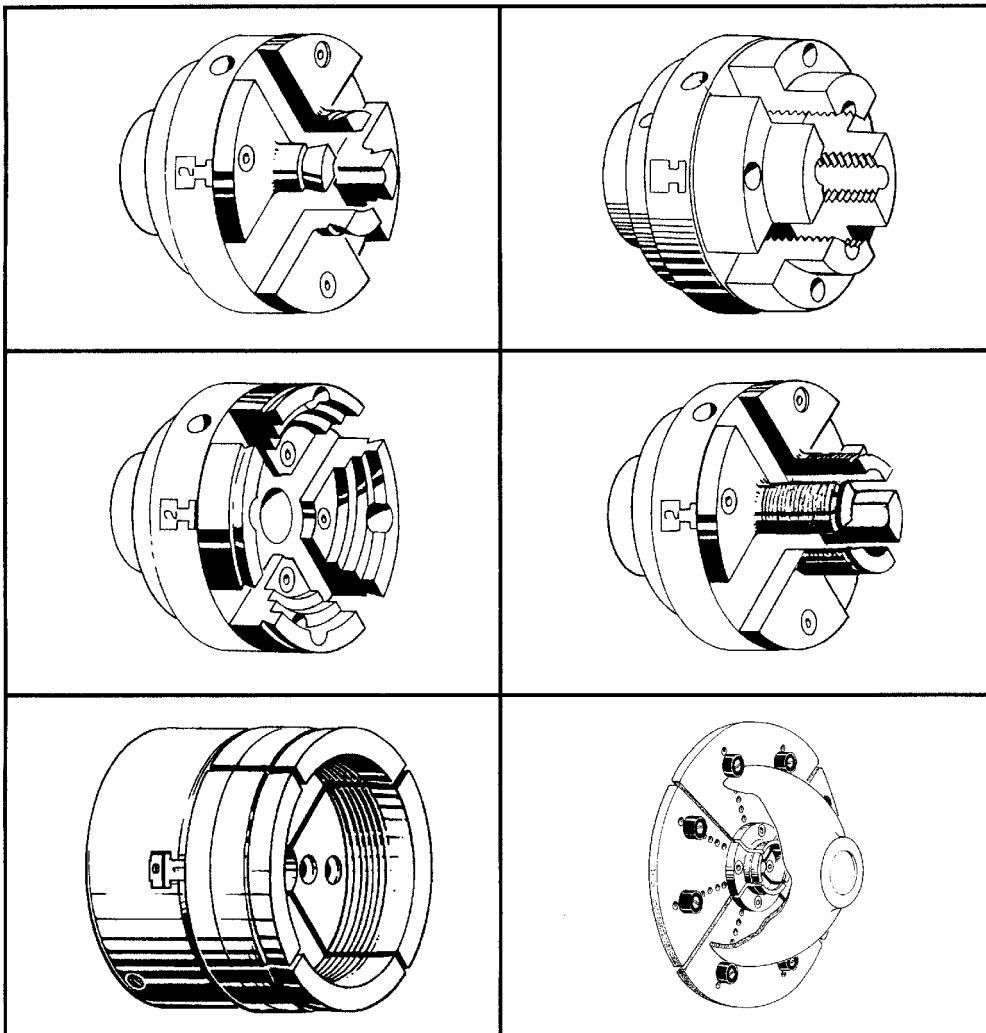




TEKNATOOL CHUCK ACCESSORY JAW MANUAL



Jaws specifications may vary from country to country

VISIT OUR WEBSITE: www.teknatool.com

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WARRANTY

DATE PURCHASED
(To be completed by Sales Outlet).

This Teknatool Product is backed by a warranty period of twenty four months from the date of purchase. Teknatool International hereby agrees to make repairs or replace components without the charge for any defects due to faulty material or workmanship, provided that –

1. The warranty period has not elapsed. Proof of purchase date (sales slip etc.) would need to be forwarded to Teknatool International.
2. If in our opinion the unit has not been altered repaired or modified in any way that would affect its operation; has not been subjected to misuse, negligence, accident or not used strictly in accordance with instructions.
3. Where necessary transportation is prepaid to Factory Service Centre, or other authorised Teknatool Service Centre.

Warranty does not cover any costs or damages arising directly or indirectly from the operation of this Teknatool Product. No other guarantee, written or verbal is authorised by Teknatool International hereby.

OVERSEAS CUSTOMERS: Our Teknatool agents will issue their own Warranty to cover this product. The terms may vary from those stated above - please check with your dealer.

Our policy is one of continuous improvement. We therefore reserve the right to change specification/design without notice.

You can register your warranty online!
Go to www.teknaool.com

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Thank you for purchasing this accessory jaw set for your Teknatool Chuck. You will find that the wide range of jaw sets will really enhance the versatility of your Chuck. The jaws all have complementary applications and provide the opportunity to extend your woodturning interests.

Teknatool International specialises in innovative woodturning equipment and in the back of this manual you can learn about some of the many products in the range. For more information enquire with your stockist or contact Teknatool directly. Alternatively visit our website - www.teknatool.com. A video featuring the accessory jaws and their applications is also available.

All sizes listed are in metric with the nearest approximate inch (") equivalent.

EXPLANATION OF DIFFERENT JAW SETS

25MM JAW SET - Code: JS25N

Designed for small bowl and small unsupported spigot turning work which is below the size that can be handled by the 50mm jaw set.

PIN JAW SET - Code: JSPIN

These special 25mm extended jaws are designed to act like a pin chuck – expanding into a pre-bored hole – a useful technique for free form edge bowls. The advantage of these jaws is that you don't have to bore an exact size as with other pin jaws. The longer jaws allow for a very powerful spigot grip for smaller work such as lace bobbins. There is also a small dovetail to mount small bowls. Twist drills also can be gripped to enable the chuck to be used as a drill chuck.

35MM BOWL JAWS - Code: 6019

The 35mm bowl jaws fit perfectly into the current jaw range, picking up a small gap left between the 25mm and the 50m. These jaws are perfect for small to medium sizes with maximum grip, provided by the dovetail.

50MM JAW SET - Code: JS50N

These jaws are standard with all Teknatool chuck standard versions. A versatile all round jaw that enables the turner to become fully competent with Teknatool chucks before moving on to more specialized jaws.

75MM BOWL JAWS - Code: 6014

The dovetail walls are three times the thickness of conventional jaw types. Screws go right through the wall section to add more securing force where its needed most. All this equals holding power for large bowls and also moderate hollow forms. The deep smooth walled dovetail (10mm external and 8mm internal) hold wood gently but very firmly.

75MM LONG NOSED JAWS - Code: 6012

A huge two inch rise above their mounting base means very long reach deep inside of bowls. Huge holding power externally and internally. Ideal for green wood turning. Internal features dovetail grip for holding footed bowls and other footed work pieces. Plus, an internal powergrip for holding spigoted work pieces.

STEP JAW SET - Code: JS75N

Designed primarily to grip the base (foot) of footed bowls in the contracting mode. The step sizes provide optimum gripping for three foot sizes with minimal crush damaged wood.

SPIGOT JAW 35MM/45MM JAW SET - Codes: JS-5P35/JS-SP45

Available in two different internal sizes, 35mm and 45mm. These jaws provide a strong grip to unsupported spigot turning applications, e.g vases, goblets. Designed to grip both in the contracting and in the expanding mode.

100MM JAW SET - Code: JS100N

Designed for expanded dovetail, reverse dovetail for gripping footed bowls, with limited spigot facility - not recommended for square spigot work. There is provision to mount false wooden jaws, so customised jaws can be made for special purposes.

130MM JUMBO JAW SET - Code: JS130N

Essentially the big brother to the 100mm jaw set. These are designed to handle large work up to 750mm in diameter. An ideal 'companion jaw' to both the Titan chuck and the Supernova 2 as the power of both these chucks matches the big capacity of these jaws. These jaws are also ideal for use with centre saving systems.

