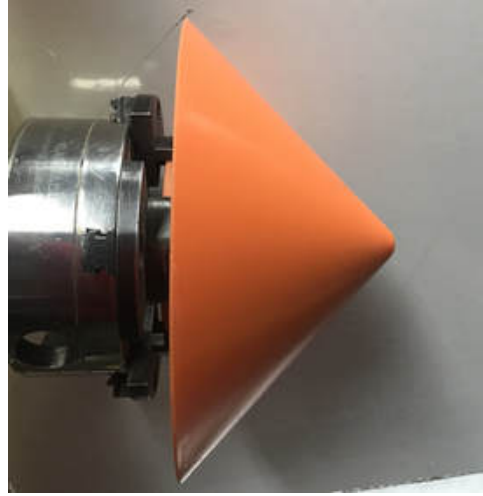
Micro 2-1/4" & No Nose Chucky:

Same purpose & use as described for the Mini 3" & No Nose Chucky above. May also be used simultaneously from headstock (arbor only as no tenon) & tailstock for use in final sanding and/or finishing.



Jumbo 7-3/4", No Nose & Convertible Chucky:

The Jumbo Chuckies are great for segmented glue-ups, bowls, platters or hollow forms with large openings. The Convertible Chucky provides the best of both worlds.



When using the Jumbo Convertible Chucky **WITH** the **Cone**, you **MUST** use the included Special Arbor/Extension. The Chucky has two nuts inserted in the main body & one nut (3/4-10 Jam Nut) inserted in the Cone. The Special Arbor/Extension comes with a stop nut on it. **DO NOT USE WITHOUT THIS NUT – it STOPS the Jumbo Chucky from threading too far onto the Arbor/Extension.**

After installing the Arbor/Extension into the headstock, be sure to check that the nut is on it correctly.

Jumbo 7-3/4", No Nose & Convertible Chucky (continued):

After the Arbor is properly installed in the spindle, thread the Chucky Body onto the Arbor and leave more than enough thread protruding beyond it to accommodate the Cone. Thread the cone onto the Arbor until it stops, and then thread the body toward the Cone until they meet.

To aid in threading the Base and Cone onto the Arbor, start threading first and then turn the lathe on to its lowest speed while firmly holding onto the Chucky. A little WD-40 on the Arbor may make this process easier.

THIS STEP IS IMPORTANT SO PLEASE PAY ATTENTION OR YOU MAY RUIN YOUR CHUCKY!!

Thread the JAM NUT forward until it meets the base of the Chucky Body. This holds the whole set-up in place, prevents frustration & hard work if you thread the Chucky too far on the Special Arbor/Extension.

If you wish to remove the whole Chucky or just the Cone from the Special Arbor/Extension unscrew the Cone FIRST – then unscrew the body. You can use the threading process outlined above only run the lathe in reverse.

If only using the base of the Jumbo Convertible Chucky you can remove it from the Special Arbor/Extension & mount it in a Scroll Chuck (or on the Live Center). If using only the base with the Special Arbor/Extension be sure the tip of the end of the Extension does NOT protrude beyond the Chucky. Then be sure to run the Jam Nut up to the base of the Chucky so that it locks it in place.

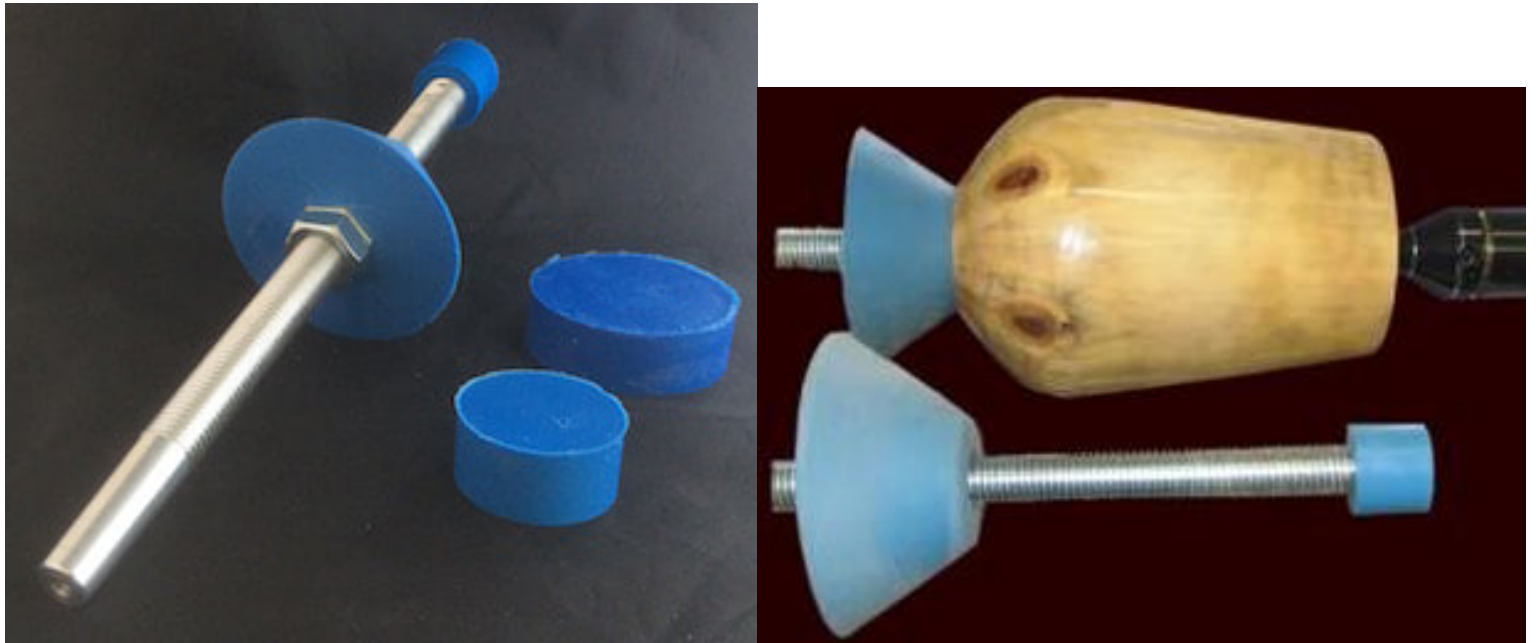
The Extension is matched to the arbor by having a flat on the shank that ensures proper alignment of the threads between the Arbor & the Extension, and permanently secured with Locktite. **Do Not try to remove the Extension from the Arbor as the threads are aligned to allow the Jam Nut to move along the threads.**

