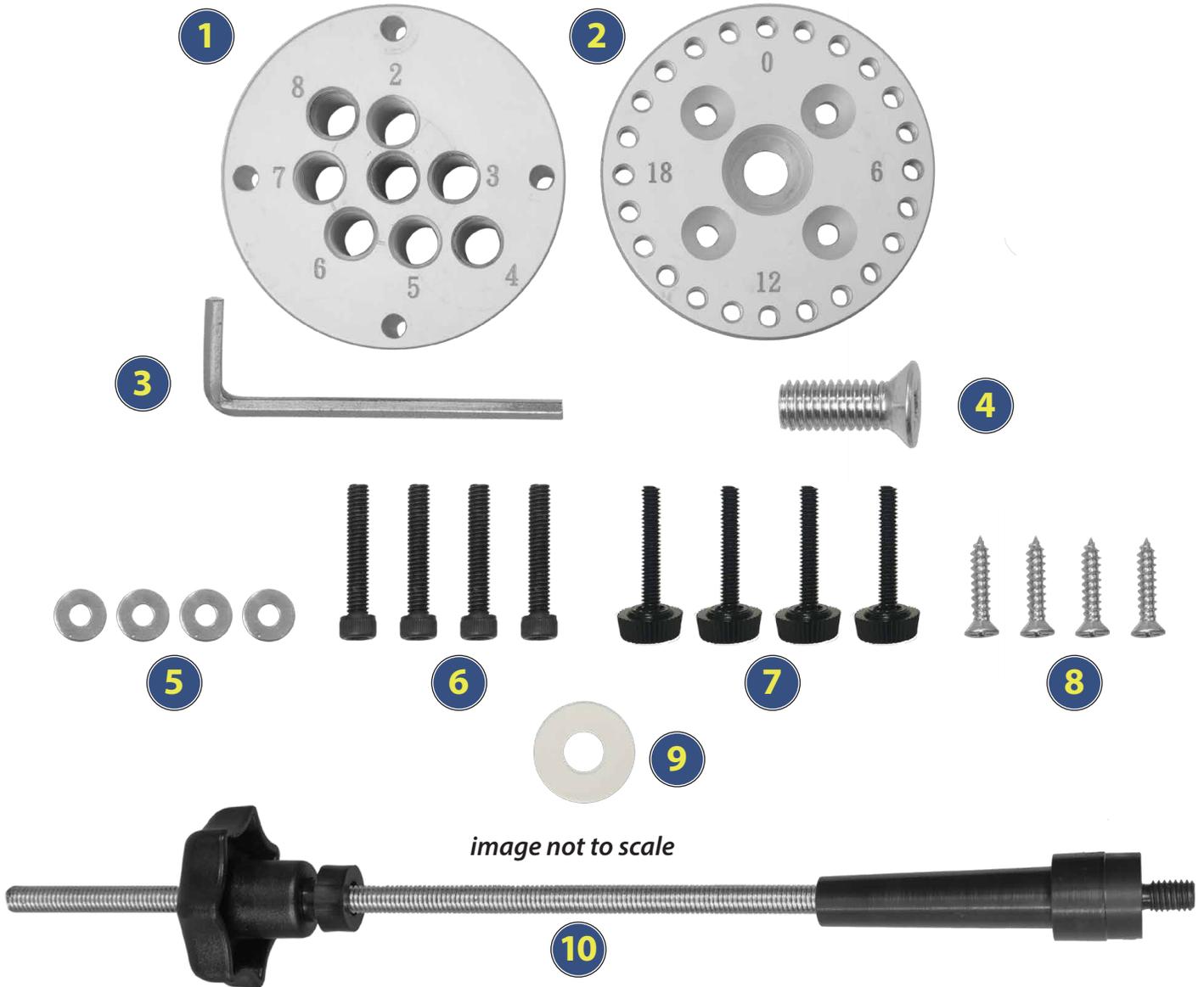


## ⚠ CAUTION

Be sure to read, follow and understand your machine or power tools instruction and safety procedures before proceeding. Always wear proper safety equipment and unplug any machine or power tool before making any adjustments.