TITAN POWER GRIPS - Code: 13029

These jaws have tremendous holding power. Best used in conjunction with the Nova Titan 5inch, as the extra gripping power of the chuck enhances the PowerGrip's action. This jaw is included with the standard Nova Titan model. Able to hold large work up to 750mm (29") in diameter but has the added advantage over the 130mm jaws, of being able to hold long spigots up to 19" long. Also has a dovetail facility with up to 120mm (5") recess.

COLE JAW AND MINI COLE JAW SETS - Codes: JSCOLE & 6006

A versatile set designed primarily for the re-chucking of bowls to remove chuck marks or to re-shape the bottoms of bowls that have already been turned. Many other Nova jaw sets can be fitted to the Cole Jaws making a combination jaw facility – expanding dovetail facility for mounting bowls/platters and a reverse dovetail for mounting footed bowls/platters.

POWERGRIP JAW SET - Code: PJSN

A multi purpose jaw that should satisfy the needs of bowl turners and hollow form turners. The dovetail sizes fit neatly between the standard 50mm and the Jumbo 130mm jaw sets, while the spigot facility enables larger/longer hollow forms to be undertaken.

VACUUM FACEPLATE - Code: FPV

Designed for use with the 50mm jaw set. Provides a faceplate facility to enable you to vacuum chuck. The faceplate allows you the maximum freedom in designing any size or shape of carrier. MDF or wooden carriers made to suit your particular workpieces are screwed to the faceplate. The seal between the carrier and workpieces needs to be made of sheet closed cell foam (neoprene rubber).

FACEPLATE RINGS - Code: 6000, 6001 & 6002

Strong and fast mounting method for bowl blanks. A better alternative to the woodworm screw which is only suitable for smaller bowls. Offers the secure mounting of a faceplate with the quick convenience and power of a chuck. Strong mounting and method even with irregular sized wood and rough cut surfaces.



Note: Special Jaw Identification on Chuck!!!

The jaws may have either two types of identification

Type 1: The jaws are numbered 1-4

Type 2: The jaws are identified by the number of dots on the locating ring.

ACCESSORY JAWS

RANGE OF APPLICATIONS

This chart is designed to provide a guide to the range of use of the Teknatool Chuck Accessory Jaw Sets. The chart is a guide only. Allowance must be made for condition of wood and experience of turner.

EXPANDING ACTION (Internal Dovetail)			CONTRACTING ACTION (Spigot Mode)			
JAW SET	RECESS DIAMETERS	SIZE OF WORKPIECE	ROUND SPIGOT DIAMETER	SQUARE SPIGOT DIAMETER	SIZE OF WORKPIECE	
25mm JAW SET	23.5mm - 46mm (0.925" - 1.61")	Bowls up to 150mm dia x 50mm depth (6" x 2")	8.5mm - 25mm (0.33" - 1.25")	12mm - 32mm max. (0.5" - 1.00") (5" x 1")	Up to 125mm length x 25mm diameter	
PIN JAW	25mm - 49.5mm (1" - 2" approx)	Bowls up to 150mm x 50mm (6" x 2")	11mm - 25mm (0.43" - 1.3")	9mm - 32mm (0.35" - 1.02")	Up to 150mm length x 25mm diameter (6" x 1")	
50mm JAW (Included with Nova Precision Midi Chuck and Standard SuperNova2 version)	50mm - 75mm (2" - 3")	Bowls up to 310mm x 100mm (12" x 4")	45mm - 65mm (1.77" - 2.56")	40mm - 50mm (1.57" - 2.00")	150mm length x 100mm diameter (6" x 4")	
STEP JAW	76mm - 98mm (3" - 3.85")	Bowls up to 310mm x 100mm (12" - 4")	42mm - 61mm (1.65" - 2.4")	3 FOOT SIZES 50mm - 68mm (2" - 2.68")	64mm - 80mm (2.5" - 3.15")	
35mm SPIGOT JAW	Small Step: 53mm - 71mm (2.08" - 2.8") Large Step: 77mm - 97mm (3" - 3.8")	Hollowed Boxes, Vases 120mm dia x 150mm long (4.72" - 6")	30mm - 50mm (1.2" - 2")	30mm - 40mm (1.2" - 1.8")	150mm diameter x 260mm length (6" x 10")	
45mm SPIGOT JAW	Same as 35mm Spigot Jaw	Same as 35mm Spigot Jaw	38mm - 60mm (1.5" - 2.4")	30mm - 45mm (1.2" - 1.8")	Same as 35mm Spigot Jaw	
100mm JAW	97mm - 117mm (3.8" - 4.6")	Bowls up to Foot 360mm x 127mm (14" x 5")	Mounting of Bowls 84mm - 92mm (3.3"-3.6") Optimum foot size	Not recommended	Bowls up to dia 310mm x 100mm depth (12" x 4") Spigot Mounting 85mm (3.35") 150mm length x 127mm depth (6" x 5")	

130mm JAW	124mm - 149mm (4.88" - 5.86")	Platters up to 750mm x 75mm (29.5" x 3")	107mm x 130mm (4.2" x 5")	Not recommended (29.5" x 3")	Platters up to 760mm x 75mm
POWERGRIP JAW (included with SuperNova2 premier version)	96mm - 120mm (3.8" - 4.7")	Bowls up to 400mm x 150mm (16" x 6")	Contracting Dovetail for Bowls: 84mm - 92mm (3.1 - 4") Rounds: 30mm - 100mm (1.2" - 4")	60mm - 80mm (2.3" - 3.1")	200mm diameter x 310mm length (8" x 12")
75mm BOWL JAWS	82mm - 96mm (3.23" - 3.78")	Bowls up to 360mm x 127mm (14" x 5")	46.5mm - 60mm (1.83" - 2.36")	38.5mm - 45mm (1.516" - 1.77")	Bowls up to 310mm x 100mm (12" x 4")
LONG NOSE JAW	45mm x 66.5mm (1.77" - 2.62")	Bowls up to 200mm x 90mm (7.87" x 3.5")	11mm - 32.5mm (0.43" - 1.3")	9mm - 26mm (0.35" - 1.02")	Max depth 58mm (2.28")
NOVA TITAN POWERGRIP	128mm x 156mm (5" - 6.14")	Bowls up to 735mm x 150mm (29" x 6")	108mm - 136mm (4.25" - 5.35")	78mm - 108mm (3" - 4.25")	350mm diameter x 350mm in length (14" x 14") Crossgrain wood: 200mm diameter x 200mm length (8" x 8")
COLE JAW	Use in conjunction with other jaw sets. Re-chucking function. Max. 250mm (10") diameter bowl.				
MINI COLE JAW	Use in conjunction with other jaw sets or on its own. Re-chucking function. Max. 203mm (8") diameter bowl. Can be held.				
FACEPLATE RINGS 3 sizes 50mm (2"), used with 50mm Jaws 100mm (4") used with 100mm Jaws, Power Grip Jaws, 130mm (5") Use with 130mm Jaws.	Strong and fast mounting method for bowl blanks. A better alternative to the Woodworm screw which is only suitable for smaller bowls. Offer the secure mounting of a faceplate with the quick convenience and power of your Teknatool Chuck. Strong mounting and method even with irregular sized wood and rough cut surfaces. 2" 50mm Faceplate only suitable for use on Precision Midi.				
VACUUM FACEPLATE	This plate is used as a basis for vacuum holding system to re-chuck bowls. Can also be used as a faceplate.				

NOTE: Workpiece sizes and expansion and contraction sizes provided are when used with the SuperNova chuck, sizing may vary depending on the specific model of Teknatool Chucks used.

ACCESSORY JAWS TURNING SPEED GUIDE

The following guide sets out the recommended maximum speeds for each of the accessory jaws. Remember, excessive speed is a serious lathe hazard – give careful consideration to the speed you use:

1. The bigger the work diameter – the slower the speed used.
2. Out of balance/work being roughed out must always be turned at the slowest speed possible.
3. Speeds may differ from those in your lathe manual. If there is a difference, use the SLOWER of the two recommended speeds.