WE STRONGLY recommend using a Drawbar with any Jumbo Chucky.

Reverse 4" Chucky & Drives:

The Reverse Chucky was designed to stabilize the work-piece when removing the tenon or finishing thin wall hollow vessels by using the included 12" long aircraft aluminum arbor. The Drive Chuckies are different from other Drive Chuckies as they do not have a recess in the threaded area & may not fit properly on a Live Center.

ALWAYS USE THE TAILSTOCK LIVE CENTER WHEN USING REVERSE CHUCKY

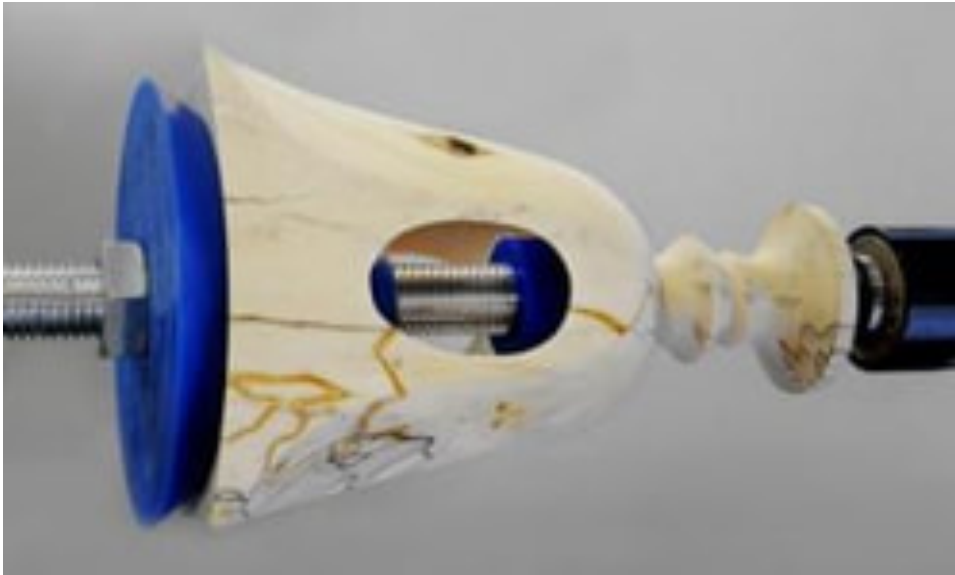


Insert the Morse Taper end of the Arbor into the Headstock Spindle. Thread the Jam Nut toward the headstock far enough to allow the cone to be installed now. Bring the Live Center up to the end of the Arbor, then bring the Jam Nut up flush to the Cone. Turn the lathe to a slow speed & if the Cone needs to be trued up do so at this time. Place the shank of a chisel on the surface while it is turning & if it bounces then it needs to be trued up. Use a very light shear cut & repeat process.

Once trued, remove the Live Center from the Arbor and thread the appropriate Drive Chucky on the end of the Arbor. You may take a light cut on the end of the Drive Chucky to ensure it is squared up. Simply mount it on the end of the Arbor to make the cut.

Reverse 4" Chucky & Drives (**continued**):

If using the "Chucklet" Drive provided with the Mini Reverse Chucky, make sure it is secured in the threaded end of the Arbor with the provided set screw. Install your vessel by bringing the Cone & Live Center up to the vessel as shown below. Make sure when the Cone is properly set and the Drive Chucky is touching the bottom of the vessel that you bring the Jam Nut up to the Cone & tighten it to the Cone to ensure the Cone doesn't move toward the headstock. Failure to use the Jam Nut may cause the Cone to move & damage your work-piece.



There is a 1/4" hole and set screw in the threaded end of the shaft that enables you to add a sanding disk, buffing pad, etc. for other operator desired applications. Be sure to secure the accessory with the provided set-screw. If exercising this option you should install a Drawbar to the taper end of the Arbor. A 1/4-20 threaded hole is provided for this option.

