

# Sphere Chucky Instructions

Although we “pre-true” the Sphere Chuckies, they may need to be “trued up” again depending upon various reasons.

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

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. However, if it is not returned to the same location, additional run-out can occur. We suggest after final truing on an arbor that you bring the jam nut up to the Sphere Chucky, and use Loctite to secure the nut on the arbor. This will ensure that it returns to the same thread if removed from the arbor and remains trued. A jam nut is included with the arbor.

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.**

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

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 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 screwed onto it. We found that adding the jam nut works well in this situation. Also when using the arbor; screwing 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.

By gently placing a chisel shank on the surface of the chucky you will be able to determine if the chucky needs truing. If they do, we suggest making a very slight shear cut to the surface of the chucky. We use a gouge but feel free to use the tool of your choice. Gently place the shank of tool on the chucky again to test its concentricity. If it bounces, repeat the aforementioned process. If it doesn't bounce then it is trued up. Be careful with this procedure; if you don't understand it please contact us for further instructions before proceeding.

Please remember that if you have any questions concerning the use of your Rubber Chucky product to please either email us [sales@rubberchucky.com](mailto: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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