MAXIMUM RECOMMENDED SPEEDS

JAW TYPE	TURNING METHOD	
	EXPANDING	CONTRACTING
25mm Jaw Set	684 rpm	1440 rpm
Pin Jaw Set	684 rpm	1440 rpm
35mm Bowl Jaw Set	684 rpm	1440 rpm
50mm Jaw Set	684 rpm	1020 rpm
75mm Bowl Jaw Set	684 rpm	1020 rpm
75mm Long Nosed Jaw Set	400 rpm	400 rpm
Step Jaw Set	684 rpm	684 rpm
Spigot Jaw Set 35mm/45mm	684 rpm	684 rpm
100mm Jaw Set	684 rpm	684 rpm
130mm Jumbo Jaw Set	400 rpm	400 rpm
Mini Cole & Cole Jaw Set	600 rpm	600 rpm
Powergrip Jaw Set	684 rpm	684 rpm
Titan Powergrip Jaw Set	400 rpm	400 rpm
Vacuum Faceplate	684 rpm	N/A
50mm Faceplate Ring	684 rpm	1020 rpm
100mm Faceplate Ring	684 rpm	684 rpm
130mm Faceplate Ring	400 rpm	400 rpm

EXPLANATION OF TWO OF THE MORE COMMON CHUCKING TECHNIQUES USED IN THIS MANUAL

EXPANDING DOVETAIL OPERATION

Expansion of the jaws into a recess. This function is for bowl and platter turning where the projection (depth) of the wood blank is not too great. Specific sizes for each jaw type is stated in that area. Please refer to your Teknatool Chuck manual for information on how to form a recess.

When making a recess it is important to calculate the depth. The recess depth is an important consideration for maximising the holding power of the jaws, guidelines under each jaw should be followed closely. The depth of a recess can be varied according to the size and mass of the workpiece. Larger bowls and softer woods require a deeper recess. Smaller lids and thin platters generally require a shallower recess. Always use a recess depth in excess of what is required. IF THERE IS ANY DOUBT INCREASE RECESS DEPTH.

SPIGOT OPERATION

Contraction of the jaws around a wooden spigot for grip. Mainly used for box, goblet and vase turning, that is, endgrain items with a fair degree of overhang. Generally tailstock support is minimal or cannot be used because of the need to hollow out the inside. This method seems to be preferred by many bowl turners over the internal dovetail recess as the foot can later be re-shaped or removed, if desired, to make a smooth outside bottom of the bowl.

This situation is one of the most difficult to provide secure holding no matter what fixing method is used. **EXTREME CAUTION WITH THIS OPERATION MUST BE EXERCISED.** If used properly however, Teknatool Chucks provide a very secure grip in this mode.

Check for adequate contact and grip of all four jaws into the wood when using this operation. **MAKE SURE YOU HAVE AN ADEQUATE GRIP BEFORE OPERATION** by vigorously wrenching the work piece mounted in the chuck. If any loosening occurs **DO NOT PROCEED** with operation. Repeat tightening procedure and retest grip. Refer to your Teknatool chuck manual for information on forming a spigot.

FREE END TURNING

Turning where the work is not supported by the tailstock.

SAFETY RULES

PLEASE READ AND UNDERSTAND THESE SAFETY RULES BEFORE OPERATING ANY OF THE ACCESSORY JAWS.

WARNING – THE NOVA ACCESSORY JAWS ARE DESIGNED FOR USE ON TEKNATOOL CHUCKS ONLY. THEY ARE NOT DESIGNED TO FIT AND CANNOT BE USED WITH ANY OTHER CHUCK. TO DO SO COULD CAUSE A MALFUNCTION AND RISK OF SERIOUS INJURY. IF YOU ARE UNSURE OF THE USE OR APPLICATION OF ANY OF THESE ACCESSORY JAWS BEFORE USING CONTACT YOUR RESELLER OR TEKNATOOL DIRECTLY.

IMPORTANT – READ VERY CAREFULLY THE SAFETY SECTION IN THE TEKNATOOL CHUCK MANUAL BEFORE OPERATION AND FOLLOW CLOSELY THE SAFETY RULES OUTLINED IN THIS JAW MANUAL.

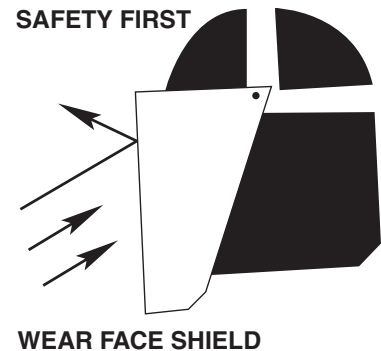
CONSULT RELEVANT OPERATIONAL SECTIONS OF THE TEKNATOOL CHUCK MANUAL BEFORE USING JAWS.

SOME SAFETY DIRECTIONS ARE PERTINENT ONLY TO A CERTAIN JAW SET. ANY ADDITIONAL SAFETY INFORMATION IS LOCATED IN THE TEXT OF THE RELEVANT ACCESSORY JAW IN THE PAGES FOLLOWING.

DANGER – THIS CHUCK IS CAPABLE OF CONTRIBUTING TO SERIOUS INJURY, AS WITH ANY OTHER POWER TOOL ACCESSORY, IF USED IMPROPERLY ON THE LATHE.

Before using the Teknatool Chuck and accessory jaws, read and understand the instruction manuals. Read and understand also the lathe manual. If you do not have a manual, contact the supplier of your lathe to obtain one before using the lathe and chuck.

User must be professionally trained to use this chuck and accessory jaws. Vocational school courses are recommended. As with any other chucking method, an extremely cautious and sensible approach is necessary. With the Teknatool chuck it is not possible to give exact directions as to the amount of tightening pressure required for work holding. Follow closely strict guidelines in this manual for different jaw types for wood blank diameters length, and turning speed.



ALWAYS WEAR EYE PROTECTION WHICH COMPLIES WITH CURRENT ANSI STANDARD Z87.1 (USA). WE STRONGLY RECOMMEND THAT A FULL FACE SHIELD IS USED AT ALL TIMES.

BEFORE USING THE TEKNATOOL CHUCK ACCESSORY JAWS BE SURE THAT –

- **WARNING!!! EXCESSIVE SPEED IS A SERIOUS LATHE HAZARD. ALWAYS TURN AT THE LOWEST SPEED POSSIBLE.**
Speed required will vary with wood blank size. The larger the blank the slower the speed. Consult your lathe manual. DO NOT ATTEMPT TO USE THE CHUCK UNLESS THE LATHE SPEEDS ARE KNOWN. YOU MUST STRICTLY FOLLOW THE MAXIMUM SPEED LIMITS SET OUT IN THE OPERATIONAL SECTIONS OF THIS MANUAL. DO NOT EXCEED THEM UNDER ANY CIRCUMSTANCES.
- EXAMINE WOOD CAREFULLY. ONLY MOUNT SOUND WOOD. If any cracks or weakness is found in the wood - DO NOT MOUNT IN CHUCK OR IN ACCESSORY JAWS. DO NOT MOUNT WOOD THAT IS LIKELY TO BREAK UP DURING TURNING (EG ROTTEN OR SPONGY WOOD). DO NOT USE POORLY LAMINATED WOOD.
- DO NOT EXCEED MAXIMUM GUIDELINES IN THIS MANUAL FOR WOOD BLANK DIAMETER/LENGTH FOR THE DIFFERENT MODES OF OPERATION AND JAW TYPES.
- DO NOT EXTEND JAW SLIDES BEYOND CHUCK BODY UNDER ANY CIRCUMSTANCES. ONLY OPERATE CHUCK WITH JAW SLIDE STOP SCREW IN PLACE. This prevents jaw slides from dislodging from chuck. NOTE: SuperNova2 Chuck has automatic internal stop.
- WARNING – MAKE SURE THAT IN EXPANSION MODE THAT THE AMOUNT OF TRAVEL REQUIRED IS LESS THAN THE LIMIT OF THE STOP SCREW, OR AUTOSTOP. DO NOT TRY TO FORCE CHUCK OPEN FURTHER.
- ALWAYS TEST WORKPIECE IS GRIPPED SECURELY IN THE JAWS. BEFORE OPERATION TEST BY WRENCHING WORKPIECE IN JAWS. IF ANY LOOSENING OCCURS, RE-EXAMINE HOLDING AREA FOR ADEQUATE GRIP (following mounting guidelines) AND ANY DAMAGE TO GRIPPING AREA.
- MAKE SURE WORKPIECE IS CLEAR OF OBSTRUCTION BY MANUALLY ROTATING WORKPIECE BEFORE SWITCHING POWER ON.

