

4-Jaw Self-Centering Mini-Grip 3 Chuck System

Product #1632

The Ideal Chuck for Mini and Midi Woodworking Lathes

Warranty

Thank you for purchasing one of our growing family of woodworking products. The Mini-Grip 3 #1632 is engineered and manufactured to the highest standards of quality. You will find this product an essential accessory to your workshop.

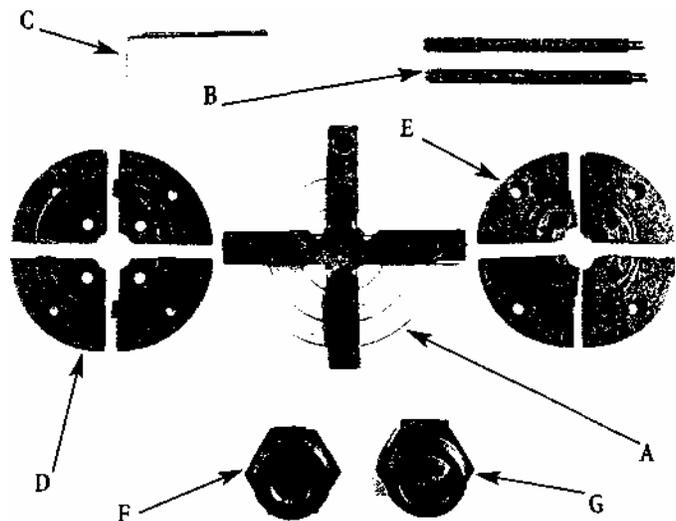
This product is warranted against defects in material and workmanship for a period of two years for all components. This warranty applies to the original purchaser of the product and is limited to the repair and/or replacement of the product, or its parts at the discretion of the distributor. Excluded are parts which have been misused, abused, altered, or consumed by normal operation of the chuck. Also excluded are direct or consequential damages to persons, properties, or materials. Your invoice serves as proof of purchase and must be referenced to authorize any warranty repair. Call us for proper authorization.

Safety Instructions for the Mini-Grip 3 Chuck System #1632

1. Do not wear gloves or loose clothing when turning
2. Do not wrap any strip sandpaper or clothing around your hands or fingers when sanding or turning.
3. Use proper eye protection when turning.
4. Check your wood for splits, weakness or cracking prior to loading the chuck.
5. Confirm that the wood is tightly gripped before turning your chuck under power.
6. Rotate the chuck manually prior to starting your lathe to confirm proper clearance.
7. Always check and re-tighten after any problem or catch.
8. Use appropriate speeds as referenced in instructions.
9. Always turn with sharp lathe chisels.

Package Contents

- A. Mini-Grip 3 Chuck with straight jaws mounted.
- B. Tightening levers (2 each)
- C. Hex wrench
- D. 1 set (4 pieces) of #2 round jaws
- E. 1 set (4 pieces) #1 step jaws
- E 3/4"-16tpi adapter
- G. 1"-8tpi adapter



Jaw Capacity Chart Gripping Dowel

Dia. Gripping in Hole Dia.

Jaw Style

Basic Straight	from 1/8" to 1"	
#1 Step Jaws	from 3/8" to 1-1/4"	from 1" to 2- 1/2"
#2 Round jaws	from 1-1/2" to 2-3/8"	from 2" to 3"

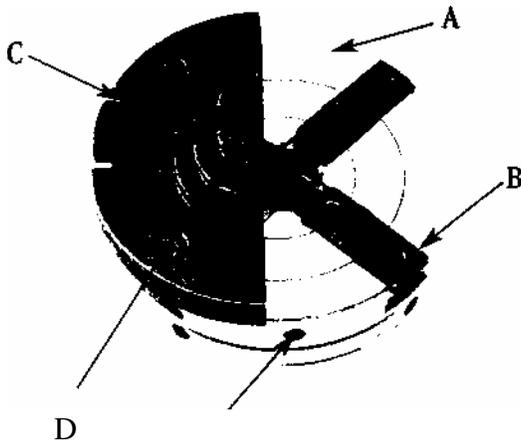
Optional Flat Jaws-#1631

for finishing bowls from 3-1/2" to 4-3/4" bowl dia.

1632I Mini-Grip 3 Chuck System Description

- A. Main body of chuck designed to hold all other jaws as an assembly.
- B. Carriers-To which the top jaws are attached with two hex screws. (2 each jaw)
- C. Jaws-Attaches to the carrier used for gripping the wood product to be turned (stepped jaws, are shown in the below photograph).
- D. Hex screws- attaches jaws to chuck (2 per jaw).
- E. Pin holes for tightening levers.

Installing the Jaws



(Shown with two #1 step jaws installed)

Select the appropriate jaw for your project. Place the selected jaw on top of the carrier. Using the provided hex wrench and the two hex screws, firmly tighten the jaw down onto the surface of the carrier. Repeat this step for the remaining three jaws. Match the number stamped on the main body to the number on each individual jaw.

Maintenance

Brushing is all that is needed to clean your chuck. If the chuck becomes sticky, soak in varsol or mineral spirits with 10% oil added. Soak for thirty minutes and blow dry.

Mounting the Adapter

1. Wipe the inside of the threads and the outside of the adapter to insure both surfaces are clean.
2. Select the appropriate adapter for your lathe, 3/4"-16tpi adapter or 1"-8tpi adapter.
3. Holding the chuck in your hand, screw and tighten the adapter into the bottom threaded portion of the chuck.



Mounting the 1632 Mini-Grip 3 Chuck to your lathe

Screw the completed assembly onto your lathe. The chuck should go on effortlessly with no binding. Screw the chuck all the way until the adapter face contacts the shoulder of the lathe spindle. Lock the spindle, slightly unscrew the chuck and give it a firm spin. This then will snap the chuck firmly in place.

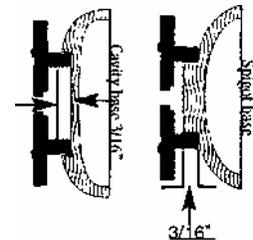
Operating the 1632 Mini-Grip 3 Chuck

Your chuck has two movable layers. Each layer has 4 small pin openings to accommodate the tightening levers. Insert a tightening lever into one of the pin holes on each level. Rotate the tightening levers away or toward each other to close or open the chuck.

Chuck Gripping Depth

When turning a bowl, allow a minimum amount of wood for the chuck to grab while turning.

1. Spigot base (outside grip)
 - for a 2" diameter base minimum grip is 3/16".
2. Cavity base (inside grip) - for a 2" diameter base, minimum hole depth is 3/16".



Lathe speeds

Make sure your wood is properly aligned and balanced when mounted.

- Turning- 500-1500 RPM
- Sanding & Polishing -1500 - 2500 RPM Use slower speeds for larger work.