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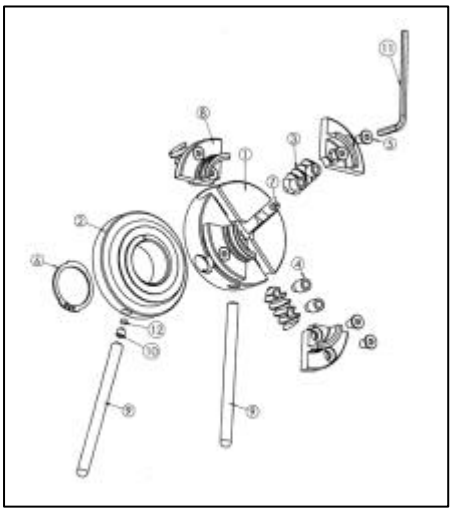
Frequently Asked Questions
Assembly & Disassembly of the Compac Chuck

Date Raised: 19.12.01 Date Amended:	Safe practises should always be employed to ensure the Health and Safety of yourself, employees and customers (if applicable) Refer to product manuals, exploded drawings and our website if further assistance is required, or contact us on service@teknatool.com



Item #	Qty	Part No	Description
1	1	48000	Chuck Body
2	1	48001	Scroll Ring
3	4	48002	Jaw Slides
4	8	48009	Guide Pin
5	8	48005	M6x1 Counter Sunk Screw
6	1	EC32	Circlip 32mm
7	1	LSM4N	4mm Lock Stop Screw
8	4	48004	45mm Jaws
9	2	79458391	Operating Bar
10	1	AK4	4mm Allen Key

When might disassembly & cleaning be required?
Over time wood dust and debris can build up inside the chuck mechanism. An indication of this may be that you find the chuck action becoming progressively tighter over time. Frequency of maintenance will depend on chuck use but on average a disassemble and clean should only be needed once every two years.

Tools required:
1. Bench Vice 3 1/2" (90mm) throat.
2. Buffer Material (such as clean soft cloth, rubber strips etc)
3. 1/8" Screw Driver
4. Soft Cloth
5. Lubricant such as CRC Silicon Spray.

To disassemble

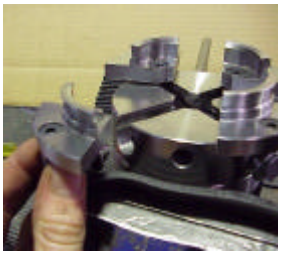
1 Holding the buffer material between the chuck and the vice, do up the vice finger tight. The vice should be gripping on the scroll ring ONLY. Make sure the scroll is positioned so the chuck is not clamping over the scroll lever holes.

Make sure the Vice grips the scroll ring of the chuck only.

2 Using the levers, wind the chuck in, so that the collets meet in the middle.

3 Remove the stop screw using the 1/8" blade screw driver.

4 Remove Jaw slides: Using a lever in the chuck body wind the jaw slides out (clockwise direction) as far as you can out until you feel the movement becomes tight. Find one jaw slide that is loose and pull it – you will feel it 'click' back off the scroll. Turn the chuck another ¼ turn – it will become tight again – find the next jaw that is loose and again pull it to 'click' back off the scroll. Repeat the process until all four jaw slides can be removed from chuck body.



Cleaning:

1 Clean out scroll ring and clean down jaws. If your workshop is equipped with one, it is best to use an air gun - BUT a soft clean cloth will also do.

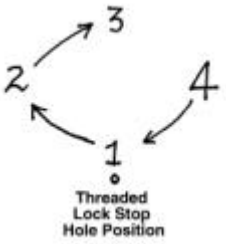
2 Give a light spray with a suitable lubricating spray, we use CRC silicon based spray.

Re-assembly:

1 Firstly, identify your jaw slides.
All four jaw slides can be uniquely identified:
#1 Jaw Slide: Notched out at the end for the stop screw.
#2 Jaw Slide: 2 rings cut into front taper.
#3 Jaw Slide: 3 rings cut into front taper.
#4 Jaw Slide: No rings cut into front taper and no notch in end of jaw slide.

Locate the number of rings on the jaw slide for #2&#3 jaw slides

2 Note that the way of assembling the Compac Chuck slides is different to what you may be used to with the Nova & SuperNova Chucks. You need to start with #4 jaw slide. You must locate #4 jaw slide in the body hole next back from the #1 position (#1 has the threaded lock screw hole).



3 Find the leading edge of the scroll then back it off by turning body clockwise.

4 Get the #4 Jaw Slide, and push it in until you feel it stop.

5 Then bring around the leading edge of the scroll to the #1 jaw position (only a ¼ turn) and as you turn, you need to keep pushing to hold the #4 Jaw Slide in place. Repeat process by backing off leading edge of scroll as for the #4 Jaw slide.

6 Then hold the #4&#1 Jaw Slides in position while moving the leading edge around to the #2 Jaw Slide position.

7 Repeat process for the final #3 jaw slide.

8 When all jaws have been engaged with the scroll wind them to centre to make sure they meet evenly – it will be obvious if one jaw or more has not engaged with the scroll properly. If the jaws do not meet evenly – remove them from chuck body again and repeat insertion process above. The usual reason for an out of position jaw is that the scroll has been moved a ½ turn or more before the next jaw is engaged (inserted). Remember to advance the scroll only ¼ turn at a time between each jaw insertion.