MOUNTING THE ACCESSORY JAWS

THE ACCESSORY JAWS NEED TO BE LOCATED AND SCREWED ON THE JAW SLIDES OF THE CHUCK.

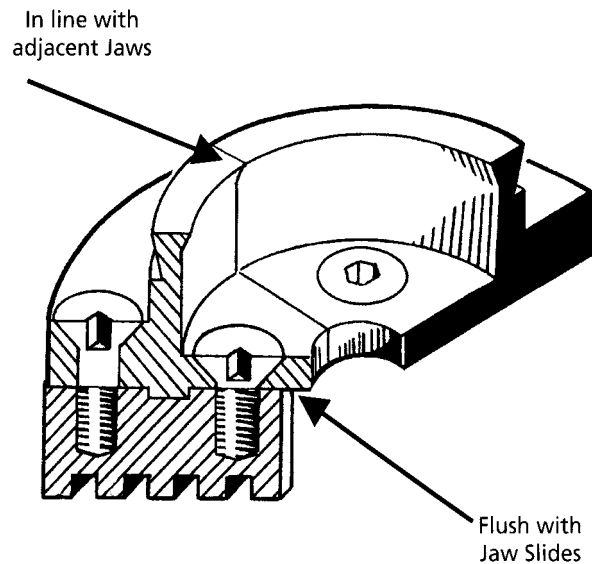
NOTE: THE MINI COLE/COLE JAWS AND VACUUM FACEPLATE HAVE SPECIAL MOUNTING INSTRUCTIONS. REFER TO SPECIFIC SECTIONS ON THESE JAWS IN THIS MANUAL.

IT IS IMPORTANT TO LOCATE JAWS PROPERLY INTO THE JAW SLIDES FOR THE CHUCK TO FUNCTION ACCURATELY.

Follow the method set out below

1. You will note that the back of the jaws have a stepped location ring. This location ring is designed to fit into the grooved section of the jaw slide for precision location. Ensure that the slide and collet back are clean and free from any burrs or damage that might affect location. Place the jaw segment over the hole positions on the jaw. Press the jaw segment firmly onto the jaw slide. For the first few times you may need to GENTLY tap the jaws into the locater slot with a block of wood.
2. You will notice that each jaw segment is numbered 1-4 on the bottom or top face. Jaws should be mounted clockwise in the same sequence. This ensures the jaws are re-assembled the same way they were cut during manufacture. This will ensure optimum accuracy.
3. The screw can now be screwed in, using the 4mm allen key provided in the chuck kit. Lightly grease or oil screws under heads before use to prevent screws locking onto jaw. Preferably use an anti-locking compound such as ROCOL J166 Anti-seize compound. Do all screws up finger tight and then loosen off one quarter of turn.

4. Wind the mounted jaws into the centre of the chuck until they all butt against the other. Now finally tighten screws, starting with the centre screws and then outside screws. Nip screw up firmly but do not OVERTIGHTEN.
5. Check there is no light between jaw slides and add on jaw segments or that one or more segments is not higher or lower than the others. If this is the case repeat the procedure above.



MAINTENANCE AND CARE OF YOUR JAWS

Always follow instructions on installation and use.

Use correct fixing screws and replace at regular intervals.

Use a small amount of grease under the head or a copper based antiseize product to aid removal of fixing screws.

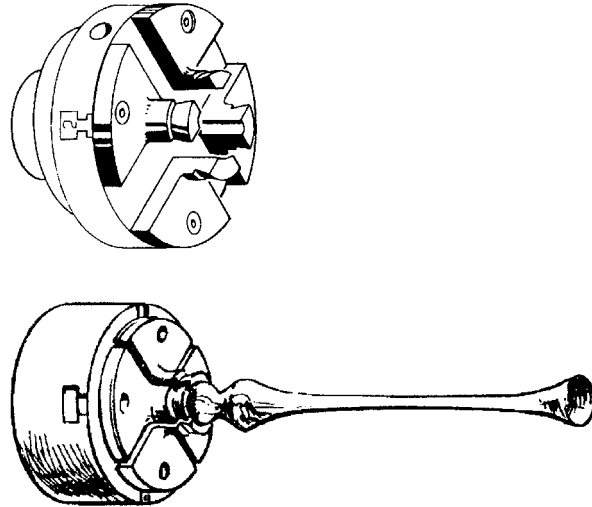
Clean jaws after use and spray with a protectant product like WD40. Additionally, for longer term storage, wrap in an oil soaked cloth.

25mm JAW SET

Code: JS25N

SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.



MOUNTING THE JAWS

See "Mounting the Accessory Jaws" on Page 12 & 13 of this manual.

PARTS PROVIDED – Four jaw segments NOTE: There is only one screw position for each of the 25mm jaw segments. Only one screw is necessary for secure fastening of jaw segments because the jaw is designed for small turning work.

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using the 25mm jaws, bowls up to 150mm (6") in diameter by 50mm (2") depth can be turned.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 50mm AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK.
DO NOT EXCEED 684 RPM IN THIS MODE. OUT OF BALANCE STOCK MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.

Recess: Maximum recess depth of 6.5mm can be used. Any recess diameter can be turned between 23.5mm (15/16") and 46mm (1 13/16"). The optimum recess diameter is 25mm (1"). At this diameter, full contact of jaws with recess is achieved. As the recess diameter is increased above 25mm, less jaw contact is made. This needs to be kept in mind when considering the recess depth and the size of the wood blank being mounted. Increase the recess depth to maximum if a recess diameter in excess of 25mm is used.

b. Square Blanks (Contracting Action)

These jaws can grip a square spigot between approximately 12mm (31/64") to a maximum of 25mm (1").

DO NOT EXCEED 1440 RPM IN THIS MODE

MAXIMUM LENGTH Wood blanks up to 125mm (5" length by 25mm (1").

c. Spigot Mounting (Contracting Action)

Use wood blank size up to 125mm (5") length by 25mm (1") diameter.

DO NOT EXCEED 1440 RPM FOR THIS OPERATION

Spigot Size: Minimum spigot size is 8.5mm (23/64") up to a maximum spigot size of 25mm (1"). Spigot Depth Always use the maximum spigot depth which is 19mm (3/4").

d. Special Function

For lathes with hollow spindles, Teknatool Chucks with the 25mm jaws mounted, could accept long lengths of round dowel below the 25mm size, which could be fed through the lathe spindle and through the chuck. This means that multiple turnings could be achieved by simply advancing the dowel through the centre of the chuck and securing with the jaws, turning, parting off, and then advancing the next piece through. Do not allow dowel to protrude past spindle on the outboard end.

OPTIONAL ACCESSORIES

Not applicable for this jaw set.