## Package Contents

- |  |   |
|--|---|
| <b>1.</b> 1 each Off Set Chuck                 | <b>6.</b> 4 each Bolts (for large projects) |
| <b>2.</b> 1 each Indexing Plate                | <b>7.</b> 4 each Thumb Screws               |
| <b>3.</b> 1 each Hex Key Wrench                | <b>8.</b> 4 each Wood Screws                |
| <b>4.</b> 1 each Bottle Stopper Mounting Screw | <b>9.</b> Nylon washer for chuck mount      |
| <b>5.</b> 4 each Washers                       | <b>10.</b> 1 each Draw Bar / MT2 Mount      |

### Off Set Chuck Assembly

1



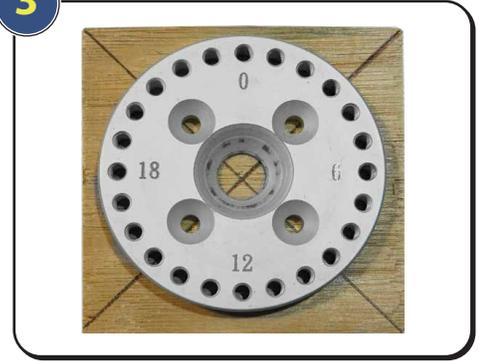
Insert the MT-2 mount into and through the headstock spindle on your lathe.

2



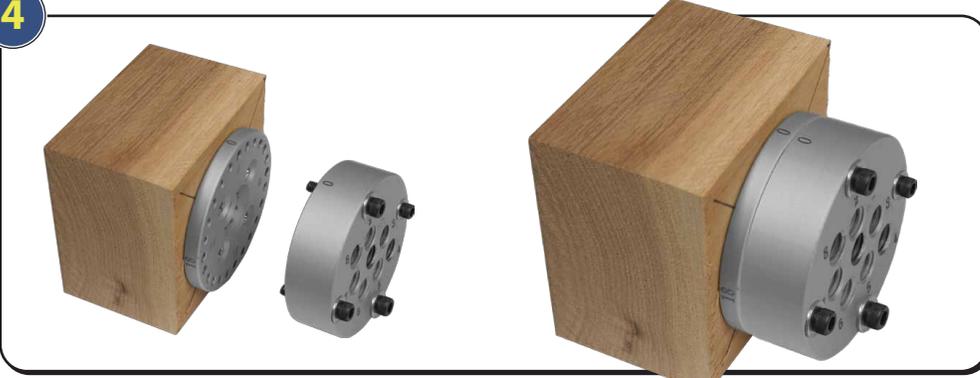
Install the black washer and thread the knob on to the thread of the drawbar and secure. *NOTE: The draw bar is intentionally made extra long to fit most any lathe. You may cut the bar shorter if desired.*

3



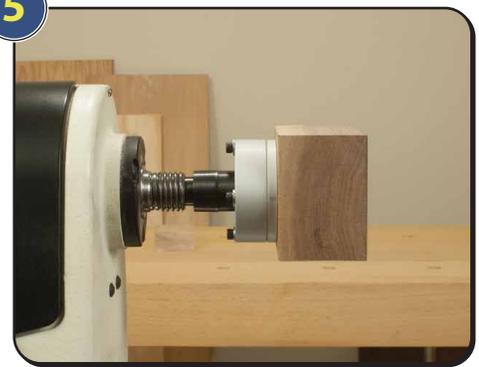
Screw your waste block on to the index plate using the four small phillips head screws that are supplied with this chuck system.

4



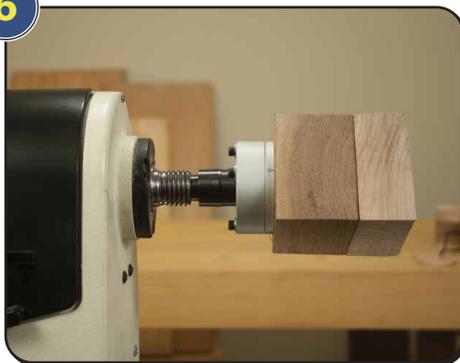
Mount the index plate and waste block assembly to the off set chuck with the four bolts and washers that are included. Make sure you align the two zero marks on the chuck and the index plate. Also included with your offset chuck are 4 thumb screws used for smaller projects and quicker adjustments to the indexing plate.

