

## Reverse and Mini Reverse Chucky Instructions

Insert the Morse Taper end of the Arbor into your Headstock Spindle.

Gently tap the end of the arbor with a wood or rubber mallet – this “seats” the Morse Taper. **DO NOT use any metal object for this operation as it could cause damage to the arbor or your lathe.**

Thread the Jam Nut toward the headstocks far enough to allow the cone to be installed.

Install the cone.

Bring the Live Center up to the end of the arbor. Next bring the Jam Nut up flush to the Cone. Turn on your lathe to a **slow speed**. If the cone needs to be trued up, do so at this time.

“Truing it up” ensures that it runs true and also slightly roughens the surface; allowing for better gripping of the workpiece. This enables you to put less pressure on your workpiece, eliminating the burning of or possible breakage of the workpiece.

To true up your product, we suggest to gently place the shank of a chisel on the surface of the applicable Rubber Chucky while it is turning - if it bounces then it needs to be trued up.

If this is the case; we suggest making a **very light** shear cut to the surface. We use a gouge but feel free to use the tool of your choice. Then repeat the aforementioned process of placing the chisel shank on the surface - if it doesn't bounce then it is trued up. Repeat the above process as necessary. Be careful with this procedure; if you don't understand it please contact us for further instructions before proceeding.

Once trued, remove the Live Center from the arbor and thread the appropriate size Drive Chucky on the end of the arbor. You may also 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 and make the cut.

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 and 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 and 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 and damage your workpiece.



This is a Hollow Form in process by Rudy Lopez.  
Check out his work at [www.rudolphlopez.com](http://www.rudolphlopez.com)

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 draw bar to the taper end of the arbor. A 1/4-20 threaded hole is provided for this option. See our website in the Buffing/Sanding Products section for information on a draw bar.

**Tip:** If necessary spray the arbor with WD-40 to aid in moving the cone. The cone can be moved forward or backward on your lathe at a **SLOW** speed by holding and pushing the cone toward the headstock, but make sure the tailstock is brought up in place without the Drive Chucky mounted.

Need a longer arbor?

We offer 2", 3" and 6" Extensions (shown on our website – see Extensions and Arbors) that insert into the threaded end of the arbor and held with the set-screw.

**ALWAYS USE YOUR LIVE CENTER WHEN USING A REVERSE OR MINI REVERSE CHUCKY.**

The safe use of this product is entirely the responsibility of the purchaser. If you do not agree with this, please return the Rubber Chucky product immediately for a full refund. Your use of this product will constitute your agreement to your responsibility.