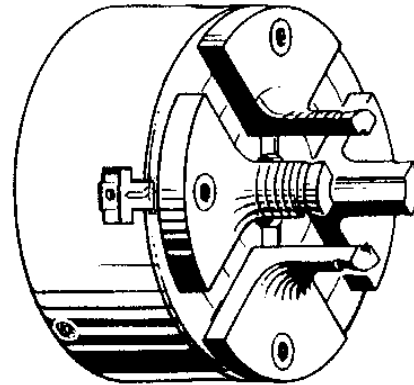
The 25mm jaw set is not designed for mounting to the Cole/Mini Cole Jaws Sets. DO NOT USE WITH COLE OR MINI COLE JAW SETS.

PIN JAW SET

Code: JSPIN

SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.



MOUNTING THE JAWS

See "Mounting Accessory Jaws" on page 12 of this manual.

PARTS PROVIDED – Four Jaw Segments. **NOTE** – There is only one screw position for each of the Pin jaw segments. Only one screw is necessary because the jaw is designed for small turning work.

OPERATIONAL MODES

a. Pin Jaw Function

A 25mm (1") diameter (approx) hole is needed in the wood blank to accept the jaw. With the jaws fully contracted the bowl blank should slip into place on the jaws. To achieve the best grip it is essential that the jaws are expanded firmly against the sides of the hole.

**THIS METHOD MUST NOT BE USED FOR ANY WORK GREATER THAN 300MM (12") DIAMETER BY 75MM (3") THICK.
DO NOT EXCEED 684RPM. OUT OF BALANCE WORK MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.**

b. Expanding Dovetail Jaws

Using the dovetail section of Pin jaws, bowls up to 150mm (6") diameter by 50mm (2") depth can be turned.

THIS METHOD MUST NOT BE USED FOR ANY WORK WITH DEPTH GREATER THAN 50MM (2") AS THERE WOULD BE GREAT DANGER OF THE WOOD TEARING OUT OF THE CHUCK. DO NOT EXCEED 684RPM IN THIS MODE.

Recess: Maximum recess depth of 4mm.

Any recess diameter can be turned between 25mm (1") to 49.5mm (2").

The optimum recess diameter is 25.5mm (1"). At this diameter full.

contact of the jaws with the recess is achieved. As the recess diameter is increased above 25.5mm, less jaw contact is made. This needs to be kept in mind when considering the recess depth and the size of the wood blank being mounted. Increase the recess depth to maximum if a recess diameter in excess of 25.4mm (1") is used.

c. Square Blanks (Contracting Action)

These jaws can grip a square spigot between approx. 9mm (11/32") to a maximum of 26mm (1").

DO NOT EXCEED 1440RPM IN THIS MODE.

Maximum length Wood blanks up to 150mm (6" by 25mm (1").

d. Spigot Mounting (Contraction Action)

Use wood blank size up to 150mm (6") length by 25mm (1") diameter.

DO NOT EXCEED 1440RPM FOR THIS OPERATION.

Spigot size: Minimum spigot size is approx 11 mm (7/16") up to a maximum size of 25mm (1"). Spigot depth: Always use the maximum spigot depth which is 33mm (1 5/16"). This method must not be used in conjunction with any copy turner device.

e. Special Dowel Function

For lathes with hollow spindled, the Chuck with the Pin jaws mounted could accept long lengths of round dowel below the 25mm (1") size, which could be fed through the lathe spindle and chuck. (The limiting factor would normally be the lathe spindle – e.g. Nova 3000 has a 15mm bore). This means that multiple turnings could be achieved by simply advancing the dowel through the centre of the chuck. The dowel is then secured with the jaws, turned, parted off, and the next piece is pulled through. Do not allow dowel to protrude past spindle on outboard end.

f. Drill Chuck Function

The increased depth (length) of the jaws allows for firm gripping of twist drills to enable the chuck to be used as a drill chuck driven from the headstock spindle. Make sure you use all of the drill section to grip the drill shank. The minimum drill shank diameter: approx: 10mm (13/32").

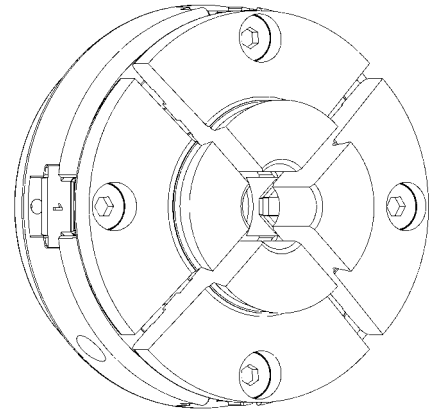
The pin jaw set is not designed for mounting to the Cole/Mini Cole Jaws Sets. DO NOT USE WITH COLE OR MINI COLE JAW SETS.

35mm BOWL JAW

Code: 6019

SAFETY

Consult the safety section on Page 10 of the accessory jaw manual and also read the safety section of your Chuck manual and be thoroughly familiar with the safety operation before using these jaws. In addition, please carefully follow the specific safety information regarding the operational use of the Long nose Jaws outlined in the Operational section.



PARTS PROVIDED – Four bowl jaw segments.

NOTE

Use the M6x10 Countersunk screws provided with your Teknatool Chuck to mount the 35mm Bowl Jaws. Spares can be purchased from the Teknatool Website: www.teknatool.com

MOUNTING JAWS

See “Mounting the Accessory Jaws” on page 12 & 13 of the Accessory Jaw manual.

WARNING - BEFORE OPERATING YOUR BOWL JAW SET:

- DO NOT EXCEED 1000 RPM WITH THE JAWS IN ANY OPERATIONAL MODE.
- OUT OF BALANCE WOOD OR LARGE WOOD BLANKS MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE ON OR BELOW 250 RPM.
- DO NOT ATTEMPT TO USE THESE JAWS IF YOUR LATHE DOES NOT HAVE A USABLE SPEED OF 250 RPM OR BELOW.
- MAKE SURE THAT JAW SLIDES DO NOT PROJECT BEYOND CHUCK BODY WHEN JAWS ARE EXPANDED.
- DO NOT STAND IN A POSITION THAT MIGHT PUT YOU IN THE PATH OF A DISLODGED ROTATING BOWL.

OPERATIONAL MODES

a. Expanding Dovetail Mode

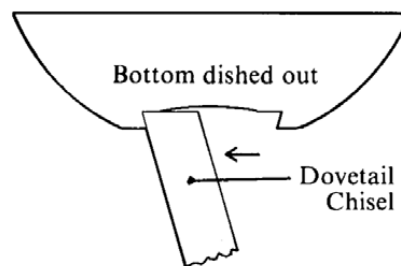
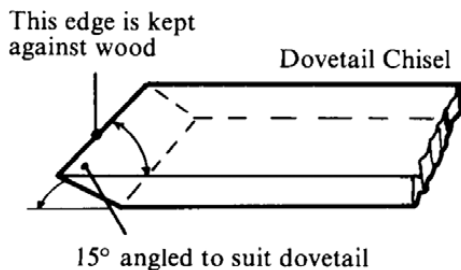
Using the bowl Jaws, bowls up to 300mm (8") in diameter by 150mm (4") depth can be turned. Recommend that there is 50mm (2") of wood outside of dovetail area.

Any recess diameter can be turned between 42mm and 62mm. The optimum aim size (true circle is 45mm).

Note the 42mm, 45mm and 62mm is the small diameter of the recess.

To make the recess is an easy process.

1. Draw a circle on the base of the bowl 45mm diameter.
2. Hollow out the recess area, being careful not to cut out further than the 45mm.
3. Use a left hand skew scraper with a 15 degree angle. These are a common standard chisel.
Position the chisel so that the scraper end is engaged with the wood along its front face.
The edge of the chisel that cuts the recess will now automatically be at 15 degrees.
4. Move the chisel outwards until the chisel is just cutting away the pencil circle. The 45mm is the optimum but you can make smaller (42mm) or up to (62mm) As the recess diameter is increased less jaw contact is made. This needs to be kept in mind when considering the recess depth and size of the wood blank being mounted.