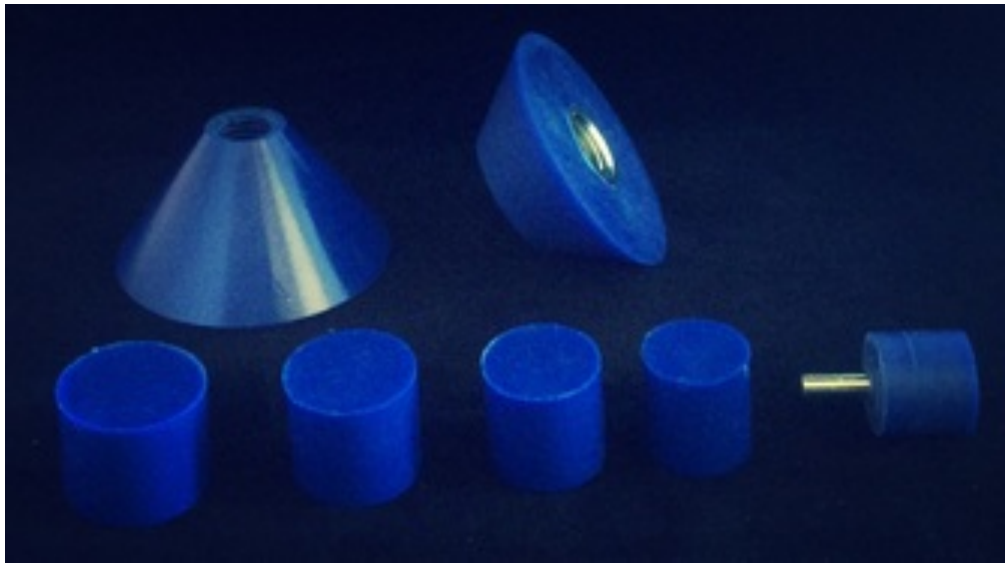
ALWAYS USE THE TAILSTOCK LIVE CENTER WHEN USING REVERSE CHUCKY

Mini Reverse 2-3/4" Chucky & Drives:

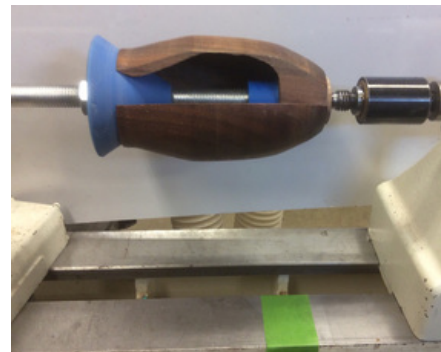
See the instructions included with the Reverse 4" Chucky for guidance is set-up and utilization of the Mini Reverse Chucky.

The Mini Reverse Chucky is for hollow forms with small openings and may use the same interchangeable arbor as the Reverse Chucky. There is a 1/4" hole and set screw in the end of the shaft that make use of the Reverse & Mini Reverse Chuckies a potential for finish sanding, buffing, etc. Simply insert a sanding disc or buff on a 1/4" diameter shank into the hole in the end of the arbor and secure with the provided set-screw. Optional attachments are not included in the set.

ALWAYS USE THE TAILSTOCK LIVE CENTER WHEN USING MINI REVERSE CHUCKY



Photos below show how to locate the vessel bottom to assist in material removal.

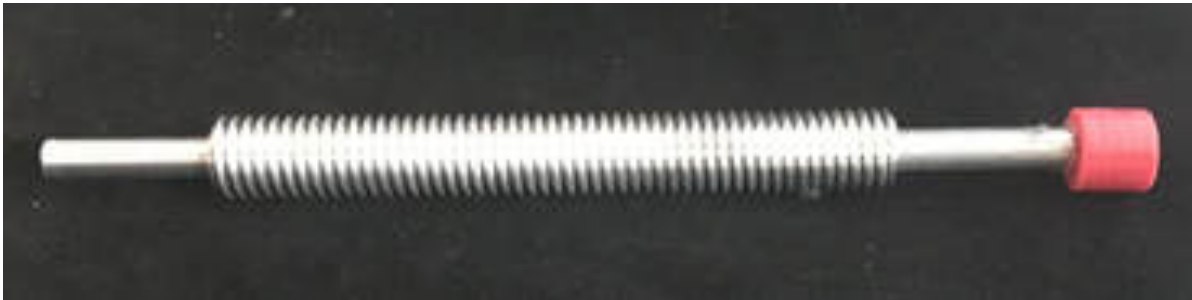


Micro Reverse Chucky:

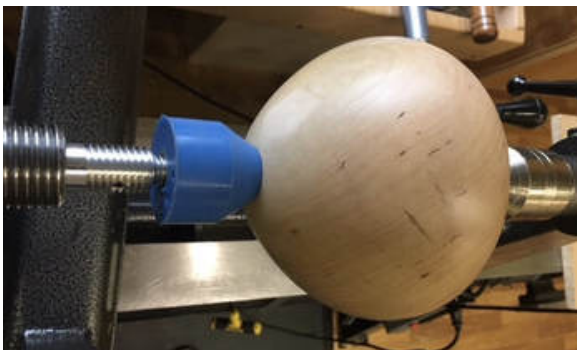
The Micro Reverse Chucky is designed for ANY item that has an access hole too small for the Reverse & Mini Reverse Chuckies $\frac{3}{4}$ " diameter Arbor. It stabilizes the work-piece while reverse chucking. The Micro Reverse Chucky consists of a MT2 Chucky Arbor, the Micro Reverse Chucky Cone, two 4" x $\frac{1}{2}$ " -13 Arbors & hardware (which consists of two Drives, the Stop Nut, an Allen Wrench & extra Set Screws).



