



# 4 Jaw Chuck System

## For Woodturning Lathes

Version 1.0

### Safety First



Disconnect tool from power source before fitting or removing insert.



Always wear proper ear protection when working with machinery.



Use caution when handling sharp objects (saw blades, router bits, drill bits and so on). Use protective gloves whenever possible.



Always wear proper eye protection when working with machinery and tools.



Always wear proper respiratory protection when working near airborne dust particles.

Please read and fully understand any and all safety materials that came with your power tools or machinery before operation. Always follow all safety guidelines set in place by the power tool or machine manufacturer.



#### 4 Jaw Chuck Contents

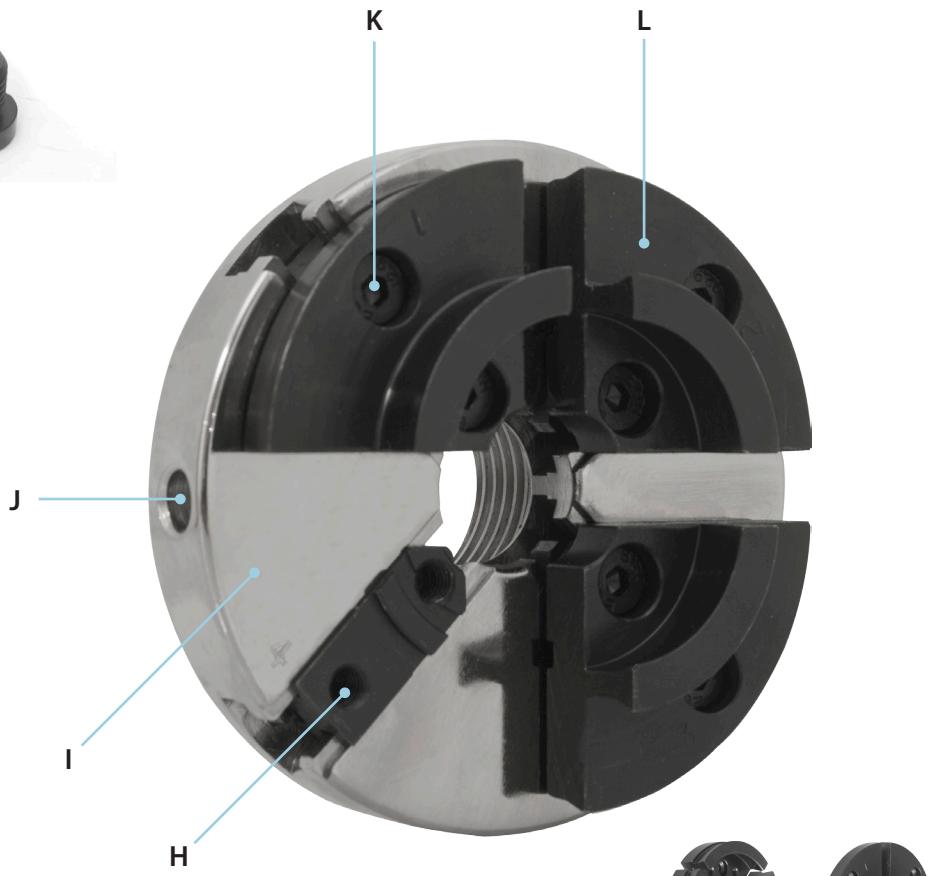
- A. Chuck with standard jaws
- B. Hex key wrench
- C. Lever for tightening/loosening
- D. Lever for tightening/loosening
- E. Adapter (size varies depending on which set you purchased)
- F. 8 extra Jaw Installation Screws
- G. Screw Chuck

#### Chuck Description

- H. Carrier: Chuck jaws are secured here using two of the 8 Jaw Installation Screws
- I. Main Chuck Body
- J. Holes for Levers to tighten chuck jaws for a secure grip
- K. Hex Screws used for securing the jaws to the carrier
- L. Chuck Jaws are attached to the carrier which can be adjusted as needed.