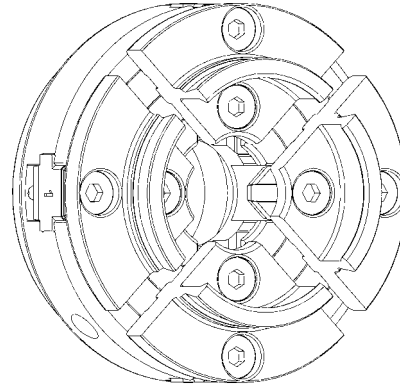


DO NOT EXCEED 600RPM IN THIS MODE

50mm JAW SET

Code: JS50N

These jaws are supplied standard with most Teknatool Chucks. Check your chuck specification.



SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.

MOUNTING THE JAWS

See "Mounting the Accessory Jaws" on page 12 & 13 of this manual.

PARTS PROVIDED – Four jaw segments

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using this method bowls of up to 310mm (12) in diameter by 100mm (4") in depth can be turned.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 100MM AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK. DO NOT EXCEED 684RPM IN THIS MODE. OUT OF BALANCE STOCK MUST BE TURNED AT THE LOWEST SPEED POSSIBLE.

Recess: Maximum recess depth 6mm (1/4). Any recess can be turned between 50mm (2") and 75mm (3") diameter. The optimum recess diameter is 50mm (2"). Where ever possible keep your recess between 50mm – 60mm. Extra care must be taken while turning with recesses above 60mm. **YOU MUST USE THE MAXIMUM RECESS DEPTH ON ALL RECESSES OVER 64mm (2.5") diameter OR ANY WORK WITH A DIAMETER OVER 150MM (6").**

For smaller lids and thin platters, not exceeding 150mm diameter, only a shallow recess of around 3mm (1/8") is necessary.

b. Square Blanks (Contracting Action)

These jaws can grip a square spigot between approximately 40mm (1 9/16") to a maximum of 50mm (2").

DO NOT EXCEED 1020RPM IN THIS MODE

Maximum length: Wood blanks up to 150mm (6") length by 100mm (4").

c. Spigot Mounting (Contracting Action)

Use wood blank size up to 150mm (6") length by 100mm (4") diameter.

DO NOT EXCEED 1020RPM IN THIS OPERATION

Spigot Size: Minimum spigot size of 45mm (1 49/64") up to a maximum spigot size of 65mm (2 9/16").

Spigot Depth: The length of the spigot area must not be less than 16mm (5/8").

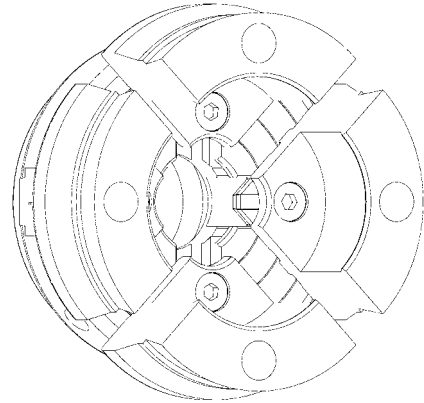
75mm Bowl Jaw

Code: 6014

SAFETY

Consult the safety section on Page 10 of the accessory jaw manual and also read the safety section of your Chuck manual and be thoroughly familiar with the safety operation before using these jaws.

In addition, please carefully follow the specific safety information regarding the operational use of the Long nose Jaws outlined in the Operational section.



PARTS PROVIDED – Four 75mm bowl jaw segments

NOTE

Use the M6x10 Countersunk screws provided with your Teknatool Chuck to mount the Long nose Jaws. Spares can be purchased from the Teknatool Website: www.teknatool.com

MOUNTING JAWS

See “Mounting the Accessory Jaws” on page 12 & 13 of the Accessory Jaw manual.

WARNING - BEFORE OPERATING YOUR BOWL JAW SET:

- DO NOT EXCEED 1000 RPM WITH THE JAWS IN ANY OPERATIONAL MODE.
- OUT OF BALANCE WOOD OR LARGE WOOD BLANKS MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE ON OR BELOW 250 RPM.
- DO NOT ATTEMPT TO USE THESE JAWS IF YOUR LATHE DOES NOT HAVE A USABLE SPEED OF 250 RPM OR BELOW.
- MAKE SURE THAT JAW SLIDES DO NOT PROJECT BEYOND CHUCK BODY WHEN JAWS ARE EXPANDED.
- DO NOT STAND IN A POSITION THAT MIGHT PUT YOU IN THE PATH OF A DISLODGED ROTATING BOWL.

OPERATIONAL MODES

a. Expanding Dovetail Mode

Using the Bowl Jaws, bowls up to 300mm (12") in diameter by 150mm (6") depth can be turned. Recommend that there is 50mm (2") of wood outside of dovetail area. Any recess diameter can be turned between 42mm and 62mm. The optimum aim size (true circle is 45mm).

Note the 42mm, 45mm and 62mm is the small diameter of the recess.

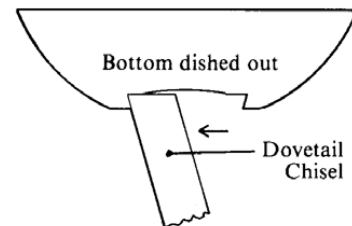
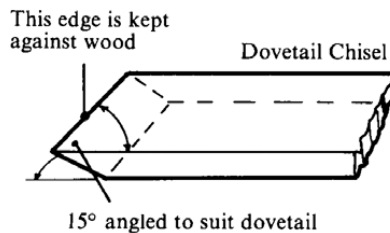
To make the recess is an easy process.

1. Draw a circle on the base of the bowl 45mm diameter.
2. Hollow out the recess area, being careful not to cut out further than the 45mm.
3. Use a left hand skew scraper with a 15 degree angle. These are a common standard chisel.

Position the chisel so that the scraper end is engaged with the wood along its front face.

The edge of the chisel that cuts the recess will now automatically be at 15 degrees.

4. Move the chisel outwards until the chisel is just cutting away the pencil circle. The 45mm is the optimum but you can make smaller (42mm) or up to (62mm) As the recess diameter is increased less jaw contact is made. This needs to be kept in mind when considering the recess depth and size of the wood blank being mounted.



THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 100MM (4") AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK. **DO NOT EXCEED 750 RPM IN THIS MODE OUT OF BALANCE WOOD MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.**

b. Spigot Mounting Rounds Recommendations For Endgrain Wood Only

Wood should be pre-machined to a cylinder (to optimise balance) with a diameter 75mm. This method can be used to grip pre-machine/pre-turned spigots between diameter. Use the maximum spigot depth that is practicable.

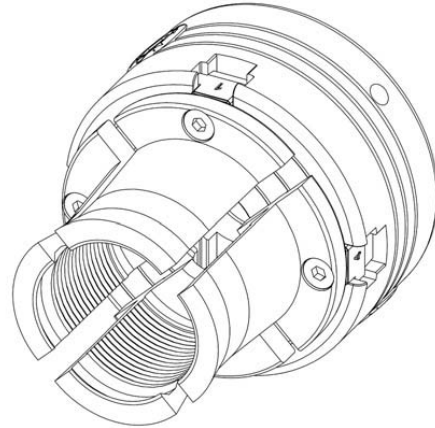
DO NOT EXCEED 600RPM IN THIS MODE

LONGNOSE JAW

Code: 6012

SAFETY

Consult the safety section on Page 10 of the accessory jaw manual and also read the safety section on Page 3 of your Chuck manual and be thoroughly familiar with the safety operation before using these jaws. In addition, please carefully follow the specific safety information regarding the operational use of the Long nose Jaws outlined in the Operational section.



PARTS PROVIDED – Four long nose jaw segments.

NOTE: Use the M6x10 Countersunk screws provided with your Teknatool Chuck to mount the Long nose Jaws. Spares can be purchased from the Teknatool Website: www.teknatool.com

MOUNTING THE JAWS

See “Mounting the Accessory Jaws” on page 12 & 13 of this manual.