Retracted



Extended



Drive Chuckies (8):

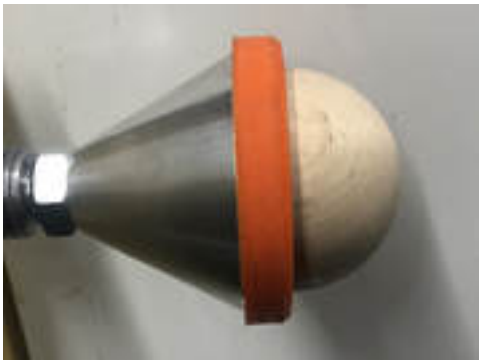
A series of 8 Drive Chuckies that are threaded to mount onto a $\frac{3}{4}$ " x 10 threaded Live Center or any MT2 Chucky Arbor. Drive Chuckies are great when needing to improvise to hold a work-piece for turning or finishing.

The set consists of 8 sizes from 1" thru 1-7/8" diameter in 1/8" increments. All Drive Chuckies are approximately 1-1/8" long.



Chucky Bull Nose Cone Vacuum:

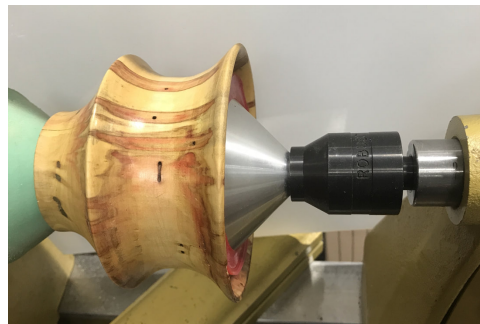
Convert the Live Center Bull Nose cone into a Vacuum Cone or a Jam Chuck.



Used as a vacuum.



Used as a Jam chuck w/Taper Arbor.



Used w/appropriate chucky based on item.

Chucky Vacuum Cone Set:

The set include 1 Chucky Vacuum Cone, 1 large Chucky Vacuum Cone and 1 set of Micro Vacuum Chuckies along with MT2 Arbor.

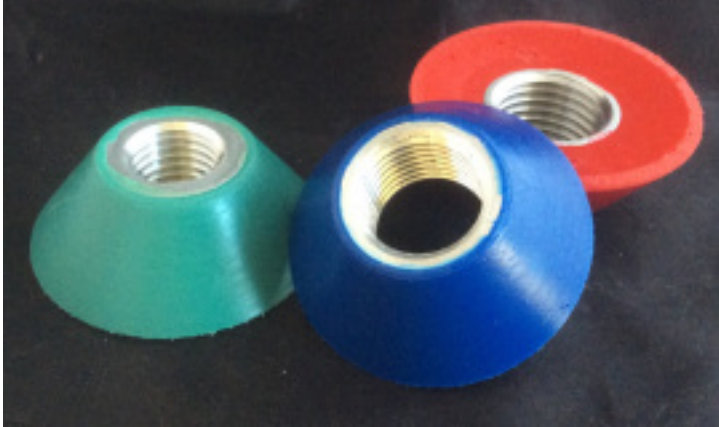


There are adapters on the market available from other suppliers that are fine products & plug into the wheel side of the headstock that will work with this product.



Chucky Vacuum Cone:

The cone threads directly onto the spindle for use with smaller items – must have your own vacuum system. Each color is a different size so only need the one that will fit your spindle (red).



It is recommended that you use the live center whenever possible.

Chucky Vacuum Kit:

Kit includes base with appropriate spindle size insert, 3" Schedule 40 Coupling, a spacer and seal. Color of the base & seal will vary according to spindle size.

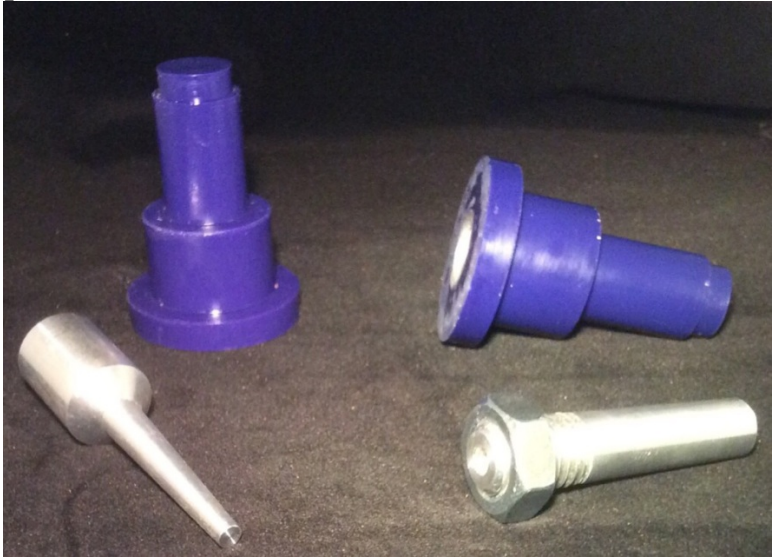


On OneWay lathe make sure to install the spacer so it aligns with the recess in the OneWay spindle.

