

Sphere Chucky Instructions

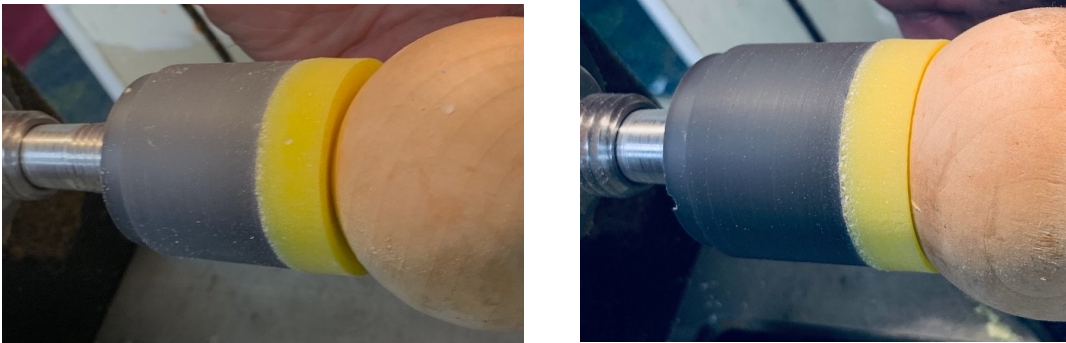
Sphere Chuckies are pre-trued but they may need to be **“trued up”** again for various reasons.

We “pre-true” the Sphere Chuckies when they are mounted on our optional MT2 Arbor.

Please Note:

The soft (yellow) end of the Sphere Chucky can be re-shaped. This is often done to better fit your particular Sphere. We have found that the easiest is to use a round Carbide cutter but you can use any tool of choice. We have even used 80 Grit sand paper – and smoother grits if necessary.

Take small cuts!!!



Shown below is a before and after fit of a Sphere to the Chucky.

The Sphere Chuckies are unique because they have a soft end and a hard body. It is designed so that soft end gets squashed down to conform to the shape of the workpiece. It may appear that it is more out of round than it really is because of the soft end.

Some centering of the workpiece to the Chucky may be necessary.

We prefer to use the arbor when mounting the Chucky to the headstock.

Additional truing may or may not be required.

If using the arbor be sure to gently tap it into the spindle with a wood mallet to “seat” the arbor.

Never use a metal object to do this as it could harm the arbor or spindle of your lathe.

Whenever an item is located on a thread many variables can occur.

Most commonly stopping on a half thread.

Sometimes backing it off or tightening it a thread will allow it to run truer.

Once trued, bring the jam nut up to the Sphere Chucky to secure it.

Also, when using the arbor; threading the Chucky onto the threads by hand for a couple threads and holding it with a slight upward pressure while the arbor turns at a very low speed; engages the threads in a more consistent manner.

If using your Sphere Chucky with a scroll chuck, make sure the jaws of your chuck are securely fastened to the chuck base and the Chucky. Loose jaws will cause additional run-out.

When mounting the Sphere Chucky to a Live Center be sure it is threaded onto the Live Center as far as it will go. If it does not thread all the way on, you can add a 3/4-10 jam nut to the threads of the live center. Occasionally, some live centers have slightly flatter threads which do not allow the Chucky to be completely threaded onto it. We found that adding the jam nut works well in this situation.

Please remember if you have any questions concerning the use of your Rubber Chucky product, please either email us at sales@rubberchucky.com or call us at 248.877.0828

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

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