WARNING - BEFORE OPERATING YOUR LONGNOSE SET:

- DO NOT EXCEED 1000 RPM WITH THE JAWS IN ANY OPERATIONAL MODE.
- OUT OF BALANCE WOOD OR LARGE WOOD BLANKS MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE ON OR BELOW 250 RPM.
- DO NOT ATTEMPT TO USE THESE JAWS IF YOUR LATHE DOES NOT HAVE A USABLE SPEED OF 250 RPM OR BELOW.
- MAKE SURE THAT JAW SLIDES DO NOT PROJECT BEYOND CHUCK BODY WHEN JAWS ARE EXPANDED.
- DO NOT STAND IN A POSITION THAT MIGHT PUT YOU IN THE PATH OF A DISLODGED ROTATING BOWL.

OPERATIONAL MODES

a. Expanding Dovetail Mode

Using the Long nose Jaws, bowls up to 200mm (8") in diameter by 100mm (4") depth can be turned. Recommend that there is 50mm (2") of wood outside of dovetail area.

Any recess diameter can be turned between 43mm and 72mm. The optimum aim size (true circle is 56mm).

Note the 42mm, 45mm and 62mm is the maximum internal diameter of the recess.

To make the recess is an easy process.

1. Draw a circle on the base of the bowl 45mm diameter.
2. Hollow out the recess area, being careful not to cut out further than the 45mm.
3. Use a left hand skew scraper with a 15 degree angle. These are a common standard chisel.

Position the chisel so that the scraper end is engaged with the wood along its front face.

The edge of the chisel that cuts the recess will now automatically be at 15 degrees.

Alternatively The Nova Dovetail chisel product code 6008 can be used.

4. Move the chisel outwards until the chisel is just cutting away the pencil circle. The 45mm is the optimum but you can make smaller (43mm) or up to (72mm) As the recess diameter is increased less jaw contact is made. This needs to be kept in mind when considering the recess depth and size of the wood blank being mounted.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 100mm (4") AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK. DO NOT EXCEED 750 RPM IN THIS MODE OUT OF BALANCE WOOD MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.

b. Square Blanks (Contracting Action)

These jaws can grip a square spigot between approx. 31mm (1 1/8") to a maximum of 45mm (1 3/4").

DO NOT EXCEED 600 RPM IN THIS MODE

d. Spigot Mounting Rounds Recommendations For Endgrain Wood Only

Wood should be pre-machined to a cylinder (to optimise balance) with a diameter 75mm. This method can be used to grip pre-machine/pre-turned spigots between 40 mm (1 1/2") up to 60mm (2 1/3") diameter. Use the maximum spigot depth that is practicable.

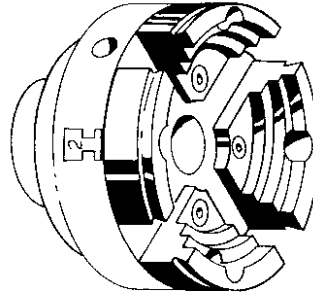
DO NOT EXCEED 600 RPM IN THIS MODE

STEP JAW SET

Code: JS75N

SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.



MOUNTING THE JAWS

See “Mounting the Accessory Jaws” on page 12 & 13 of this manual.

PARTS PROVIDED – Four jaw segments note – The step jaws are numbered on the underside of each segment.

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using the expanding dovetail function of the step jaws, bowls up to 360mm (14”) diameter by 100mm (4”) depth can be turned. Use the dovetail form on the outer part of the jaws. Any recess can be turned in between 76mm (3”) to 98mm (3 27/32”). At the 79mm diameter, full contact of jaws with recess is achieved. As the recess diameter is increased above 79mm less jaw contact is made. This needs to be kept in mind when considering the recess depth and size of the wood being mounted. As a rule, increase the recess depth to a maximum if a recess diameter in excess of 79mm is used.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 75mm AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK. DO NOT EXCEED 684RPM IN THIS MODE. OUT OF BALANCE STOCK MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.

Recess – A full recess depth of 6.5mm (1/4") is available. Recess depth can be varied; shallow for smaller/thin wood blanks. Note guidelines above the recess over 79mm diameter.

b. Contracting Mode for Footed Bowls

Three step sizes are provided for gripping footed bowls.

Step one (smallest) – The optimum foot grip size is 42mm (1 21/32"). To ensure there is no crushing of the wood the size of the bowl foot should be made as close as possible to 42mm. Larger diameters up to 61 mm (2 13/32") can be used but above 42mm the edges of the jaws can mark the wood. It is suggested that masking tape be used to help protect the foot from jaw marks.

NOTE: Using this smallest step, consideration needs to be given to the shape of the lower part of the bowl so it does not contact the jaw steps above.

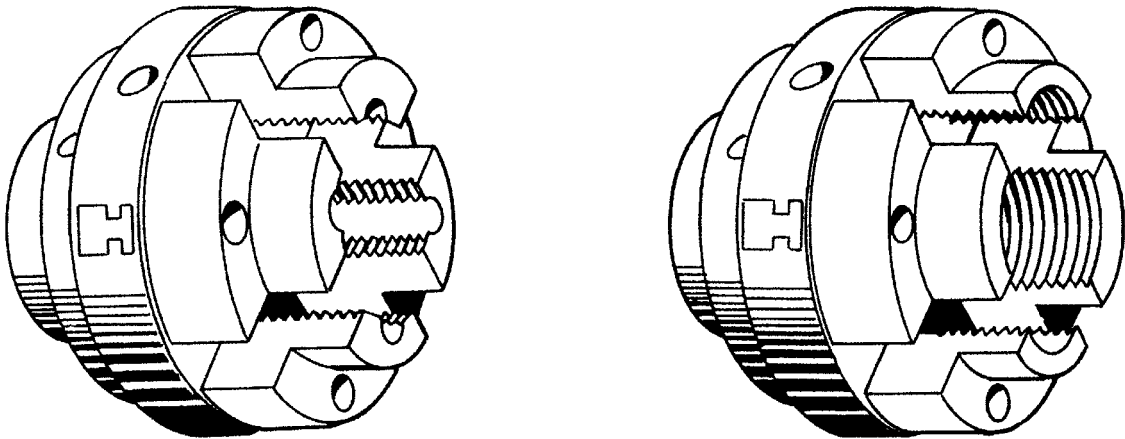
Step Two – The optimum foot size is 50mm (2") to a maximum of 68mm (2.68").

Step Three – The optimum foot size is 64mm (2 1/2") up to a maximum of 80mm (3 9/64").

DO NOT EXCEED 684RPM IN THIS MODE

OPTIONAL ACCESSORIES

Not applicable for this jaw set.



SPIGOT JAW 35mm and SPIGOT JAW 45mm

Code: JS-SP35 and JS-SP45

SAFETY

Consult the safety section on Page 10 of this jaw manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.

MOUNTING THE JAWS

See "Mounting the Accessory Jaws" on page 12 of this manual.

PARTS PROVIDED – Four jaw segments.

OPERATIONAL MODES

a. Expansion Mode

In the expansion mode either the 35mm or 45mm spigot jaws can hold any parallel opening (hollowed boxes, vases, etc...) up to 120mm (4 45/64") diameter by 150mm (6") depth.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 150MM AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK.

DO NOT EXCEED 684RPM IN THIS MODE. OUT OF BALANCE STOCK MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.

There are two steps which provide for two different sizes of holding.

SMALL STEP

Any recess diameter can be turned between 53mm (2 3/32") and 71 mm (2 51/64"). The optimum recess diameter is 53mm (2 3/32"). At this diameter, full contact of jaws with recess is achieved. As the recess diameter is increased above 53mm less jaw contact is made. Increase the recess depth to maximum if a recess diameter in excess of 55mm (2 5/32") is used.