5



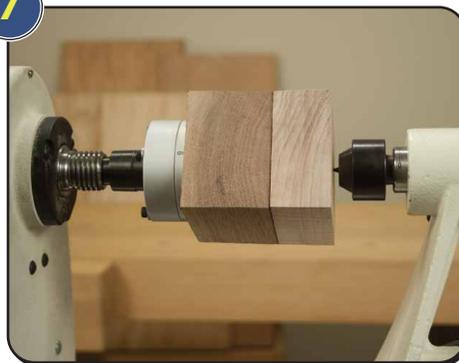
Install the nylon washer onto the MT-2 mount threads. Thread the off set chuck to the center hole #1 on to the MT-2 mount. *NOTE: Nylon washer is necessary to prevent binding between the chuck and the MT-2 mount*

6



Attach the workpiece to your waste-block. Typically for pendants and small, flat objects, double stick tape is the preferred mounting method. For large stock glue is recommended.

7



With your work piece attached to the waste block and the chuck mounted in hole #1, bring the tailstock up for stability. Turn your blank to a 2" diameter.

8



With your blank turned, remove the tailstock and slightly dome the face of your pendant. Sand your work-piece to the finished grit.

## Hanging Hole Drilling Process

Set the chuck for drilling the off center hanging hole

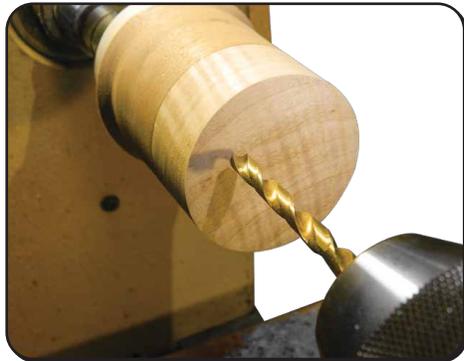
1. Un-screw the chuck from center hole #1 and re-thread it back onto offset hole #4. This will offset your work piece for drilling the hanging hole on your pendant.
2. You will be drilling a 1/4" hole near the edge of the pendant, so it is important to keep the hole just far enough from the edge as to not split or crack the workpiece. There are 3 basic methods for doing this, and they are as follows below. After you have drilled the hole, countersink or taper the area around your 1/4 inch hole.

### 1 Lathe Mounted Drill Chuck



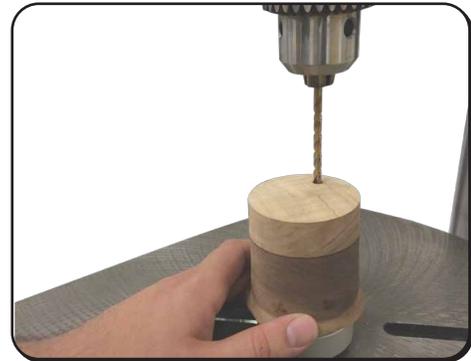
Mount a lathe drilling chuck to your lathe tailstock. Insert a 1/4" drill bit into the chuck and secure. Drill the hole.

### 2 Hand Drill or Spindle Gouge



Using the live center on your lathe tailstock, slide it into the pendant to mark a location of your hole. Using a hand drill, or small spindle gouge, drill or cut the hole at the mark.

### 3 Drill Press



Using the live center on your lathe tailstock, slide it into the pendant to mark a location of your hole. Then remove the the chuck from the lathe and drill it on the drill press using a 1/4" twist bit.



After your work piece is slightly domed and drilled, it should look similar to the image shown to the left.

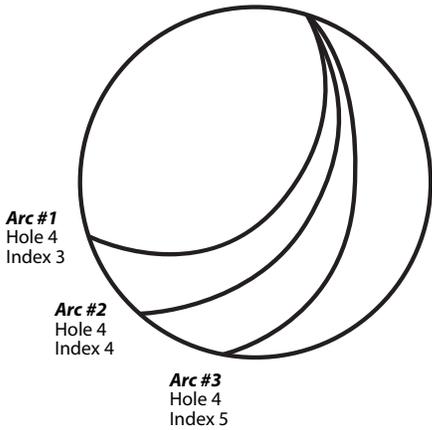
## Cutting the three Arcs

In this example we will cutting three separate arcs using point tool with the chuck positioned on offset hole 4. It is important to note that since we are working with a domed workpiece, be sure to control your depth of cut so it won't go clear to the edge of your piece. When making your pendant please keep in mind you will be making a scraping cut against the grain. Depending upon the desired look of your pendant you can choose a different turning tool to create a custom and unique look.

