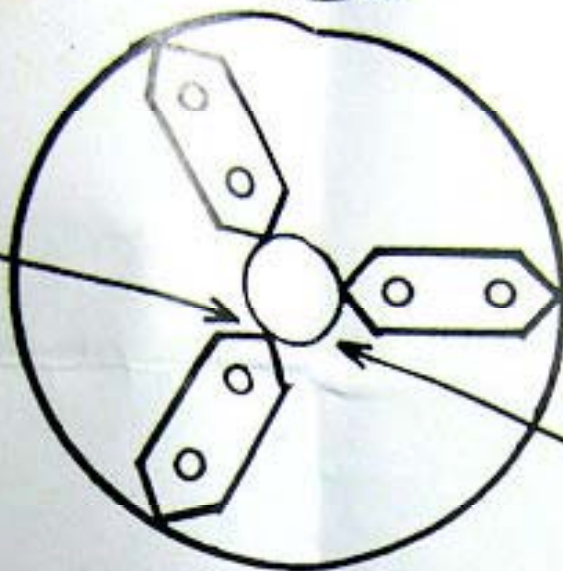


### THREE JAW CHUCK

Turn until  
all 3 jaws show  
sign of clean up.



Place washer or  
25¢ piece in chuck  
then close chuck.  
(Caution: Have  
washer or 25¢ piece  
contact the jaws  
only, then file a  
slight projection  
remaining on jaws.)

Note: Jaws are supplied in a rough machined condition and must be bored(turned) to insure maximum accuracy on each machine.

1. Clean spindle threads and oil spindle and chuck.  
Do not spin chuck on spindle-screw it on slowly to avoid jamming.
2. To machine (bore) jaws on chuck, open chuck by rotating ring then place a washer or 25¢ piece toward the back of jaws. Machine the jaws after closing chuck on washer-this forces the jaws out like a work piece will.
3. The chuck jaws will not come out in normal usage. To remove them the snap ring must be removed.