LARGE STEP

Any recess diameter can be turned between 77mm (3") and 97mm (3 13/16"). The optimum recess diameter is 77mm (3"). At this diameter, full contact of jaws with recess is achieved. As the recess diameter is increased above 77mm (3"), less jaw contact is made. Increase the recess depth to maximum if a recess diameter in excess of 80mm (3 5/32") is used.

b. Contracting Action Square Blanks

Both the 35mm and 45mm jaws can grip a square spigot between 30mm (1 3/16") to a maximum of 45mm (1 25/32").

DO NOT EXCEED 684RPM IN THIS MODE.

MAXIMUM LENGTH: Wood blanks up to 260mm (10 1/4") length by 150mm (6").

c. Contracting Action Spigot Mounting

DO NOT EXCEED 684RPM FOR THIS OPERATION.

Use wood blank size up to 260mm (10 1/4") length by 150mm (6") in diameter.

Spigot sizes: 35mm Jaws: 30mm (1 3/36") minimum to 50mm (2") maximum.
45mm Jaws: 38mm (1 1/2") minimum to 60mm (2 3/8") maximum. Spigot Depth:
Always use maximum spigot depth of 30mm (1 3/16").

OPTIONAL ACCESSORIES

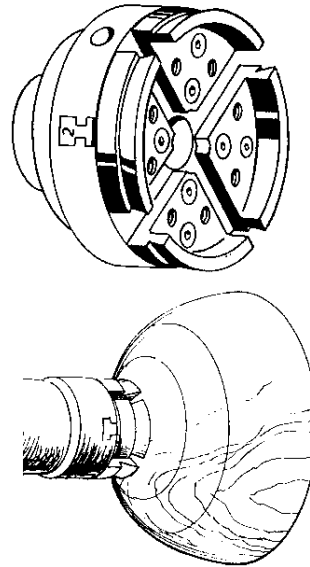
Not applicable for this jaw set.

100mm JAWS

Code: JS100N

SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.



MOUNTING THE JAWS

See "Mounting the Accessory Jaws" on page 12 & 13 of this manual.

PARTS PROVIDED – Four jaw segments

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using this method with the 100mm jaws, bowls up to 360mm (14") diameter by 127mm (5") depth can be turned. Any recess can be turned between 97mm (3 13/16") to 117mm (4 39/64"). The optimum recess diameter is 97mm (3 13/16"). At this diameter full contact of jaws with recess is achieved. As the recess diameter is increased above 97mm, less jaw contact is made. This needs to be kept in mind when considering the recess depth and the size of the wood blank being mounted. Increase the recess depth to maximum if recess diameter in excess of 100mm is used. **Recess:** A full recess depth of 9mm (11/32") is available.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 127MM AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF CHUCK. **DO NOT EXCEED 684RPM IN THIS MODE.**

b. Reverse Dovetail (Contracting Action)

There is a reverse dovetail to grip bowls with a foot mounting. Bowls/platters up to 310mm (12") can be turned. The optimum foot diameter is 85mm (3 11/32"). Larger foot diameters can be used up to 92mm (3 5/8"), but above 90mm (3 35/64") the edges of the jaws can mark the wood. It is suggested that masking tape be used to protect the foot from jaw marks. The maximum available foot depth is 12.5mm (1/2").

DO NOT EXCEED 684RPM IN THIS MODE.

c. Square Blanks (Contracting Action)

These jaws are not recommended for square blanks.

d. Spigot Mounting (with Reverse Dovetail)

A spigot using a reverse dovetail – same foot mounting procedure as in b. Wood should be pre-machined to a cylinder (to optimise balance) with a diameter no greater than 127mm (5"). DO NOT USE ANY EXTENSION OVER 120mm (4 47/64").

DO NOT EXCEED 684RPM IN THIS MODE

Spigot Depth: Always use maximum spigot depth of 12.5mm (1/2")

e. False Wooden Jaws

Custom wooden jaw segment mounted on 100 or 130mm jaws. No responsibility can be accepted for the user's own adaptations of this custom facility. It is the user's responsibility to ensure that work is safely mounted.

Provision is made for the 100mm jaws to take custom false wooden jaws. There are two screw positions in each jaw slide. These are made to accept a M6 by 30 Allen Head Cap Screw. The optional fastening kit for the 100mm jaws F100N can also be used with the 130mm jaws. This pack comes with 8 M6x30 Capscrews and a M5 Allen Key.

METHOD:

Careful consideration is needed as to the type of holding situation that is required for the false wooden jaws. This will influence jaw diameter and design. The following information is simply intended as a guideline. Turn a cylinder between centres to the approximate diameter required for the false wooden jaws. A cylinder of about 88mm (3 15/32") will provide for good expansion of false wooden jaws. However any diameter between 87mm (3 27/64" and 100mm (4") can be used.

SCREW DEPTH:

Use M6x30 screws. When the screws are fully screwed into the jaws there is a height of 24mm of screw under the head. Note: Screws can only be screwed in to a depth FLUSH with the underside of the jaw. IF SCREWS CONTACT FACE OF THE CHUCK THEY WILL PREVENT JAW MOVEMENT. Provision needs to be made for the screw head. Countersunk diameter is 10mm (25/64"). Countersunk depth depends on the length of the wooden blank. However the holes need to be countersunk to a depth such that the screw is fully home, flush with the underside of the jaw. It is helpful to bore the holes slightly oversize so there is some adjustment.

SCREW POSITION:

Suggested method – Open jaws up to accept the wooden blank. Remove blank. Use wooden blank to trace a circle on a piece of thin cardboard. Place cardboard on the mounted jaws and trace out the screw position. Use a pin punch or compass point to mark out the centre of the holes. Now place cardboard form over the end of the wooden blank and mark hole position. There are two hole positions on each jaw segment. Use two screws per segment to secure each false wooden jaw.

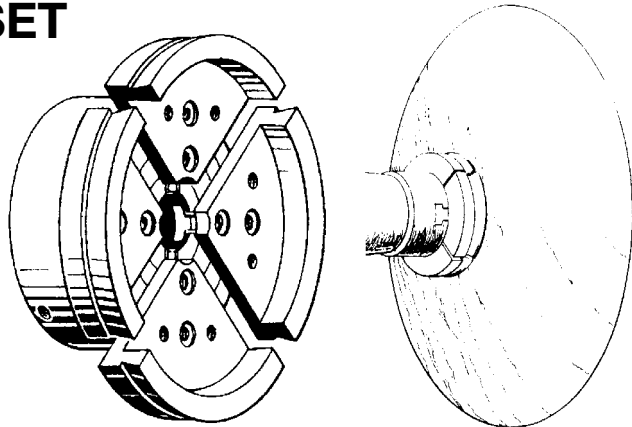
OPTIONAL ACCESSORIES:

Fastening Kit for False Wooden Jaws Code: F100N

130mm JUMBO JAW SET

Code: JS130N

NOTE: It is recommended that this is only used on lathes which has a spindle of 1" or more in diameter.



SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws. In Addition:

1. **DO NOT EXCEED 400RPM WHEN USING THESE JAWS.** Speeds higher than this could pose a serious hazard with wood blocks 400mm (16") and over. Keep to the slowest speed available on your lathe when first turning the rough wood block to shape.
2. For large or out of balance work the full depth of the jaws should be used i.e. 9mm dovetail or 12.5mm spigot.

DO NOT USE THIS JAW ON YOUR PRECISION MIDI CHUCK.

MOUNTING THE JAWS

See "Mounting accessory jaws" page 12 of this manual.

PARTS PROVIDED – Four Jaw Segments

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using this method bowls up to 750mm (29 1/2") diameter by 75mm (3") depth can be turned. Any recess can be turned between 124mm (4 7/8") to 149mm (5 7/8"). The optimum recess diameter is 128.5mm (5"). At this diameter full contact of jaws with recess is achieved. As the recess diameter is increased above 128.5mm, less jaw contact is made. This needs to be kept in mind when considering the recess depth and the size of the wood bland being mounted. As a rule, increase the recess depth to maximum if recess diameter in excess of 128.5mm is used. The full recess depth of 9mm should be used on all recess