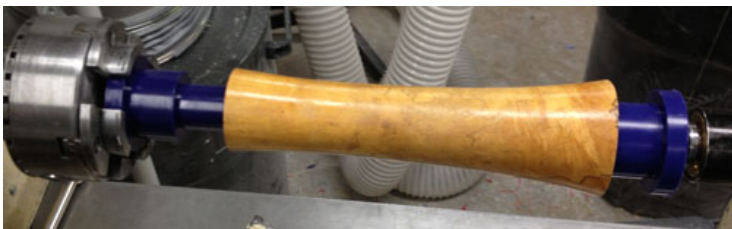
Pepper/Salt Mill Chucky:

The Pepper/Salt Mill Chucky can be used to make both pepper & salt mills. It consists of a $\frac{3}{4}$ "-10 threaded Taper Arbor and two (2) Reducing Diameter Chuckies.

The Reducing Diameter Chucky is 2" at the base which allows for mounting in a scroll chuck. It reduces to 1-5/8" for the bottom hole of the Mill & further reduces to 1-1/16" for the hole in the inside of the mill base. The end of the Reducing Chucky is reduced to approximately 7/8" to accommodate the inside of the tenon on the top portion of the Mill.



Taper & 1 Chucky for top of the Mill.



Scroll Chuck, 2 Chuckies w/bottom of Mill



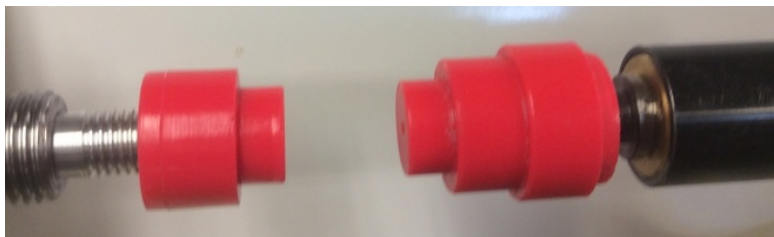
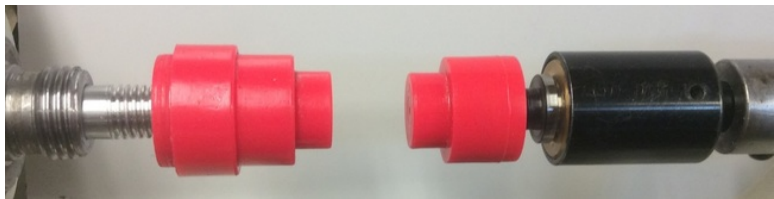
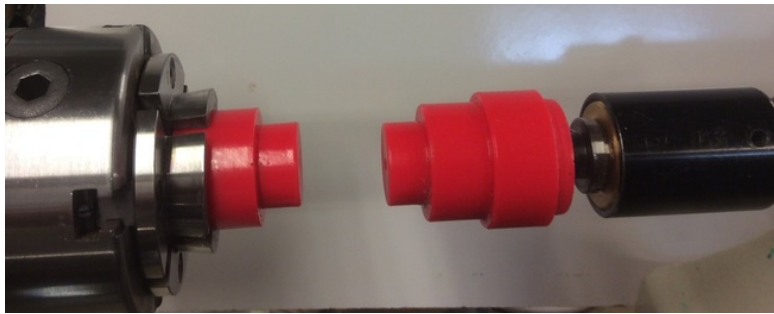
Taper Arbor, one Chucky w/bottom of Mill.

Crush Grind Chucky - Shaft-less Version:

This Crush Grind Chucky is for use with the Crush Grind mechanism without the shaft.



Pictures of how the Crush Grind Chucky Shaft-less Version is held



Crush Grind Chucky - Shaft Version:

This Crush Grind Chucky is for use with the Crush Grind mechanism WITH the shaft.



The combinations of holding the Crush Grind Peppermill are numerous with the Crush Grind Chucky.

Held w/Scroll Chuck & Live Center



Held w/Arbor in headstock & Live Center



Crush Grind Chucky - Shaft Version (**continued**):

The combinations of holding the Crush Grind Peppermill are numerous with the Crush Grind Chucky.