#### Savannah 4-Jaw Chuck System

The Savannah Self-centering 4 jaw woodturning chuck has a large range of jaw adjustability. To adjust the quick action on the chuck simply insert the locking levers into the chuck and rotate them in opposite direction to grip in the contraction mode or expansion mode. The powerful jaws will grip and expand in a 2" to 3" dovetail recess in the base of your project. The chuck body is chrome plated and the jaws are black anodized to protect against corrosion. The chuck comes with a screw chuck that does not require any accessories or disassembly to use.



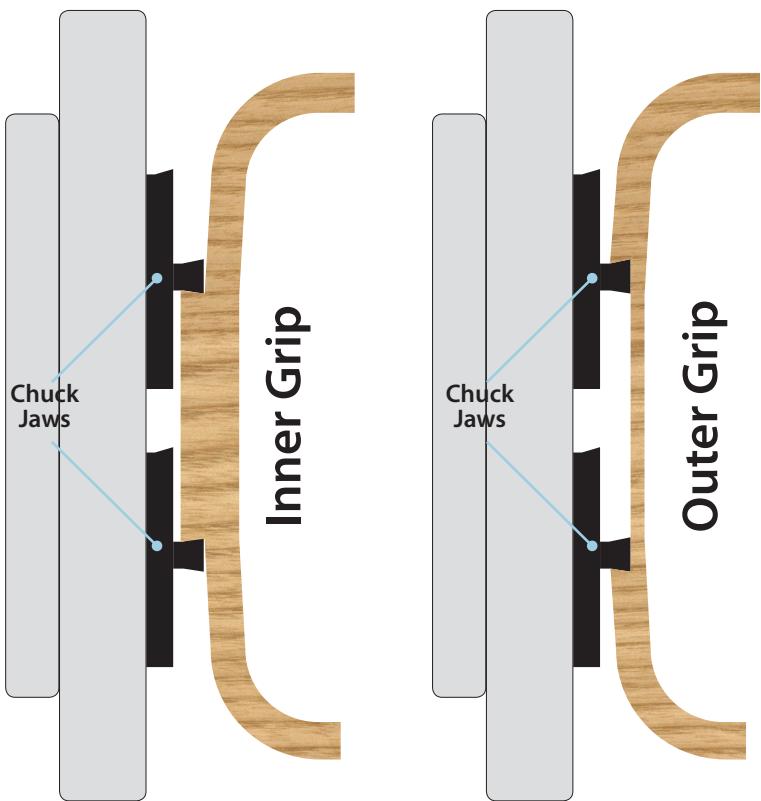
#### Optional Chuck Jaws

Sold separately, please check with your local retailer.



**1**

## Gripping Depth



For safety reasons we recommend a minimum depth of 3/16" or more for the jaws to grip your project. These jaws are dovetailed for increased gripping power. For this reason we also recommend turning a slight dovetail on to the recess or tenon for better grip.

### Inner Grip:

Recess in work piece maximum is approximately 2" in diameter  
Recess in work piece minimum is approximately 3/16" in depth

### Outer Grip:

Tenon on work piece maximum is approximately 2" in diameter  
Tenon on work piece minimum is approximately 3/16" in depth

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## Turning Speed



Typically when turning, your lathe speed varies project to project. It can also change as your project moves along. The general "rule of thumb" is to run your lathe at higher speeds for smaller projects and slower speeds for larger projects. Higher speeds are also generally used when sanding, buffing or polishing your project.