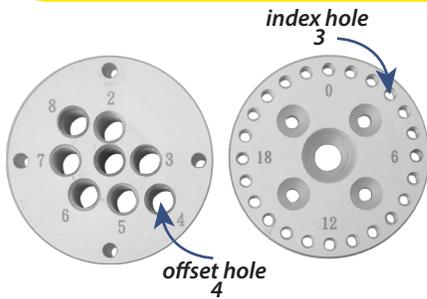
Before cutting the arcs, we must adjust the height of our tool rest, so that the cutting edge is centered to the "center" line between the turning points on the lathe.

*Shop Note:*

*An easy way to set the tool rest is to adjust it up or down in line with the live center on your tailstock*

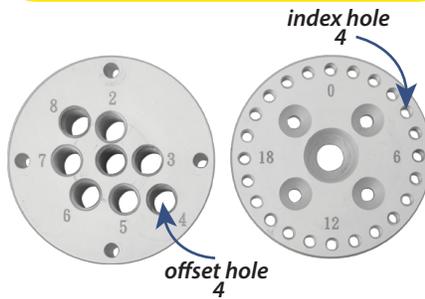


**Arc #1 - Our settings are Offset Hole 4, Index Hole 3**



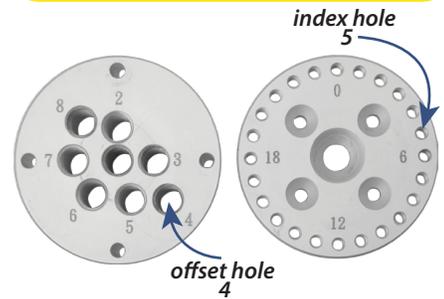
- With your chuck mounted in offset hole 4 and index hole 3, it is recommended to mark your cuts with a pencil prior to actually making the cut. This gives you a good visual reference and will allow you to make any necessary adjustments that may be needed.
- locate the starting point of your cut. (Our example is approx. 1/4" to the left of the hanging hole). Rest a pencil on your tool rest and rotate the chuck by hand and mark Arc #1.
- Make the cut using a point tool to the desired depth.
- Gently sand the arc you just cut being careful not to lose definition.

**Arc #2 - Our settings are Offset Hole 4, Index Hole 4**



- Remove the bolts on the indexing plate and rotate the indexing plate to position indexing hole 4 and re-secure index plate to chuck.
- This arc is intended to enter the work piece at the same point at the upper edge of our pendant but have a larger radius which will arc outward toward the bottom. Rest a pencil on your tool rest and rotate the chuck by hand and mark Arc # 2.
- Make the cut using a point tool to the desired depth.
- Gently sand the arc you just cut being careful not to lose definition.

**Arc #3 - Our settings are Offset Hole 4, Index Hole 5**



- Remove the bolts on the indexing plate and rotate the indexing plate to position indexing hole 5 and re-secure index plate to chuck.
- This arc is intended to enter the work piece at the same point at the upper edge of our pendant but have a larger radius which will arc outward toward the bottom. Rest a pencil on your tool rest and rotate the chuck by hand and mark Arc # 3.
- Make the cut using a point tool to the desired depth.
- Gently sand the arc you just cut being careful not to lose definition.

## Parting Off the Pendant

Now that your pendant has three arcs cut and the face has been properly sanded you are ready to part the pendant off.

Making as clean a cut as possible using a parting tool, part the pendant off 3/16" to 1/4" thick with a slight convex shape. Once the pendant is parted, use a 3 inch bowl sanding pad with a drill to clean up the back surface of the pendant. If your work piece was the desired thickness and was attached directly to the waste block with double stick tape, simply remove it from the waste block.

### *Shop Note:*

*When using fairly thick stock for making several pendants approximately 1/4 inch wide each, it is recommended to use a superthin 1/16 inch wide parting tool. This will allow you to make multiple pendants from one piece of stock mounted on your waste block.*

## Finishing the Pendant

Use your finish of choice to achieve the desired look. If you prefer you can finish the face of the pendant before you part it off. You will then only need to finish the back side of the pendant once it is parted. In our example we chose to finish both the front and backside of the pendant once it was parted off the waste block. A matte lacquer finish was applied multiple times on both sides of our pendant. Complete your project by attaching a necklace cord readily available from Hobby Lobby, Michaels Craft Stores, or any other craft store in your area. A virtually unlimited combination of designs are possible when you understand the relationship of the off-center holes on the chuck to the Indexing holes on the indexing plate.



For more designs and different pendant ideas, visit us at  
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