Top held w/Arbor in headstock



Bottom held in Scroll Chuck



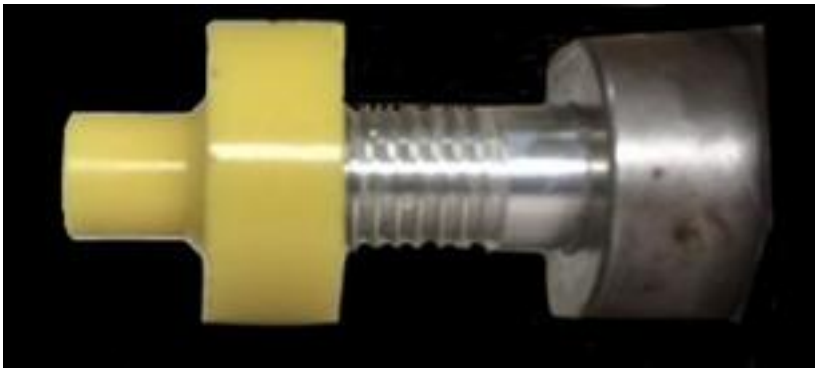
Top & bottom being held between centers



Finial Chuckies - 1/8" & 1/4":

Stabilizes the finial for turning & finishing for bearing sizes of 1/8" and 1/4".

PICTURES OF THE ORIGINAL FINIAL CHUCKIES



Mounted in Chucky Arbor in Tailstock

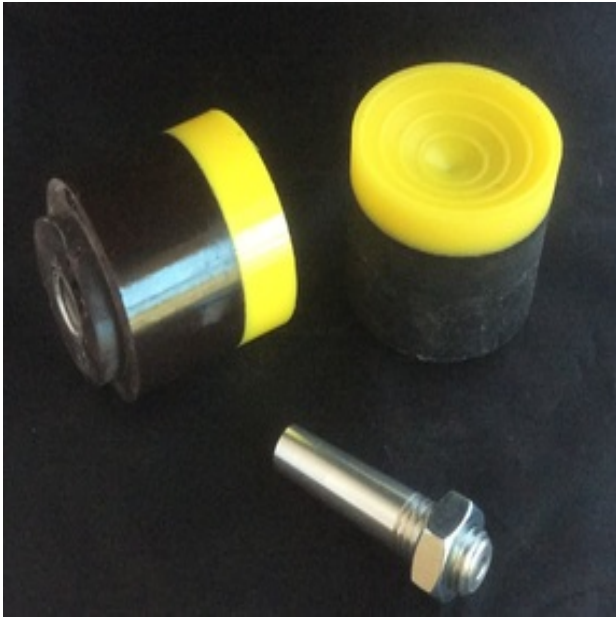
PICTURES OF THE REDESIGNED FINIAL CHUCKIES AVAILABLE AFTER 8/1/19



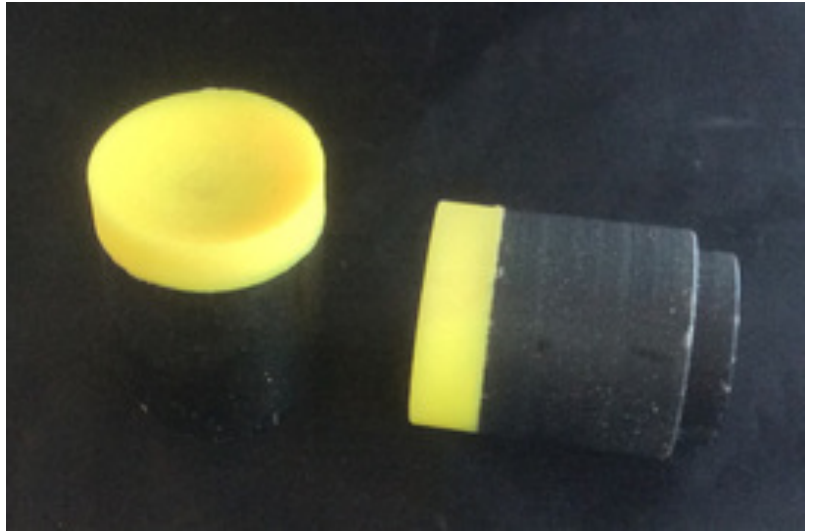
Large 2-7/8" & Small 2" Sphere Chuckies:

The Sphere Chuckies are an aid in removing the tenons from turned spheres

2.75" diameter by 3" long



2" diameter by 2" long



Mounted between 2 Sphere Chuckies with Chucky Arbor & Live Center



Large 2-7/8" & Small 2" Sphere Chuckies (continued):

The Sphere Chuckies are unique in that they have a soft end and a hard body. It is designed so that the soft end gets squashed down to conform to the shape of the work-piece. It may appear that it is more out of round that it is because of this soft end. Centering of the work-piece to the chucky may be necessary.

If the Sphere Chuckies need truing slow the lathe speed down & place the shank of a chisel on the surface while it is turning - if it bounces then it needs to be trued up. Use a very light shear cut & repeat process.

We suggest that after any needed final truing on an arbor that you bring the Jam Nut (supplied with the Arbor) up to the Sphere Chucky & use Loctite to secure the nut on the arbor. This will ensure that it returns to the same thread if removed from the Arbor & remains trued.

If using the Sphere Chucky with a scroll chuck make sure the jaws of the chuck are tightly secured to the chuck.

When mounting the Sphere Chucky to the Live Center be sure it is screwed as far onto the live center as it can go. If it does not screw all the way on you may add a 3/4-10 jam nut to the threads of the live center.

Anything Chucky Set 2" x 1-1/2":

The Anything Chucky can be used for just about any work holding solution – spheres, bowls and vessels.



