

**The Wooden Post, Inc.**  
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## **1-3/8" Combination Expanding Collet Chuck**

**#1612 - 3/4" x 16 tpi**

**#1614 - 5/8" Bore**

**#1613 - 1" x 8 tpi**

**#1615 - #1 Morse Taper**

**#1616 - #2 Morse Taper**

1: To mount your workpiece (ie. clock insert, small bowl, etc.) use a 1-3/8" forstner bit to bore a flat bottom hole with smooth sides. Drill a minimum depth of 1/2" and maximum 1/2". Insert the collet jaws into the hole with the top plate flush against the hole bottom. Twist the chuck body clockwise to secure the workpiece.

2: When using this chuck as a screw chuck, unscrew the collet jaw assembly, and replace with the supplied hanger bolt. Screw-in the supplied set screw from the back (inside the spindle hole) up against the end of the hanger bolt. Tighten both screws. This will lock both screws in place during turning. Drill a 3/16" pilot hole in the workpiece.

3: Please DO NOT EXCEED 3000 rpm while using this product, and do not run the lathe with the chuck in place without a workpiece.

### **SPECIAL NOTES FOR MORSE TAPER CHUCKS:**

A: When using morse taper chucks without the tailstock engaged, you MUST use a draw bolt. This is accomplished by using a 1/4" x 20 tpi threaded rod or long bolt, plus a wing nut or hex nut, plus a large washer. Thread the bolt into the rear of the taper and tighten it up against the spindle with the nut and washer. This will prevent the chuck from disengaging from the lathe while in use.

B: The hanger bolt has been modified to self-bottom in the morse taper chucks to eliminate any thread binding.