General Turning Speed:  
500 to 1500 RPM

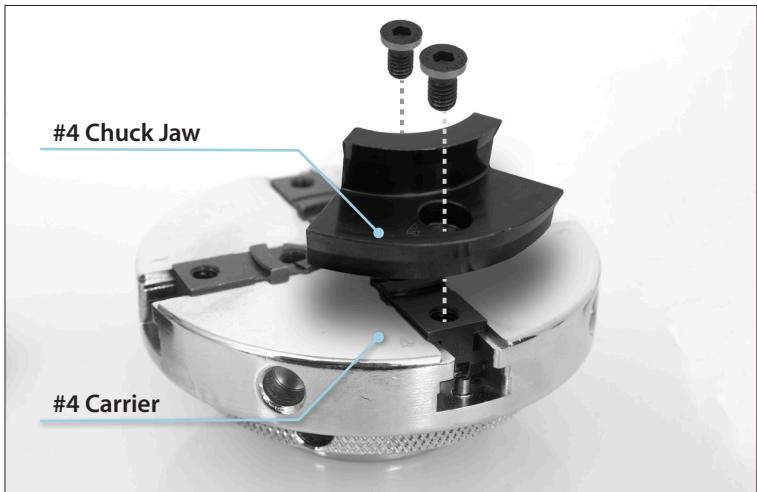
Sanding, Buffing and Polishing:  
1500 to 2500 RPM

### Please Note:

*When turning any project, it is important to make sure your work piece is properly balanced and properly aligned when the stock is either mounted or re-mounted.*

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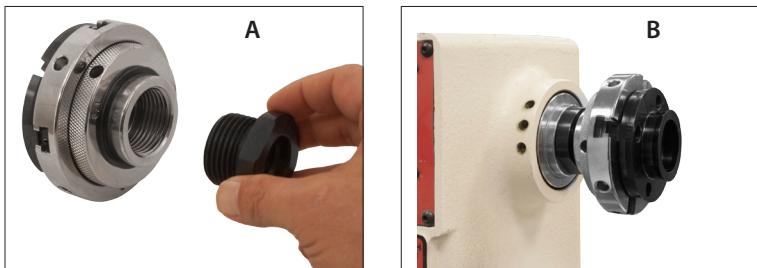
## Installation of Chuck Jaws



Locate and match the number on the chuck body to the corresponding number on the chuck jaw. In the example above we used Chuck Jaw #4 being installed into Chuck Carrier #4. Place the corresponding jaw on to the carrier. Using the provided set screws, firmly secure the jaw to the chuck surface. Once firmly secured, repeat this process for the remaining three jaws.

**4**

## Mount Chuck Adapter & Chuck

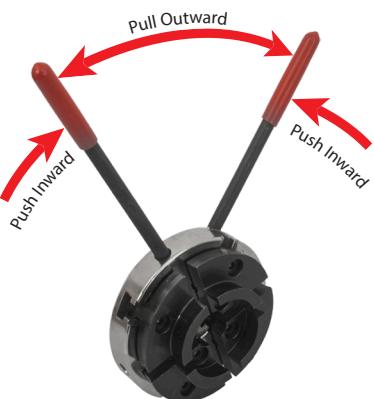


A. Make sure the chuck adapter is clean and free of debris. While holding the chuck on your hand, thread the chuck adapter into the back side of the chuck until it is fully seated into the chuck.

B. Thread the chuck on to your lathe. The chuck should thread on to the lathe smoothly and effortlessly. The chuck should be all the way up and against the base of the lathe adapter. Lock your lathe spindle, loosen the chuck slightly by turning it counter clockwise, then give the chuck a firm spin clockwise until it snaps in place.

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## Basic Chuck Operation



The 4 jaw chuck operates with two rotating discs. Each disc has holes around the outside that accept the included tightening/loosening levers. The levers tighten and loosen the chuck for jaw adjustment or change out. Insert a lever into one of the holes the large disc, then insert the other lever into a hole on the smaller disc. Push or pull the levers toward or away from one another to either open or close the chuck.

### Please Note:

*Basic Maintenance should be performed on the chuck from time to time. Brushing is all that is really necessary to clean your chuck. Sometimes however, your chuck may become sticky from the wood debris and resin, if this happens soak the chuck in mineral spirits with about 10% oil added in. Let the chuck soak for about 30 minutes, then use a blow dryer to dry the chuck off.*