When mounting the Anything Chucky Set to the Live Center be sure it is screwed as far onto the live center as it can go. If it does not screw all the way on you may add a 3/4-10 jam nut to the threads of the live center.

Spatula Chucky:

Designed by Michael Hosaluk the Spatula Chucky is designed to hold the flat end of a spatula blank. Requires a live center w/removable cone & $\frac{3}{4}$ "-10 thread.



Bullet Chuckies (2) 3-1/2' x 2" x 7/8" & 3-1/2" x 1-1/2" x 1/2":

The Bullet Chuckies can be used individually or in conjunction with any other Rubber Chucky. The taper allows it to adjust to odd and/or variable size holes as needed for individual work pieces.



The Bullet Chuckies can be reshaped to fit whatever size project needed, but be sure to take very light cuts with a chisel.

Mini Lathe Live Center Chuckies (4):

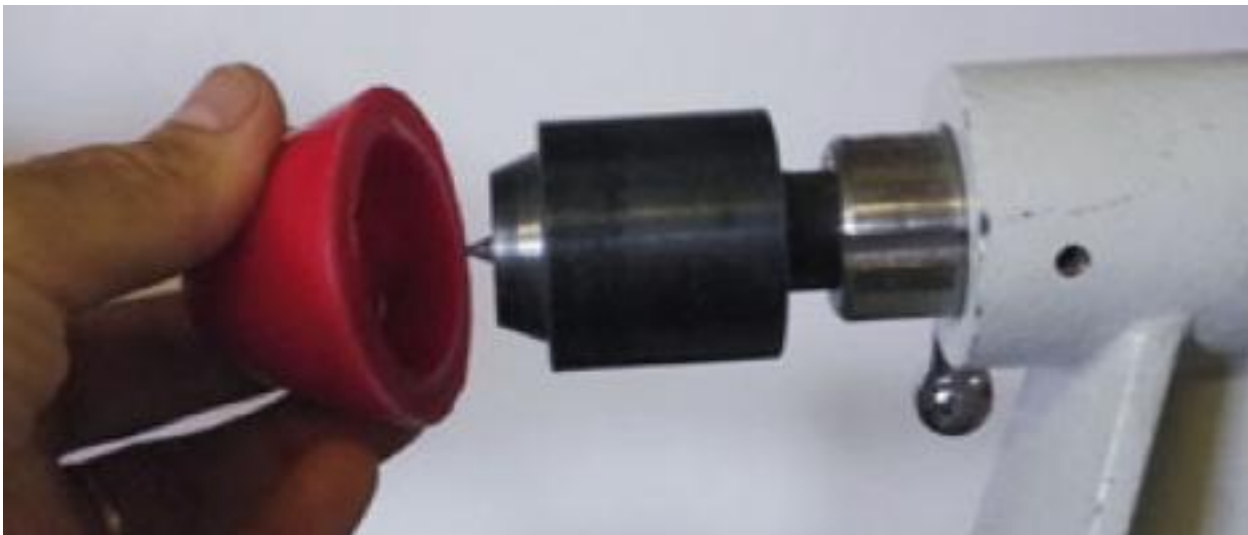
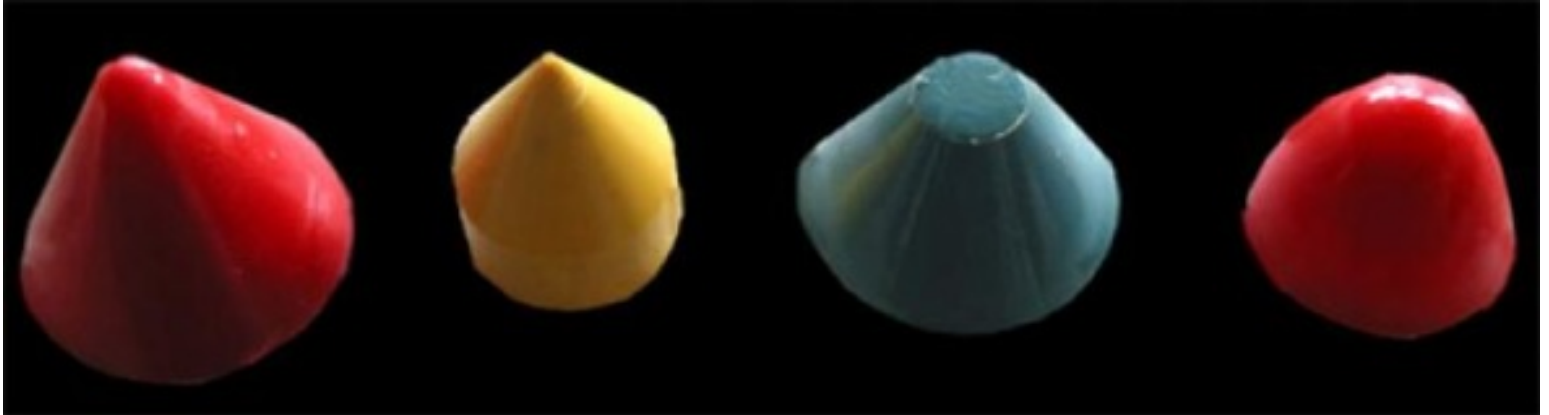
All of the Mini Lathe Live Centers simply slip over the a live center shown below.

Goblet Chucky

Hard 60 Cone

No-nose Cone

Rubber Chucky

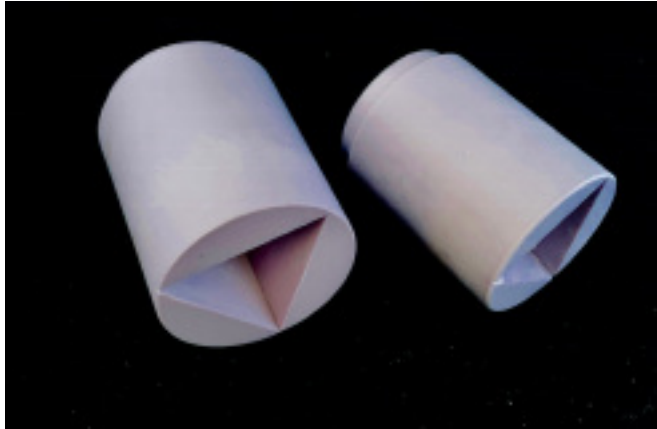


Mini Lathe Live Center Chuckies (4) (**continued**):



Three Point Chucky Set:

The Three Point Chucky Set is for turning Three Point Bowls and Boxes or any cube of choice.



Chucky Taper Arbors:

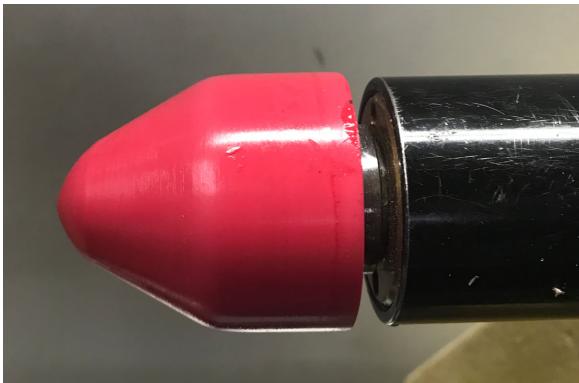
The Taper Arbor is ideal for removing tenons, gaining access to small areas with tools and refinishing work pieces or work-holding situations.



Chucky Live Center Cone Alternative:

You can't easily, nor would you want to reshape the Aluminum Live Center Cone, or you wouldn't use it on a finished piece as the point could damage the work-piece. The Chucky Live Center Cone Alternative solves both problems.

The Chucky Live Center Cone is NOT meant for taking cuts – it is only meant for refinishing the work-piece.



Chucky Extensions:

Chucky Extensions are available in 2", 3" & 6" versions. Each has a $\frac{1}{4}$ " x 1" hole in the threaded end to accommodate accessories such as buffers or sanding discs.



Chucky Drawbar Kit:

The Drawbar Chucky consists of a MT2 Buffing Arbor that has a hole in the front end to accommodate buffing sanding pads, etc. It also has a $\frac{1}{4}$ "-20 threaded hole in the taper end to accommodate a $\frac{1}{4}$ "-20 all thread rod (not included).

Put the rod through the headstock & cut the rod to length, Then screw the cut all thread into the arbor & install it in the headstock. Next install the molded wing nut onto the thread & tighten it up to the spindle to ensure the arbor is held in the spindle.



Winged Nut



Assembled Drawbar

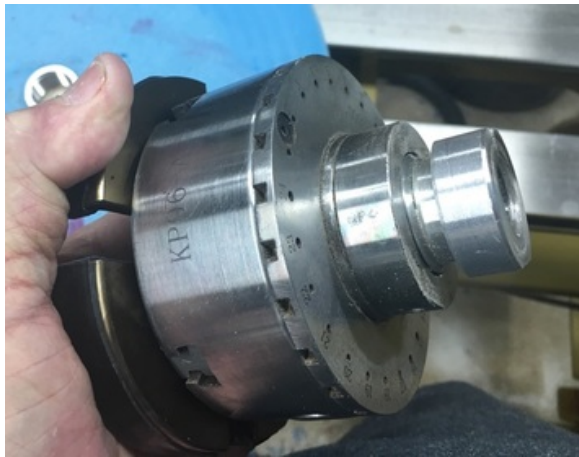


Installed Drawbar

Chucky Alignment Adapter:



The adapter has many uses as shown below:



Expansion Chuckies - 2" & 1" (7 rings w/each):

Both versions include seven rings in 1/8" diameter increments.

Each unit is adjustable by turning the Hex Bolt from the front with a 7/32" Allen wrench or rear of the Expansion Chucky with a 5/16" wrench or socket. May used to turn a bracelet, napkin ring or similar item.

Each ring only expands approximately .020 so it is important to plan the hole size to fit the expansion ring you are going to use.



Tool Rest Adjuster:



1. Place the Stop Collar on the tool rest post – do not tighten the set screw.
2. Insert the tool rest post into the banjo & raise the tool rest to parallel with the center point on the live center.
3. Place the Tool Rest Adjuster under the Stop Collar on the tool rest post & set it at the 1" height of the Step Chucky mark.
4. Tighten the set screw of the Stop Collar. This has to be done for each different tool used.